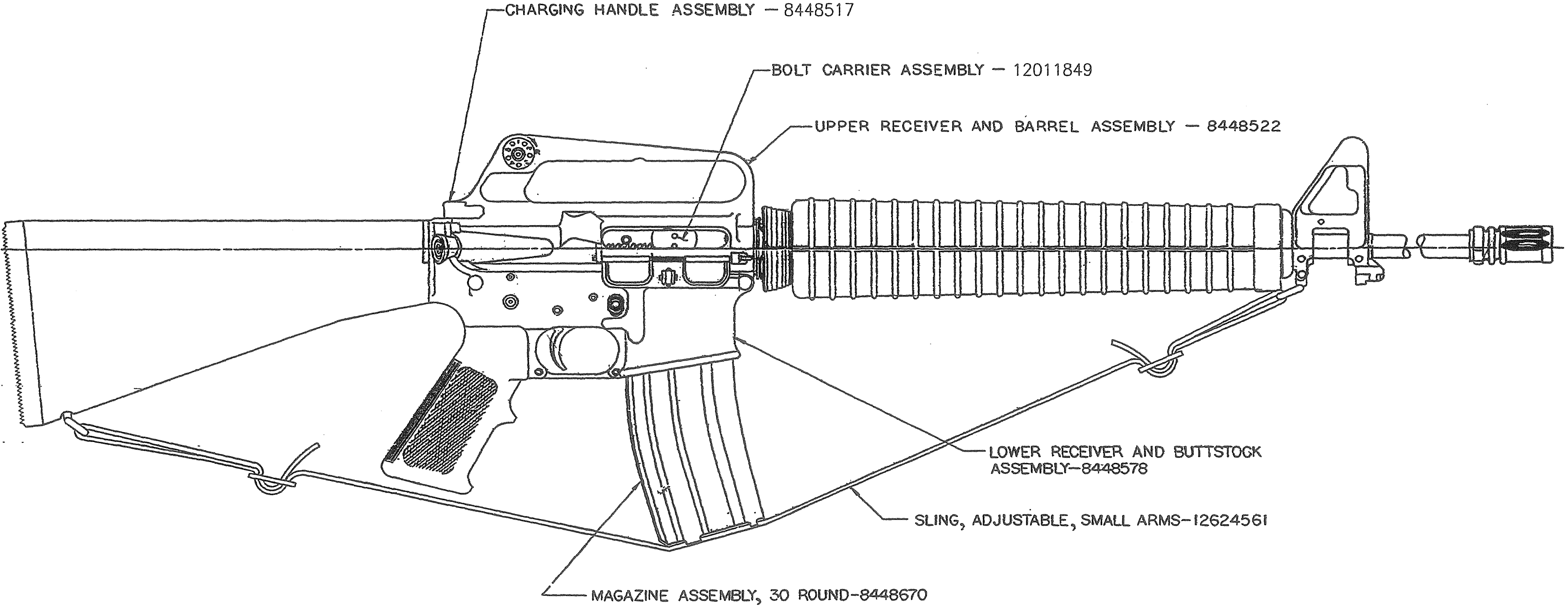
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

[illegible]

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
L	REDRAWN WITH CHANGES NOR W5S8004/860204	890215	
M	NOR G2S3057/920716	921030	RR
N	NOR L7S3059 971016 (ECP L8S3000 980126)	980313	JB

NOTES:

1. MIL-R-45587 APPLIES.
2. FOR INFORMATION ONLY:
   DRAWING A8448795 INCLUDES THE SUPPORT EQUIPMENT FOR THE RIFLE, M16A1. THIS EQUIPMENT IS NOT PACKAGED OR INCLUDED WITH THE M16A1 RIFLE, P/N 8448500.


CHARGING HANDLE ASSEMBLY — 8448517
BOLT CARRIER ASSEMBLY — 12011849
UPPER RECEIVER AND BARREL ASSEMBLY — 8448522
LOWER RECEIVER AND BUTTSTOCK ASSEMBLY–8448578
SLING, ADJUSTABLE, SMALL ARMS–12624561
MAGAZINE ASSEMBLY, 30 ROUND–8448670

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SEE PARTS LIST 8448500

PART NO. 8448500

DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING 27 APR 1970	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61201	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAFTSMAN GJC / CHECKER DK	RIFLE ASSEMBLY M16A1	
TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±	ENGR PS / ENGR DB		
THIRD ANGLE PROJECTION	F. GILHOOLEY R.S. HENRY.	SIZE F	CODE IDENT NO 19204
NEXT ASSY / USED ON APPLICATION	MECHANICAL PROPERTIES	SCALE	UNIT WT.
		8448500	SHEET 1 OF 1

SMCAR FORM 69, 1 JUL 87(TEMP) REPLACES SMCAR FORM 69, 1 JUN 86(TEMP) WHICH IS OBSOLETE

October 13, 2004 2:44 PM

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61604 REV A	27 APR 70	
		A	SEE ERR HQR 20778	6 OCT 72	R.E.
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G1S2018 91-07-08	91-10-11	
		D	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL

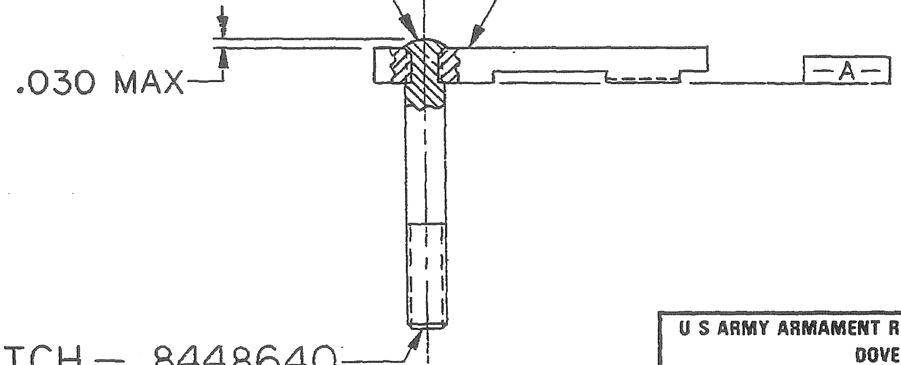
B8448638

NOTES:

1. ASSEMBLE 8448639 AND 8448640 USING 15±5 INCH LB OF TORQUE BEFORE SWAGING.
2. MIL-W-13855 APPLIES. Ⓐ

SWAGE TO FORM HEAD AND LOCK ASSEMBLY. SWAGED HEAD MUST BE SMOOTH AND SYMMETRICAL

PLATE, MAGAZINE CATCH — 8448639



SHAFT, MAGAZINE CATCH — 8448640

⊥|A|.004

SEE PL-8448638

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT

CODE IDENT NO. 19200

MECHANICAL PROPERTIES			
YS MIN		9390011	M4
YS MAX		F9327230	M231
EL 2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL
—

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO.
DATE 27 APR 1970

PREP	B.R.L.	A.J.H.
CHK		Leedham
ENGR		D. Billet

SUBMITTED F.P. Gilhooly

APPROVED R. S. Henry

DEPT OF THE ~~ARMY~~
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 6120

CATCH, MAGAZINE

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448638

SCALE 2/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CDI

October 15, 2004 11:16 AM

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NOTES:—

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 — MATERIAL: PLASTIC COMPOUND PER ASTM D4066, PA 162. COLOR SHALL BE LUSTERLESS (FLAT), APPROX. BLACK NO. 37038, TABLE IX, BUT NOT LIGHTER THAN GRAY, NO. 36076 TABLE VIII OF FED-STD-595.

3 — BREAK EDGES .010 ±.005 UNLESS OTHERWISE NOTED.

4 — FILLET RADII .009 ±.006 UNLESS OTHERWISE NOTED.

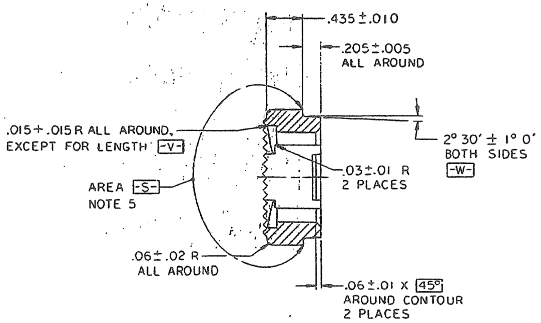
5 — ALL EXPOSED SURFACES ENCLOSED IN AREA -S- SHALL HAVE A NONREFLECTIVE MATTE SURFACE, OTHER SURFACES OPTIONAL.

6 — TRANSITION OF ANGLES -K-, -T- AND -W- SHALL BE SMOOTHLY BLENDED.

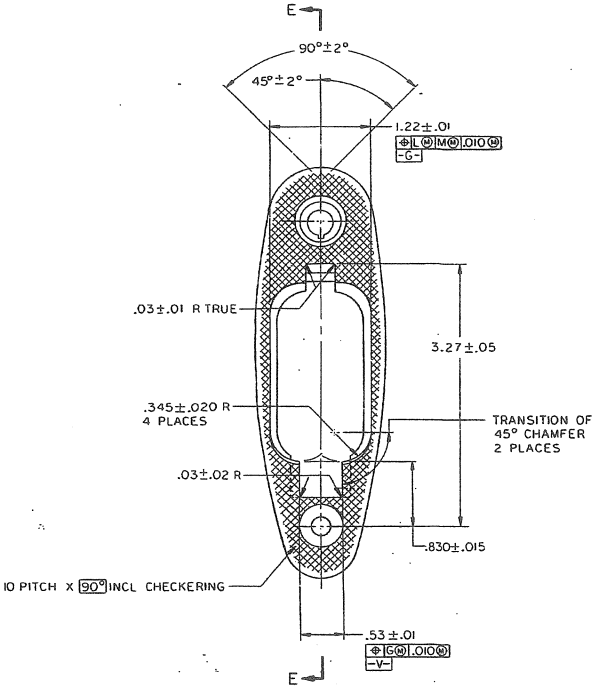
7 — REMOVE ALL FLASH.

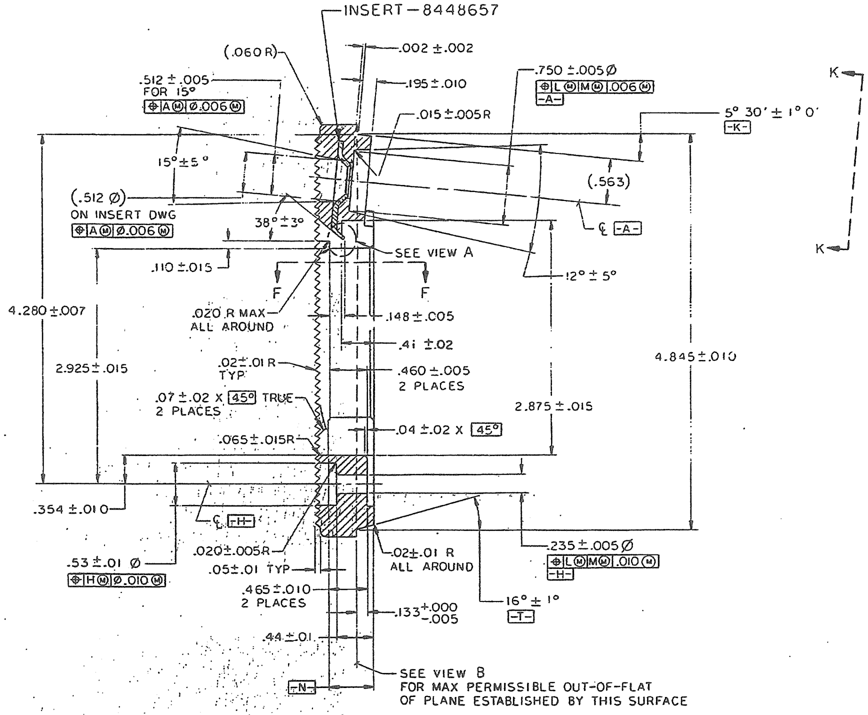
8 — PART SHALL BE FREE FROM POROSITY, CRACKING, DEFORMATION, AND FLOW AND/OR KNIT MARKS.

9 FINISH: 125√ ALL SURFACES UNLESS OTHERWISE NOTED.

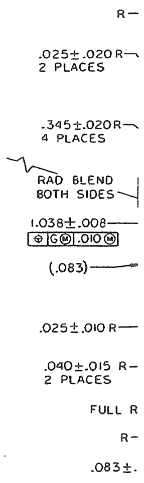

.435 ±.010
.205 ±.005 ALL AROUND
.015 + .015 R ALL AROUND, EXCEPT FOR LENGTH -V-
2° 30′ ± 1° 0′ BOTH SIDES -W-
.03 ±.01 R 2 PLACES
AREA -S- NOTE 5
.06 ±.02 R ALL AROUND
.06 ±.01 X 45° AROUND CONTOUR 2 PLACES

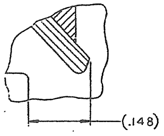
SECTION F-F


E
90° ±2°
45° ±2°
1.22 ±.01
⊕ L Ⓜ M Ⓜ .010 Ⓜ
-G-
.03 ±.01 R TRUE
3.27 ±.05
.345 ±.020 R 4 PLACES
TRANSITION OF 45° CHAMFER 2 PLACES
.03 ±.02 R
.830 ±.015
10 PITCH X 90° INCL CHECKERING
.53 ±.01
⊕ G Ⓜ .010 Ⓜ
-V-
E


INSERT — 8448657
(.060 R)
.002 ±.002
.512 ±.005 FOR 15°
⊕ A Ⓜ Ø.006 Ⓜ
.195 ±.010
.750 ±.005 Ø
⊕ L Ⓜ M Ⓜ .006 Ⓜ
-A-
.015 ±.005 R
5° 30′ ± 1° 0′
-K-
K
15° ±5°
(.563)
(.512 Ø) ON INSERT DWG
⊕ A Ⓜ Ø.006 Ⓜ
38° ±3°
℄ -A-
SEE VIEW A
.110 ±.015
12° ± 5°
K
F
F
4.280 ±.007
.020 R MAX ALL AROUND
.148 ±.005
.41 ±.02
2.925 ±.015
.02 ±.01 R TYP
.460 ±.005 2 PLACES
4.845 ±.010
.07 ±.02 X 45° TRUE 2 PLACES
2.875 ±.015
.04 ±.02 X 45°
.065 ±.015 R
.354 ±.010
℄ -H-
.53 ±.01 Ø
⊕ H Ⓜ Ø.010 Ⓜ
.020 ±.005 R
.05 ±.01 TYP
.02 ±.01 R ALL AROUND
.235 ±.005 Ø
⊕ L Ⓜ M Ⓜ .010 Ⓜ
-H-
16° ± 1°
-T-
.465 ±.010 2 PLACES
.133 +.000 −.005
.44 ±.01
-N-
SEE VIEW B FOR MAX PERMISSIBLE OUT-OF-FLAT OF PLANE ESTABLISHED BY THIS SURFACE

SECTION E-E


R—
.025 ±.020 R 2 PLACES
.345 ±.020 R 4 PLACES
RAD BLEND BOTH SIDES
1.038 ±.008
⊕ G Ⓜ .010 Ⓜ
(.083)
.025 ±.010 R
.040 ±.015 R 2 PLACES
FULL R
R—
.083 ±.

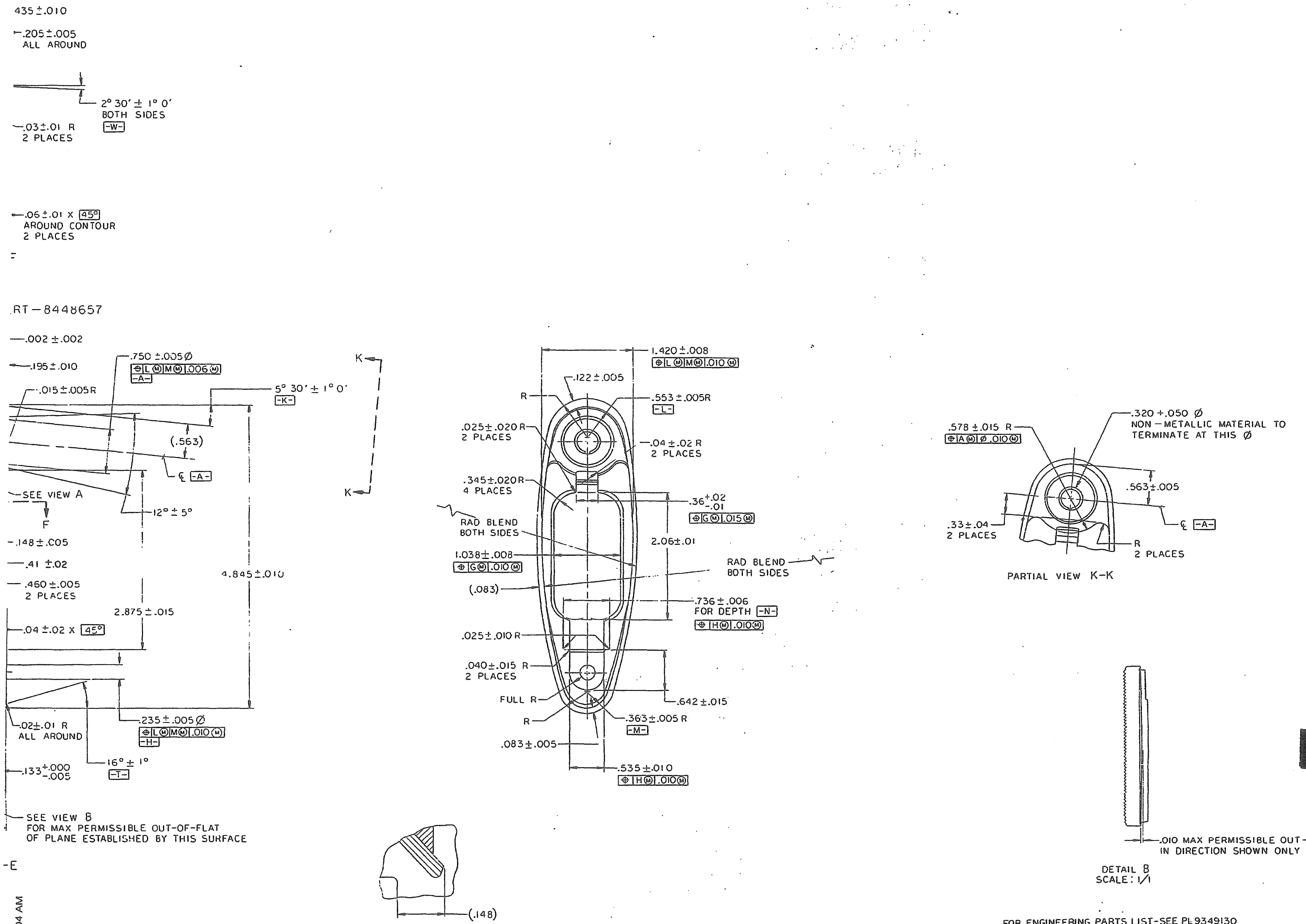


VIEW A
SCALE: 10/1

J9349130 REV F F-1/2

October 15, 2004 11:04 AM

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW252013	820614	R Hanlgn
A	NORW4S0010/84-06-20	84-07-20	
B	NORW4S0030/84-11-15	850402	
C	NORW6S3006/86-03-12	870219	
D	NOR W5S8004/860204	890215	
E	ERR Z9Z1281BB (ECP G9S3031, 89-05-23)	90-09-06	
F	NOR GIS3100 910827	911007	


435±.010
.205±.005
ALL AROUND
2° 30′ ± 1° 0′
BOTH SIDES
-W-
.03±.01 R
2 PLACES
.06±.01 X 45°
AROUND CONTOUR
2 PLACES
RT – 8448657
.002 ±.002
.195±.010
.750 ±.005Ø
⊕ L Ⓜ M Ⓜ .006 Ⓜ
-A-
.015±.005R
5° 30′ ± 1° 0′
-K-
(.563)
℄ -A-
SEE VIEW A
F
12° ± 5°
.148±.005
.41 ±.02
.460±.005
2 PLACES
2.875±.015
4.845±.010
.04 ±.02 X 45°
.02±.01 R
ALL AROUND
.235±.005Ø
⊕ L Ⓜ M Ⓜ .010 Ⓜ
-H-
16° ± 1°
-T-
.133 +.000 -.005
SEE VIEW B
FOR MAX PERMISSIBLE OUT-OF-FLAT
OF PLANE ESTABLISHED BY THIS SURFACE
-E
K
K
1.420±.008
⊕ L Ⓜ M Ⓜ .010 Ⓜ
.122±.005
R
.553±.005R
-L-
.025±.020R
2 PLACES
.04±.02 R
2 PLACES
.345±.020R
4 PLACES
.36 +.02 -.01
⊕ G Ⓜ .015 Ⓜ
RAD BLEND
BOTH SIDES
2.06±.01
1.038±.008
⊕ G Ⓜ .010 Ⓜ
RAD BLEND
BOTH SIDES
(.083)
.736±.006
FOR DEPTH -N-
⊕ H Ⓜ .010 Ⓜ
.025±.010 R
.040±.015 R
2 PLACES
.642±.015
FULL R
R
.363±.005 R
-M-
.083±.005
.535±.010
⊕ H Ⓜ .010 Ⓜ
.578±.015 R
⊕ A Ⓜ Ø .010 Ⓜ
.320 +.050 Ø
NON – METALLIC MATERIAL TO
TERMINATE AT THIS Ø
.563±.005
.33±.04
2 PLACES
℄ -A-
R
2 PLACES
.010 MAX PERMISSIBLE OUT-OF-FLAT
IN DIRECTION SHOWN ONLY
(.148)
8
7
6
5
4
3
2
1
G
F
E
D
C

PARTIAL VIEW K-K

DETAIL B
SCALE: 1/1

VIEW A
SCALE: 10/1

F-2/2

FOR ENGINEERING PARTS LIST-SEE PL 9349130

PART NO. 9349130

		MECHANICAL PROPERTIES	DO NOT SCALE DRAWING
		YP	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
		TS	TOLERANCES ON DECIMALS ±
		ELZ	FRACTIONS ± ANGLES ±
	M16	RA	
	M16A1	BH	
9349119	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN EJZ
CHECKER AB
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

BUTT PLATE ASSEMBLY

SIZE J
FSCM NO. 19200
9349130
SCALE 2/1
UNIT WT :
SHEET 1 OF :

2-FR

9…30 SH REV F

October 15, 2004 11:04 AM

ARMAMENT RESEARCH & DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PARTS LIST PL-9349119
DOCUMENT/PART NUMBER D 9349119
BUTTSTOCK ASSEMBLY, STOWAGE
CHANGE CONTROL NUMBER W253258

CURRENT FSCM NO. 19200 - ORIGINAL FSCM NO. 19200

AUTHENTICATION-RMoll

REV. DATE 04 Sep 84
REVISION LETTER B
SHEET 1
ORIG. DATE 14 JUN 82

FND NO.	QTY REQ	UNIT MEAS	FSCM NO.	PART OR IDENTIFYING NO	DRAWING/DOCUMENT SZE	DRAWING/DOCUMENT NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP LST
	1		19204	8448652	C	8448652	SWIVEL	
	1		19204	8448653	C	8448653	HINGE	
	1		19204	8448655	B	8448655	PIN	
	1			9349120	D	9349120	SCREW, SWIVEL	
	1			9349121	J	9349121	BUTTSTOCK	
	1			9349130	J	9349130	BUTT PLATE ASSEMBLY	X
	1			9331380	C	9381380	DOOR ASSEMBLY, THUMB LATCH	X

TOTAL NUMBER OF SHEETS 1

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

October 15, 2004 11:00 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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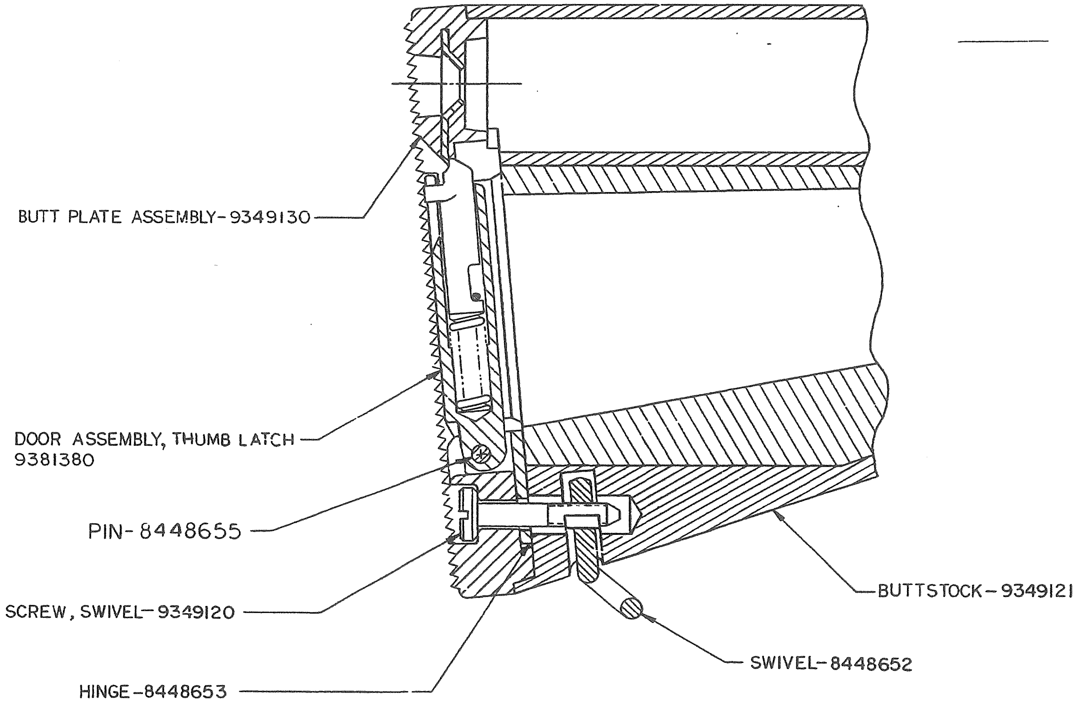
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	[illegible]
A	NORW3S3149/83-11-14	8402-10	[illegible]
B	NOR W2S3258/82-12-30	840904	[illegible]
C	NOR W4S0030/84-11-15	850402	EP
D	NORW5S0127 851106	871107	EJB
E	NOR W5S8004/860204	890215	[illegible]

NOTES:—
1— SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.



SEE SEPARATE PARTS LIST-9349119

PART NO. 9349119

NEXT ASSY	USED ON
8448578	M16A1
8448604	M16
9349100	M16A2

APPLICATION

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN DHB
CHECKER DEW
ENGR
ENGR
ENGR
ENGR

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DOVER, NEW JERSEY 07801

BUTTSTOCK ASSEMBLY,
STOWAGE

SIZE D
FSCM NO. 19200
9349119
SCALE 2/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 68 AUG 77 REPLACES DARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:00 AM

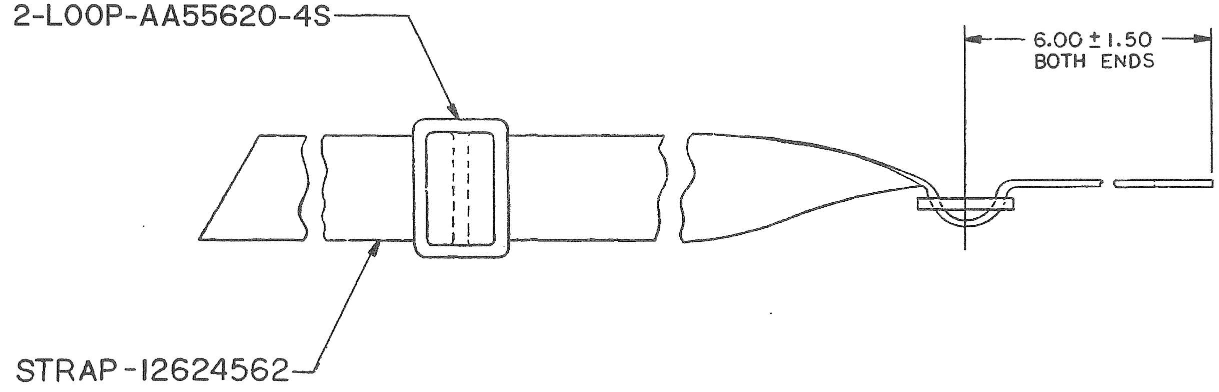
DRAWING SIZE C
(ARDCR 70-12)

4 3 2 1

NOTES:-
1-MIL-W-13855 APPLIES.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW5S0107	86-01-24	SAS
A	NOR G1S9451/910429	910605	GHS SR
B	NOR L7S2000 970214	970306	JB

D



C

B

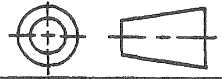
SEE SEPARATE PARTS LIST 12624561

PART NO. 12624561

F8448600	RIFLE, ASSEMBLY, M16		
F9349000	RIFLE, 5.56 MM, M16A2	F7265698	RIFLE, CAL .30 M1
D7265648	SMG, M3 & M3A1	B8426167	LAUNCHER,
C11686409	SHOTGUN, 12GA,		GRENADE
	RIOT TYPE		M79
F7265694	CARBINE, CAL .30	F8448500	RIFLE,
F7265696	M1 & M2		5.56 MM:
F7267000	RIFLE, 7.62 MM, M14		M16A1
NEXT ASSY	USED ON	NEXT ASSY	USED ON
APPLICATION		APPLICATION	

MECHANICAL PROPERTIES	
YP	
TS	
EL2	
RA	
BH	
RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±
THIRD ANGLE PROJECTION



ORIGINAL DATE OF DRAWING 86-01-24	
DRAFTSMAN SAS	CHECKER
ENGR RJH	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801-5001

SLING, ADJUSTABLE,
SMALL ARMS

SIZE	FSCM NO.	
C	19200	12624561
SCALE	UNIT WT.	SHEET

A

SMCAR FORM 67, 1 FEB 85, REPLACES ARRADCOM FORM 67, AUG 77 (WHICH MAY BE USED UNTIL EXHAUSTED)

October 15, 2004 10:56 AM

5 4 3 2 1

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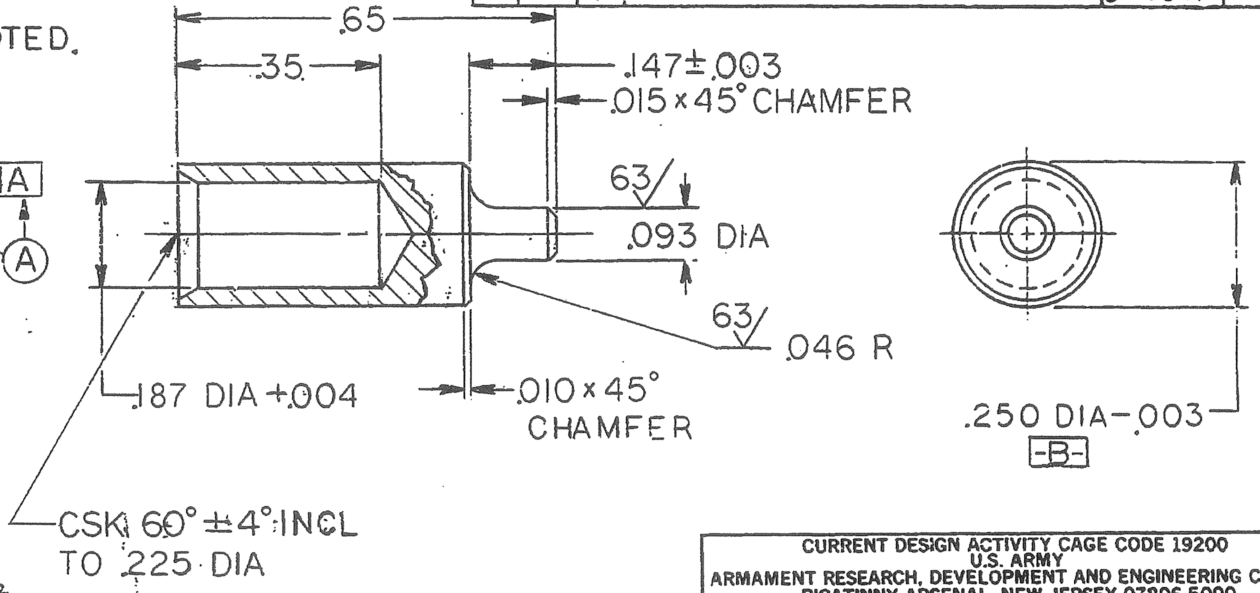
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLTS DRAWING C61582 REV B.	27 APR 70	
M		A	(3) SEE ERR HQR 20778	6 OCT 72	R.E.
M		B	NOR W9S2009 80-02-13	80-05-16	
M		C	NOR W6S0085 / 86-07-24	89-03-14	TT
		D	NOR G1S2018 91-07-08	91-10-11	RR
		E	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL SP
		F	NOR G3S3116 931130	940317	TT

NOTES:- Ⓐ

1.- STEEL CMPSN 4130 OR 41L40 ASTM A322 OR ASTM A331
2.- FINISH $\sqrt{125}$ EXCEPT AS NOTED.
3.- BREAK ALL SHARP EDGES .010 MAX.
4.- ALL DIAMETERS ⌖ B .006 DIA
5.- MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390011	M4
EL 2		C8448605	M16
RA		C8448579	M16A1
BH		NEXT ASSY	USED ON
RH	15N 72.5-76	APPLICATION	

Ⓐ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 2°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO
DATE 27 APR 1970

PREP	E.C.L.	A.J.A.
CHK		W. Leedham
ENGR	S. Smart	D. Billiet
SUBMITTED	F.O. Willoughby	
APPROVED	R.S. Henry	

US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RETAINER, BUFFER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448582
SCALE 5/1		SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CDI

8448582

October 15, 2004 10:44 AM

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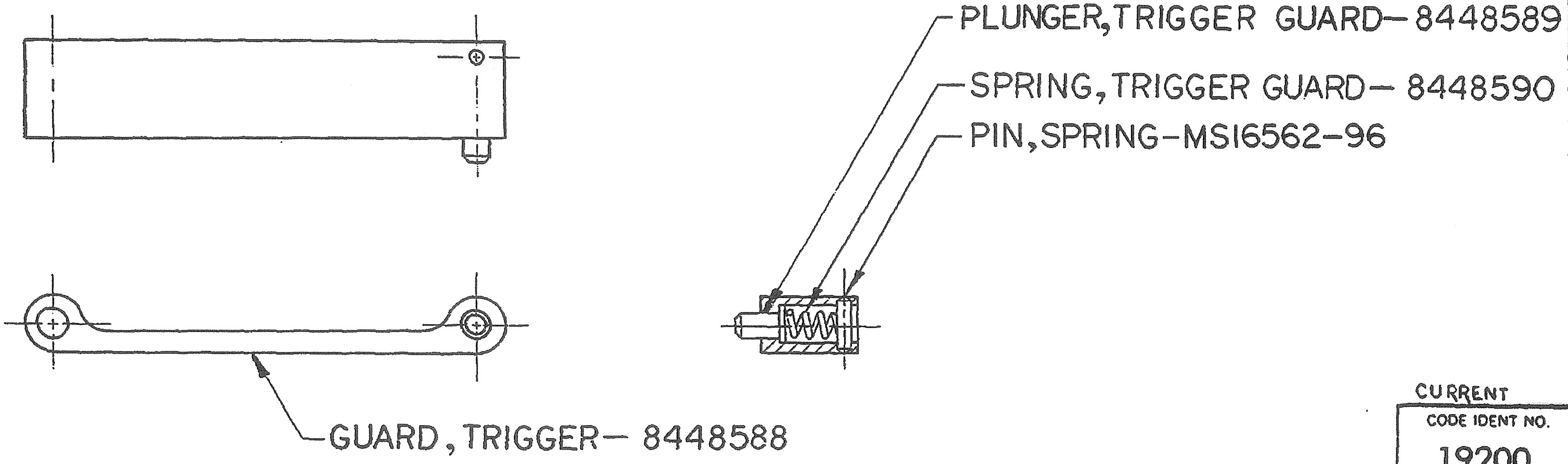
REVISIONS

MF	ZONE	LTR	DESCRIPTION		DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B61970 REV A		27 APR 70	
-M-	-	A	(5)SEE ERR HQR 20778		6 OCT 72	R.E.
		B	NOR W9S2009 80-02-13		80-05-16	
		C	NORW2S0020	82-06-09	83-02-03	LAH
		D	NOR G1S2018	91-07-08	91-10-11	

B 8448587

NOTES:

1. MIL-W-13855 APPLIES.


PLUNGER, TRIGGER GUARD—8448589
SPRING, TRIGGER GUARD— 8448590
PIN, SPRING-MS16562-96
GUARD, TRIGGER— 8448588

CURRENT
CODE IDENT NO.
19200

SEE PL-8448587

MECHANICAL PROPERTIES				
YS MIN		9390011	M4	
YS MAX		F9327230	M231	
EL 2		C8448605	M16	
RA		C8448579	M16A1	
BH		NEXT ASSY	USED ON	
RH		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —
MATERIAL —
FINAL PROTECTIVE FINISH —

CONTRACT NO
DATE 27 APR 1970
PREP RAR
CHK
ENGR
SUBMITTED
APPROVED R.S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
~~US ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

TRIGGER GUARD ASSEMBLY

SIZE B
CODE IDENT NO. ~~19204~~
DRAWING NO. 8448587
SCALE 2/1
SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M-		B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	LB
		C	NOR W2S0011 / 82-04-13 (ECP W2S0034 / 82-07-15) (ECP W3S3120 / 83-07-07)	83-11-04	
		D	NORG1S2018 91-07-08	91-10-11	RP

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0220 ± .0005
COIL DIAMETER (O.D)	.180 ± .003
FREE LENGTH	.940 REF
TOTAL COILS	14 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .490	3.0 LB ± .3 LB
LOAD AT COMPRESSED LENGTH OF	———
SPRING RATE	———
SOLID LENGTH	.335 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900° F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012.

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448583

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 84.5 MIN

NEXT ASSY	USED ON
9390011	M4
C8448605	M16
C8448579	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±—
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±—

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 70

PREP	P. Vernon	
CHK		
ENGR	R. Elbe	L. Brunton

SUBMITTED A. A. Cole

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, BUFFER RETAINER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448583

SCALE — SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

B8448583

October 15, 2004 10:54 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M	-	C	REPLACES REV B W/CHANGE SEE ERR HQR 20778	6 OCT 72	LB
		D	NORW2S0045 82-07-29	830203	
		E	NORW2S0011/82-04-13 (ECPW3S3120/83-07-07)	83-11-04	
M		F	NOR G8S2005/880310	880927	ORI 1 VZ
		G	NOR G1S2018/910708	911011	RR

B8448540

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0400±.0005
COIL DIAMETER (O.D.)	.41
FREE LENGTH AFTER SETTING	1.13 REF
TOTAL COILS	9 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .630	4.0 LB ± .4 LB
LOAD AT COMPRESSED LENGTH OF	———
SPRING RATE	———
SOLID LENGTH	.405 MAX
TYPE OF ENDS	OPEN

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572. EXCEPT PARAGRAPH 3.4.3 SHALL NOT APPLY.

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, ASTM-A228.
2. STRESS RELIEVE: HOLD AT 475°F ± 25° FOR 30 MINUTES. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448540

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		9390029	M4
RA		D8448523	M16 A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±—
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01
MATERIAL
SEE NOTE 1
FINAL PROTECTIVE FINISH

CONTRACT NO.
DATE 27 APR 70
PREP T. Vernon O. Outman
CHK G. Dresselhaus D. Krolak
ENGR R. Elbe L. Brinton
SUBMITTED A. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, PLUNGER

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448540
SCALE NONE
SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

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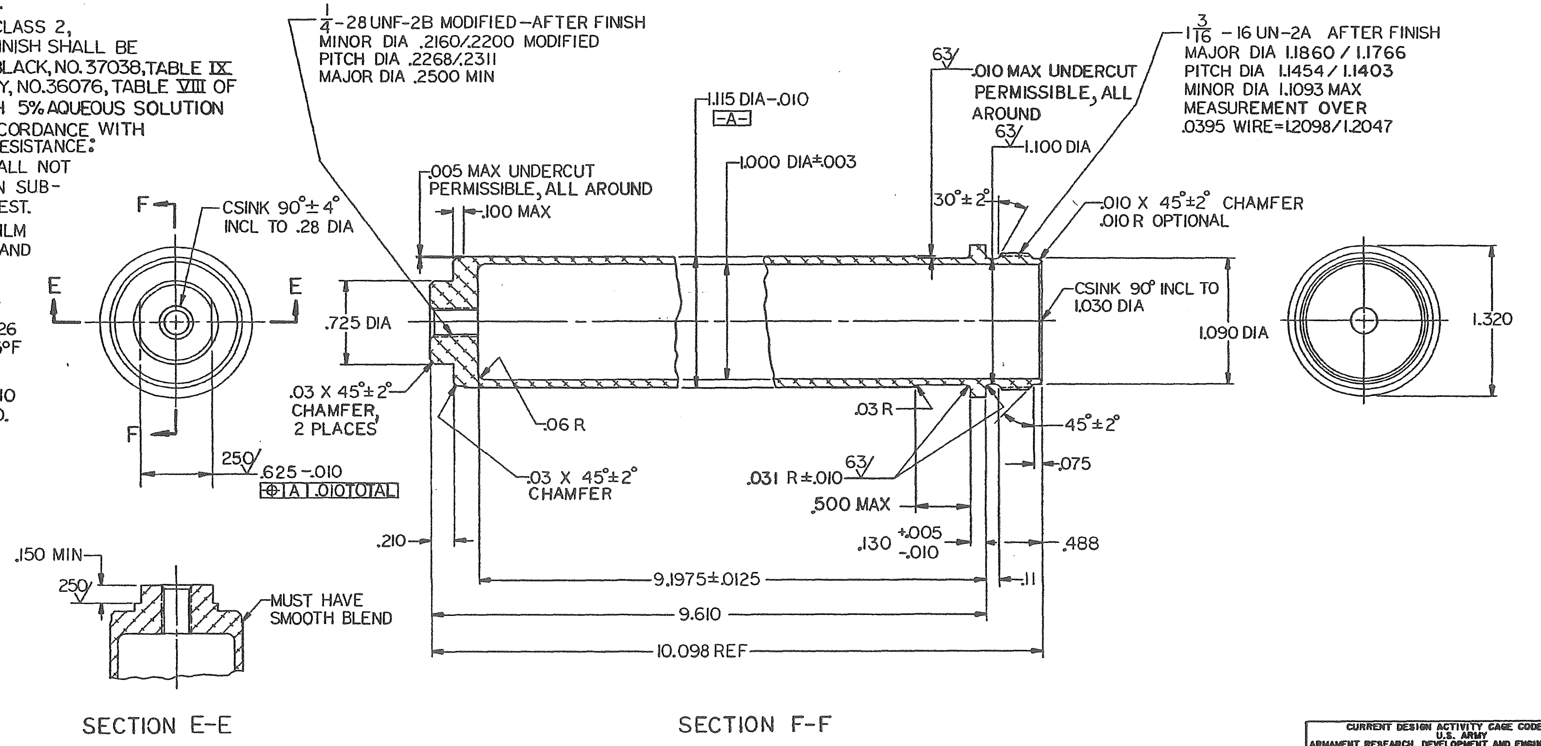
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D61574 REV C	27 APR 70	
		A	(4) SEE EO HRD 02197-3	15 JULY 70	
		B	(3) SEE EO HRD 02282	16 DEC 70	
		C	SEE ERR HQR 10797	6 JULY 71	YB
		D	(5)SEE ERR HQR 20778	6 OCT 72	R.E.
		E	SEE ERR HQR 50615	27FEB75	YB
		F	NORW2S0026 82-05-21	83-02-08	
		G	NORW6S3006/86-03-12	87-02-17	EM
		H	ERR Z9Z1182AT (ECP W6S3034 860718)	890825	
		J	NOR G0S3094 900702	901022	
		K	NOR G5S3099 951002	960117	RLV
		L	NOR L9S3009 990514	991027	BAC

NOTE:

1. FINISH 125√ EXCEPT AS NOTED.
2. FILLET RADII .010.
3. ALL DIAMETERS TO BE ◎ A .010 DIA.
4. ALL DIMENSIONS APPLY BEFORE FINISH UNLESS OTHERWISE SPECIFIED.
5. FINISH MIL-A-8625, TYPE III, CLASS 2, FILM THICKNESS .0010±.0002, FINISH SHALL BE LUSTERLESS(FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL WITH 5% AQUEOUS SOLUTION OF SODIUM DICHROMATE IN ACCORDANCE WITH PARAGRAPH 3.8.2 ABRASION RESISTANCE: THE ANODIC COATING LOSS SHALL NOT EXCEED 20 MILLIGRAMS WHEN SUBJECTED TO A 5,000 CYCLE TEST.
6. MASK THREADS, APPLY DRY FILM LUBRICANT TO BOTH INTERIOR AND EXTERIOR. .0002/.0005 FILM THICKNESS. USE MIL-L-46010 CURED AT 300°/325° F FOR 2 HOURS OR EVERLUBE 626 OR 626S CURED AT 275° ± 25°F FOR ONE HOUR.
7. BREAK SHARP EDGES .005 + .010 UNLESS OTHERWISE SPECIFIED.
8. MIL-W-13855 APPLIES.


$\frac{1}{4}$-28 UNF-2B MODIFIED—AFTER FINISH
MINOR DIA .2160/.2200 MODIFIED
PITCH DIA .2268/.2311
MAJOR DIA .2500 MIN
$1\frac{3}{16}$ - 16 UN-2A AFTER FINISH
MAJOR DIA 1.1860 / 1.1766
PITCH DIA 1.1454 / 1.1403
MINOR DIA 1.1093 MAX
MEASUREMENT OVER
.0395 WIRE=1.2098/1.2047
63
.010 MAX UNDERCUT
PERMISSIBLE, ALL
AROUND
1.115 DIA-.010
-A-
63
1.100 DIA
1.000 DIA±.003
.005 MAX UNDERCUT
PERMISSIBLE, ALL AROUND
.100 MAX
30°±2°
.010 X 45°±2° CHAMFER
.010 R OPTIONAL
F
CSINK 90°±4°
INCL TO .28 DIA
E
E
.725 DIA
CSINK 90° INCL TO
1.030 DIA
1.090 DIA
1.320
F
.03 X 45°±2°
CHAMFER,
2 PLACES
.06 R
.03 R
45°±2°
.075
250
.625 -.010
⊕ A .010 TOTAL
.03 X 45°±2°
CHAMFER
63
.031 R±.010
.500 MAX
.210
.130 +.005 -.010
.488
.150 MIN
250
MUST HAVE
SMOOTH BLEND
9.1975±.0125
.11
9.610
10.098 REF

SECTION E-E

SECTION F-F

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA				
BH		D9349101	M16A2	
		C8448605	M16	
		C8448579	M16A1	
RH		NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
ALUMINUM ALLOY,
EXTRUDED, ALLOY 7075
TEMPER T6,
ASTM B 221

FINAL PROTECTIVE FINISH
SEE NOTES 5 & 6

CONTRACT NO.

DATE 27 APR 1970

PREPARED	GJC	A.J.
CHECKED		
ENGINEER		D. Bitter

SUBMITTED F. P. McElhooly

APPROVED R. J. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

EXTENSION, RECEIVER

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448581

SCALE 2/1 SHEET 1 OF 1

CDI

D8448581

AMSWE Form 403D, 29 Jul 69

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M	-	B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	
M		C	NOR W9S2009 80-02-13	80-05-16	R. Lull
		D	~~NOR W2S0011 / 82-04-13~~ ~~CECP W2S0034 / 82-07-15~~ ~~CECP W3S3120 / 83-07-07~~	~~83-11-04~~	
		E	NOR GIS2018 91-07-08	91-10-11	RRSL

B8448637

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0290 ± .0005
COIL DIAMETER (O.D)	.298 ± .007
FREE LENGTH	1.15 REF
TOTAL COILS	8 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .470	5.64 LB ± .56 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	
SOLID LENGTH	.270 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BRAKE SHARP EDGES .003+.012.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT
PART NO. 8448637

FSCM NO.
19200

MECHANICAL PROPERTIES			
YS MIN		9390011	M4
YS MAX		F 9327230	M 231
EL 2		F 8448604	M16
RA		F 8448578	M16 A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:	
DATE	27 APR 70
PREP	P. Vernon / L. Gutman
CHK	G. Dresselhaus / D. Krolek
ENGR	R. Elbe / L. Brunton
SUBMITTED	A. A. Cole
APPROVED	R. S. Henry

DEPT OF THE ARMY
U.S. ARMY ~~WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

SPRING, MAGAZINE CATCH

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448637
SCALE —		SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:19 AM

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D62032 REV B AND COLT'S DRAWING B62496 REV A	27 APR70	
M	-	A	(3)SEE ERR HQR 20778	6 OCT 72	R.E.
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G0S3102/900628	901022	
		D	NOR G1S2018 91-07-08	91-10-11	RR
		E	NOR G6S2008 960328	960523	RLV

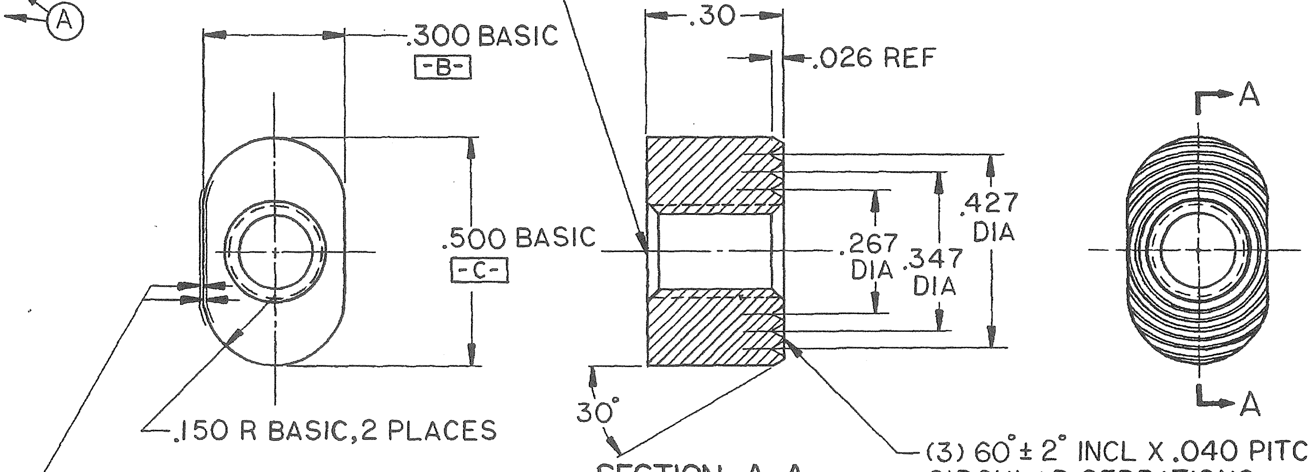
NOTE:

1. FINISH 125/.
2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. FINISH: MIL-A-8625, TYPE 3, CLASS 2, FILM THICKNESS .0010±.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL.
4. MIL-W-13855 APPLIES. Ⓐ

CSK BOTH ENDS 90°±4° TO .215 DIA+.015.
THREAD DIMENSIONS AFTER FINISH TO CONFORM TO 10-32 UNF-2B
MINOR DIA .156/.164
PITCH DIA .1697/.1736
MAJOR DIA .190 MIN.

⌖	B	.010 TOTAL
⌖	C	.010 TOTAL

Ⓐ



.150 R BASIC, 2 PLACES

TOLERANCE ZONE AROUND CONTOUR IS .0025.

SECTION A-A

(3) 60°± 2° INCL X .040 PITCH REF. CIRCULAR SERRATIONS. .005(APPROX) FLATS ON CREST AND ROOT

Ⓐ

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CURRENT
CODE IDENT NO.
19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390011	M4
EL 2		9349100	M16A2
RA		F9237230	M231
BH		F8448604	M16
		F8448578	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
ALUMINUM ALY 7075 - T6, ASTM B221

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO

DATE 27 APR 1970

PREPARED	B.W.	a.g.st.
CHECKED		
ENGINEER		D. Billiet

SUBMITTED F.P. Gilhooly

APPROVED R.S. Henry

DEPT OF THE ARMY
US. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BUTTON, MAGAZINE RELEASE

SIZE	CODE IDENT NO	DRAWING NO.
C	19204	8448636

SCALE 5/1 SHEET OF

CDI

C8448636

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:19 AM

QUALITY ASSURANCE PROVISIONS (QAP) - (CONTINUATION SHEET)

(DARCOM-R 702-10)

3.

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE (see page 1)

PART III. INSPECTION REQUIREMENTS

TABLE I. CLASSIFICATION OF QUALITY CONFORMANCE CHARACTERISTICS

100% examination shall be performed for critical characteristics unless otherwise stated. Examination for major and minor characteristics shall be performed in accordance with the classification of quality conformance characteristics contained herein. Inspection Level II shall be used and individual AQL's applied in accordance with MIL-STD-105.

CLASS	CHARACTERISTIC	AQL or 100%	INSPECTION METHOD
CRITICAL:	None defined		
MAJOR:			
101.	.590 Length	0.65	SMTE
102.	.460 Width	0.65	SMTE
MINOR:			
201.	Hardness	1.5	SMTE
202.	.116 Height .279R (ref)	1.5	SMTE
203.	.010 Maximum mismatch .125R (4 places)	1.5	Visual
204.	AA63 Surface roughness	1.5	ANSI-B36.1
205.	Defective protective coating	1.5	Visual
206.	Workmanship (See MIL-W-63150)	2.5	Visual

PART IV. CERTIFICATION PROVISIONS

The certification provisions of MIL-W-63150 for Certificate of conformance shall apply. Certification of Conformance are required for the following:

NUMBER	CHARACTERISTIC	TEST DATA TO COMPLY WITH
301	Material	Dwg. 8448536, Note 1
302	Phosphate Coating	DOD-P-16232
303.	Supplementary Oil	MIL-L-3150 & FED-STD-791

PART V. TEST METHODS AND PROCEDURES

None Required

					ORIG CODE IDENT 19204	CAGE CODE 19200
16. REVISION SYMBOL AND DATE	E841126	F880218	G920910			10. QAP NO. 8448536
						14. PAGE NO. 3

3. NOTICE: RESTRICTED AS TO USE AND DISCLOSURE (see page 1)

SPECIFICATIONS

MIL-L-3150	Lubricating Oil, Preservative, Medium
DOD-P-16232	Phosphate Coatings, Heavy, Manganese or Zinc Base (For Ferrous Metals)
MIL-W-63150	Weapons and Support Material, Standard Quality Assurance Provisions
ANSI-B46.1	Surface Texture (Surface Roughness, Waviness & Lay)

PART II. QUALITY PROVISIONS

1. Responsibility for Inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

2. First Article Inspection.

2.1 Submission. Unless otherwise specified in the contract, a first article sample consisting of five (5) QAP items shall be submitted for inspection, testing and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any of the requirements.

2.2 Rejection. If any sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

3. Quality Conformance Inspection.

3.1 Quality Conformance Inspection shall consist of inspection of all characteristics contained in Part III "Inspection Requirements" and Part IV "Certification Provisions" of this QAP.

3.1.1 All other quality characteristics not specifically listed herein are subject to inspection under the contractor's quality or inspection system.

					ORIG CODE IDENT 19204		CAGE CODE 19200
16. REVISION SYMBOL AND DATE	E841126	G920910					10. QAP NO. 8448536
							14. PAGE NO. 2

QUALITY ASSURANCE PROVISIONS (QAP)

(DARCOM-R 702-10)

1. **COMMAND AGENCY:**

U.S. ARMY ARMAMENT, RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, N.J. 07806-5000

2. **THESE QAP'S FORM PART OF DRAWING/SPECIFICATION** 8448536 **AS SPECIFIED IN THE CONTRACT. INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.**

3.

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Unless otherwise specified herein or in the contract, the provisions of MIL-W-63150 shall apply and are made part of this detail QAP.

PART I. LIST OF APPLICABLE DOCUMENTS

DRAWINGS

B8448536	Spring, Rear Sight

STANDARDS

MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
FED-STD-791	Lubricants, Liquid Fuels & Related Products, Methods of Testing

DISTRIBUTION STATEMENT F. Further distribution only as directed by ASQNC-AR or higher DoD authority 92-06-22.

REVISIONS

4. RELEASE NUMBER	50625	W2S0015	G7S3140	W6S0120					
5. DATE	750430	841126	880218	920910					
4. RELEASE NUMBER									
5. DATE									

REVISION STATUS OF SHEETS	6. REVISION	G	G	G											
	7. SHEET	1	2	3											
	6. REVISION														
	7. SHEET														

8. QAP FOR: Spring, Rear Sight - used on M16/M16A1 Rifle	ORIG CODE IDENT 19204	CAGE CODE 19200
9. SUBMITTED BY	10. QAP NO.: 8448536	

11. DATE: 700528	12. APPROVED:	13. RELEASE NO. 05105	14. PAGE NO.: 1	15. NO. OF PAGES: 3

DARCOM FORM 2484-R-E

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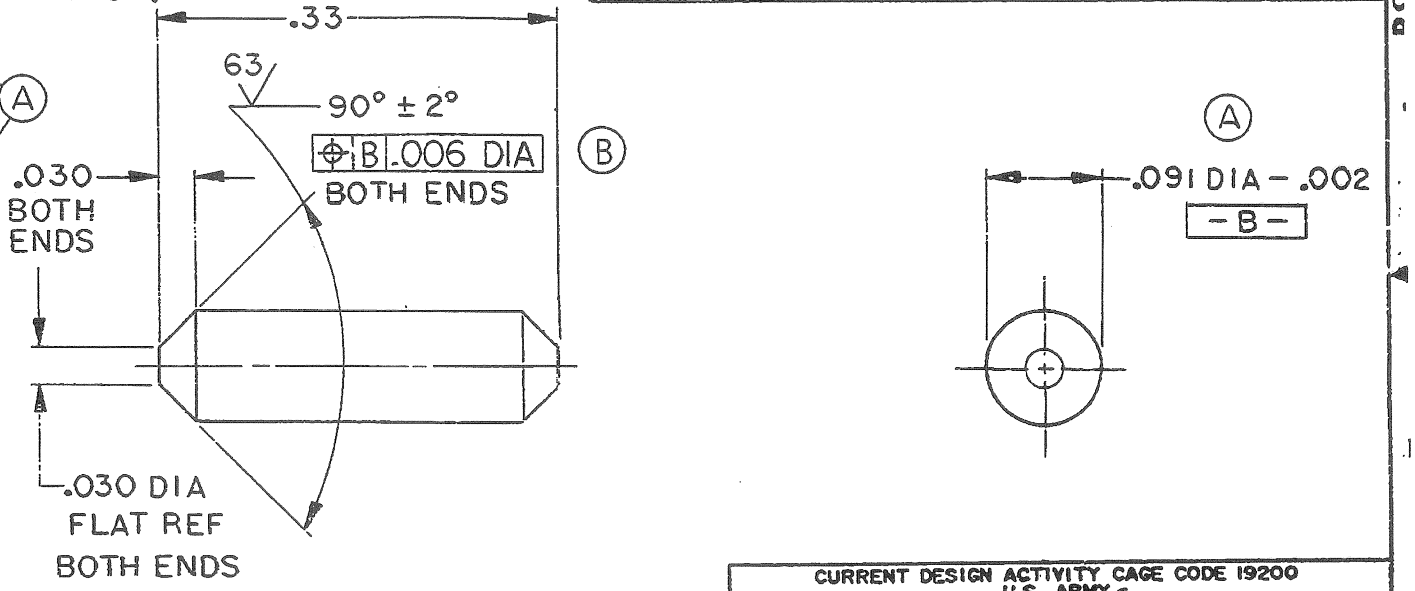
NOTES:

1. STEEL, CMPSN 1012 THRU 1018 OR 1212, 1213, 1215, 1113, ASTM A108. Ⓑ
2. FINISH 125√ EXCEPT AS NOTED. Ⓐ
3. BREAK SHARP EDGES .005 MAX.
4. FINISH 1.1.2.1 OF MIL-STD-171, DO NOT BAKE FOR EMBRITTLEMENT RELIEF.
5. CARBURIZE TO .010/.015 TOTAL CASE DEPTH.
6. ALL DIMENSIONS APPLY AFTER FINISH. Ⓐ
7. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
8. MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61698 REVISION B	27APR70	
		A	(4) SEE EO HRD 02197-3	15 JUL 70	
M		B	(2) SEE ERR HQR 20778	6 OCT 72	RE
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NORG0S3002/90-01-31	90-04-19	
		E	NOR G0S2018/ 91-07-08	91-10-11	RF
		F	NOR G2S3112/921217	930224	GH
		G	NOR G4S3064 940620	940727	RVSR



Ⓐ

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN		9390011	M4
YS MAX		F9327230	M231
EL 2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH	15N 89-91	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO
DATE 27 APR 1970
PREP Q.J. St.
CHK H. Leedham
ENGR D. Billiet
SUBMITTED F.P. Gilhooly
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DETENT, TAKEDOWN PIN

SIZE	CODE IDENT NO.	DRAWING NO
B	19204	8448585

SCALE 10/1 SHEET 1 OF 1

CD1

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:20 AM

PARTS LIST PL-8448638
DOCUMENT/PART NUMBER B 8448638
CATCH. MAGAZINE
CHANGE CONTROL NUMBER 76V0018 AUTHENTICATION-

ROCK ISLAND ARSENAL
ROCK ISLAND IL
CODE ID 19204

REV. DATE 16 APR 76
REVISION LETTER A
SHEET 1
ORIG. DATE 27 APR 70

FND NO.	QTY REQ	UNIT MEAS	CODE ID	PART OR IDENTIFYING NO.	DRAWING/DOCUMENT SZE	NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP LST
	1			8448639	C	8448639	PLATE, MAGAZINE CATCH	
	1			8448640	C	8448640	SHAFT, MAGAZINE CATCH	

TOTAL NUMBER OF SHEETS 1

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

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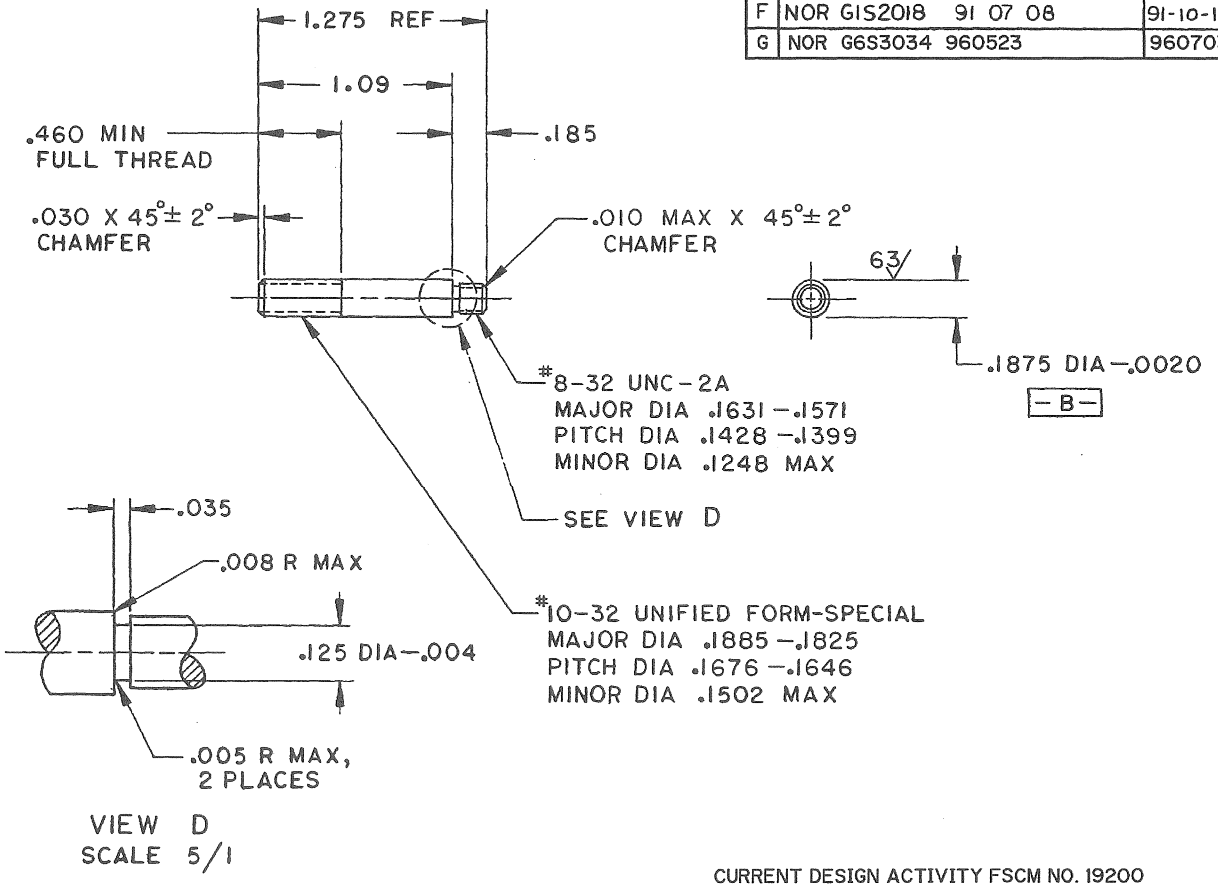
NOTES:

1. MATERIAL: STEEL, CMPSN 1018, 10L18, OR 11L18. ALTERNATE MATERIAL: COLD DRAWN SHAFTING, CMPSN 12L14 PER ASTM-A108. ALLOY STEEL BAR, AISI 8620 PER ASTM-A322.
2. FINISH 125√ EXCEPT AS NOTED.
3. ALL DIAMETERS $\boxed{\odot|B|.005\,DIA}$. Ⓑ
4. MIL-W-13855 APPLIES. Ⓑ


1.275 REF
1.09
.460 MIN
FULL THREAD
.185
.030 X 45° ± 2°
CHAMFER
.010 MAX X 45° ± 2°
CHAMFER
63√
.1875 DIA −.0020
−B−
#8-32 UNC-2A
MAJOR DIA .1631 −.1571
PITCH DIA .1428 −.1399
MINOR DIA .1248 MAX
SEE VIEW D
#10-32 UNIFIED FORM-SPECIAL
MAJOR DIA .1885 −.1825
PITCH DIA .1676 −.1646
MINOR DIA .1502 MAX
.035
.008 R MAX
.125 DIA −.004
.005 R MAX,
2 PLACES
VIEW D
SCALE 5/1

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61606 REVISION B	27 APR 70	
		A	(1) SEE EO HRD 02197-3	15 JUL 70	
		B	(3) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W2S3258/83-06-24	84-09-04	
		E	NOR G7S3041 / 870406	880222	ORFI-V2
		F	NOR G1S2018 91 07 08	91-10-11	RR
		G	NOR G6S3034 960523	960703	FET

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448638	M4
		B 8448638	M231
BH			M16
		B8448638	M16A2
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ______
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
______

CONTRACT NO

DATE 27 APR 1970
PREPARED RGA
CHECKED
ENGINEER
SUBMITTED F.P. Gilhooly
APPROVED R.S. Henry

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SHAFT,
MAGAZINE CATCH

SIZE	CODE IDENT NO	DRAWING NO
C	19204	8448640

SCALE 2/1 SHEET 1 OF 1

C8448640

CDI

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:17 AM

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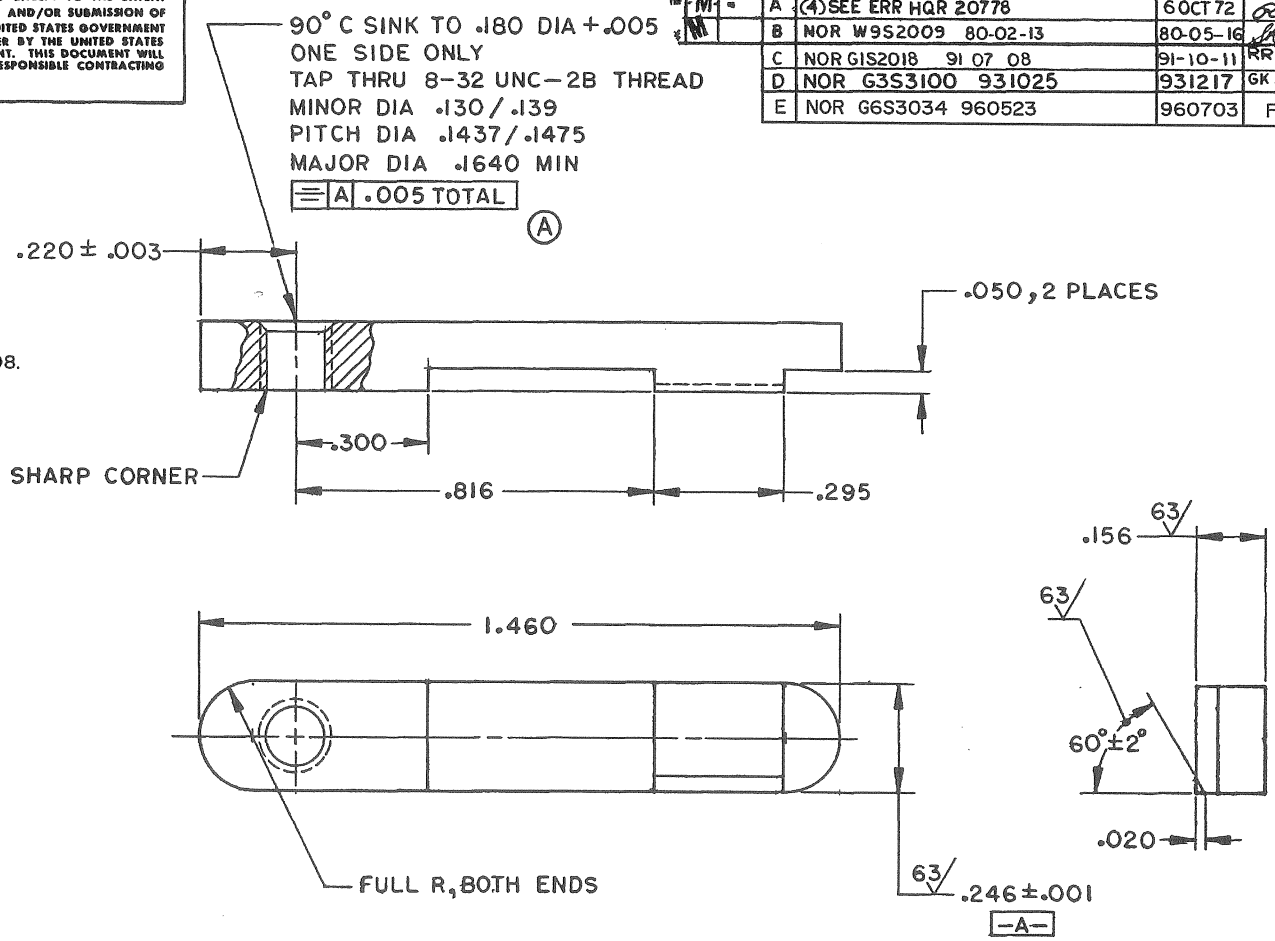
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61605 REVISION B	27 APR 70	
M		A	(4)SEE ERR HQR 20778	6 OCT 72	R.E.
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G1S2018 91 07 08	91-10-11	RR
		D	NOR G3S3100 931025	931217	GK
		E	NOR G6S3034 960523	960703	FET

NOTES:

1. FINISH $\overset{125}{\surd}$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 + .005 EXCEPT AS NOTED.
3. CARBURIZE .010 TO .015 TOTAL CASE DEPTH.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES. ⓐ
6. MATERIAL: STEEL, CMPSN 1018, PER ASTM-A108. ALTERATE MATERIAL: STEEL, AISI 8620 PER ASTM-A322 OR ASTM-A505.



C8448639

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEEING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

Ⓐ Ⓐ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		8448638	M4
RA		B8448638	M231
BH			M16
		B8448638	M16A1
RH	15N89 91	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ±

MATERIAL
SEE NOTE 6

FINAL PROTECTIVE FINISH

CONTRACT NO.

DATE 27 APR 1970
PREPARED RGA
CHECKED
ENGINEER D. Elliott
SUBMITTED F P Gilhooly
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PLATE, MAGAZINE
CATCH

SIZE C
CODE IDENT NO 19204
DRAWING NO. 8448639
SCALE 5/1
SHEET 1 OF 1

CDI

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:17 AM

DRAWING SIZE C
(ARRADCOMR 70-12)

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S0030/84-11-15	850402	
B	NOR W5S8004/860204	890215	
C	NOR G9S2089 890928	900329	

NOTES :—

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 — MATERIAL :—

A. SCREW — STEEL WIRE OR ROD, CMPSN 1010 THRU 1018 OR 10L18, SPEC. ASTM A108.

B. ELEMENT — MUST MEET THE PERFORMANCE REQUIREMENTS OF MIL-F-18240 CONFIGURATION A OR B PATCH. LOCATION OF ELEMENT SHALL BE WITHIN THE DIMENSIONAL LIMITATIONS OF STANDARD MS 15981.

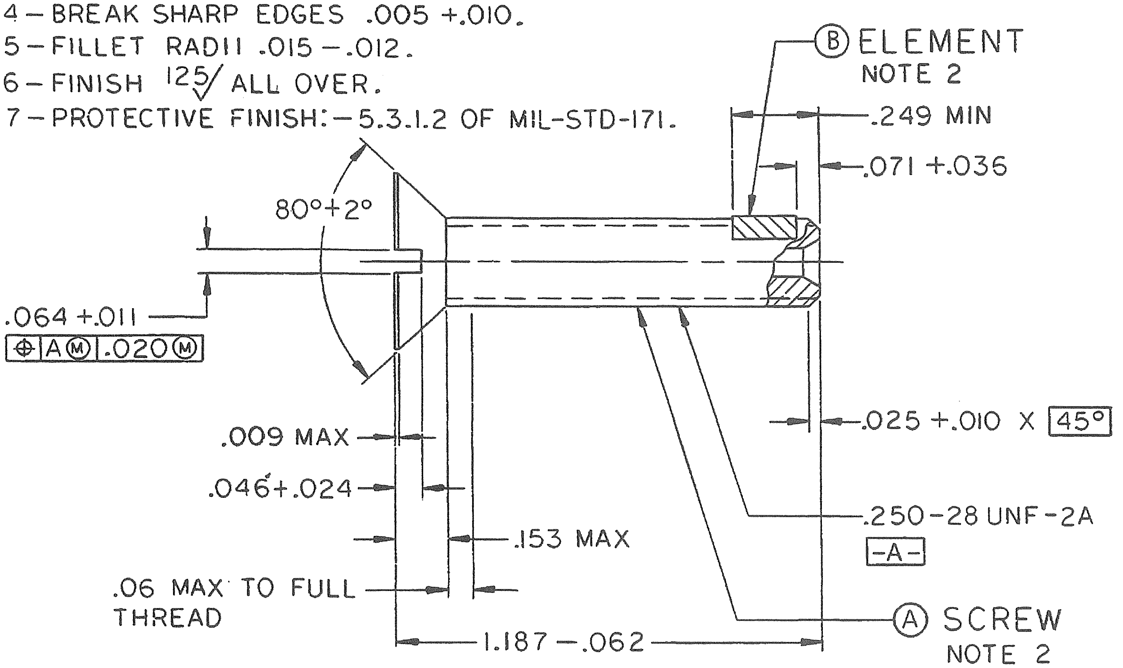
3 — COVERAGE OF ELEMENT TO BE 90° MIN OF THREADED DIA. RANDOM RADIAL LOCATION OF ELEMENT.

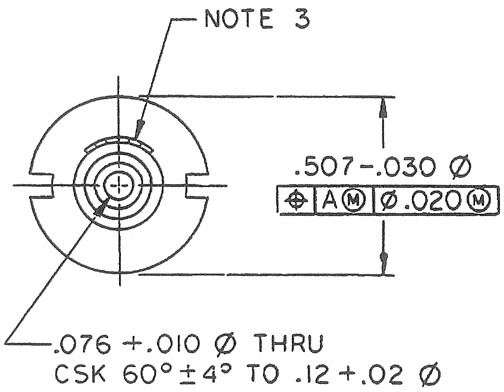
4 — BREAK SHARP EDGES .005 +.010.

5 — FILLET RADII .015 —.012.

6 — FINISH 125/ ALL OVER.

7 — PROTECTIVE FINISH:— 5.3.1.2 OF MIL-STD-171.





PART NO. 9349128

8448578	M16A1
8448604	M16
9349100	M16A2
NEXT ASSY	USED ON
APPLICATION	

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN EJZ
CHECKER AB
ENGR R Van Bodegom
ENGR
ENGR
ENGR
Robert J. McHugh

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SCREW, BUTT CAP

SIZE C
FSCM NO. 19200
9349128
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 67 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED

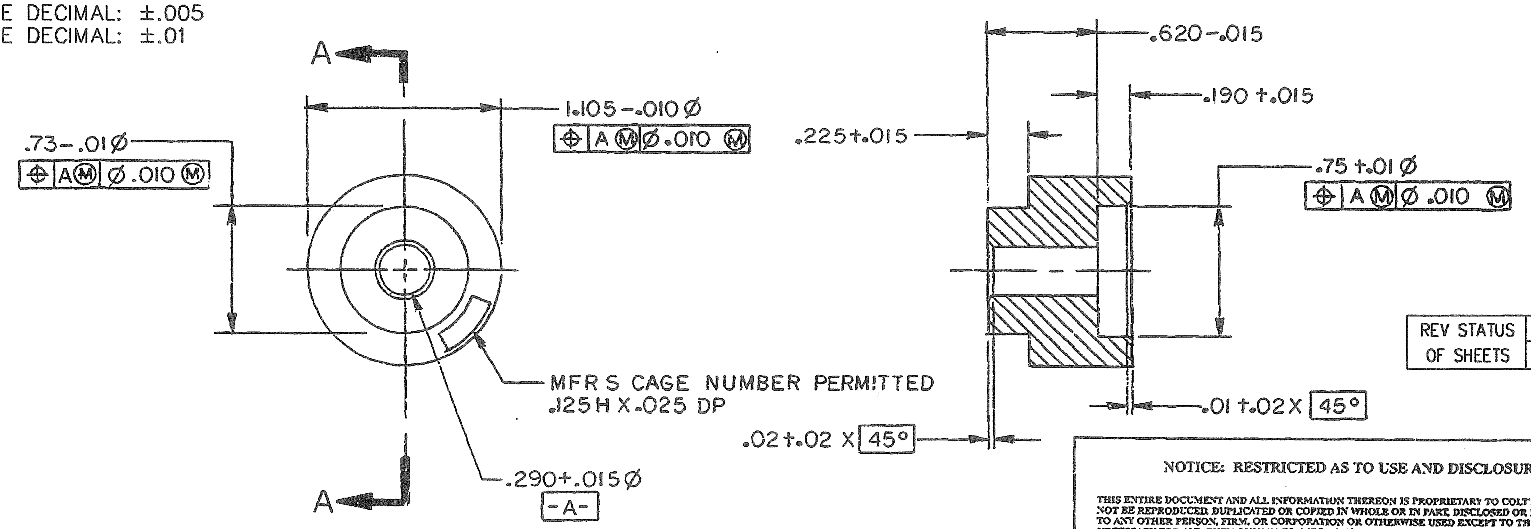
October 15, 2004 11:16 AM

NOTES:-

1 - SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
2 - MATERIAL: PLASTIC COMPOUND PER ASTM D-4066, PA162.
3 - COLOR: NATURAL
4 - BREAK SHARP EDGES .010 ±.005 UNLESS NOTED
5 - REMOVE ALL FLASH, ON PLASTIC PARTS ONLY.
6 PART SHALL BE FREE FROM POROSITY, CRACKING, DEFORMATION OR KNIT MARKS, ON PLASTIC PARTS ONLY.
7 -
8 - FINISH 125/ ALL SURFACES.
9 - ALTERNATE MATERIAL: ALUMINUM ALLOY 2024-T351 SPEC QQ-A-225/6, ALTERNATE ALLOYS, 2017-T451 SPEC QQ-A-225/5, OR 6061-T651 SPEC QQ-A-225/8.
10 - PROTECTIVE FINISH FOR ALTERNATE MATERIAL: MIL-A-8625, TYPE III CLASS 2, FILM THICKNESS .0010±.0002, SEALED.
11 - DIMENSIONS SHOWN ARE BEFORE FINAL PROTECTIVE FINISH, ON ALUMINUM PARTS ONLY.
12 - SEE SHEET 2 OF 2 FOR ALTERNATE PLASTIC MOLDED CONFIGURATION.
13 - TOLERANCE UNLESS OTHERWISE SPECIFIED:
  3 PLACE DECIMAL: ±.005
  2 PLACE DECIMAL: ±.01

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCT BASELINE ERR G7S9452	88-01-19	
A	NOR G8S2004/880329	881007	
B	NOR G8S3107 881021	890221	
C	ERR Z9Z1148J (ECP G9S3019/890421) (ECP G9S3031/890523)	890912	ORPI CQ2
D	NOR G9S2030/89-06-21	90-02-09	
E	NOR G1S3077/910626	910820	GHS
F	NOR G2S3084/920924	921105	GHS
G	NOR G2S2052/921217	930225	RP
H	NOR G6S9003/960722	961113	MG



REV STATUS OF SHEETS	REV	H	H
	SH	1	2

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DISTRIBUTION STATEMENT F
DISTRIBUTION IS AUTHORIZED TO DOD AGENCIES AND DOD QUALIFIED US ORDNSNCE CONTRACTORS.FURTHER DISSEMINATION ONLY AS DIRECTED BY COMMANDER ARDEC ATTN: SMCAR-ESW.ROCK ISLAND ASQNC-AR THIS DETERMINATION WAS MADE ON 91-10-25

PART NO.12597640

NEXT ASSY	USED ON
12556127	M16A1
9349100	M16A2
APPLICATION	

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±
THIRD ANGLE PROJECTION

ORIGINAL DATE OF DRAWING 88-01-19
DRAFTSMAN J.BRENNAN
CHECKER
ENGR
ENGR
ENGR
ENGR FUNCASTA

U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
DOVER, NEW JERSEY 07801-5001

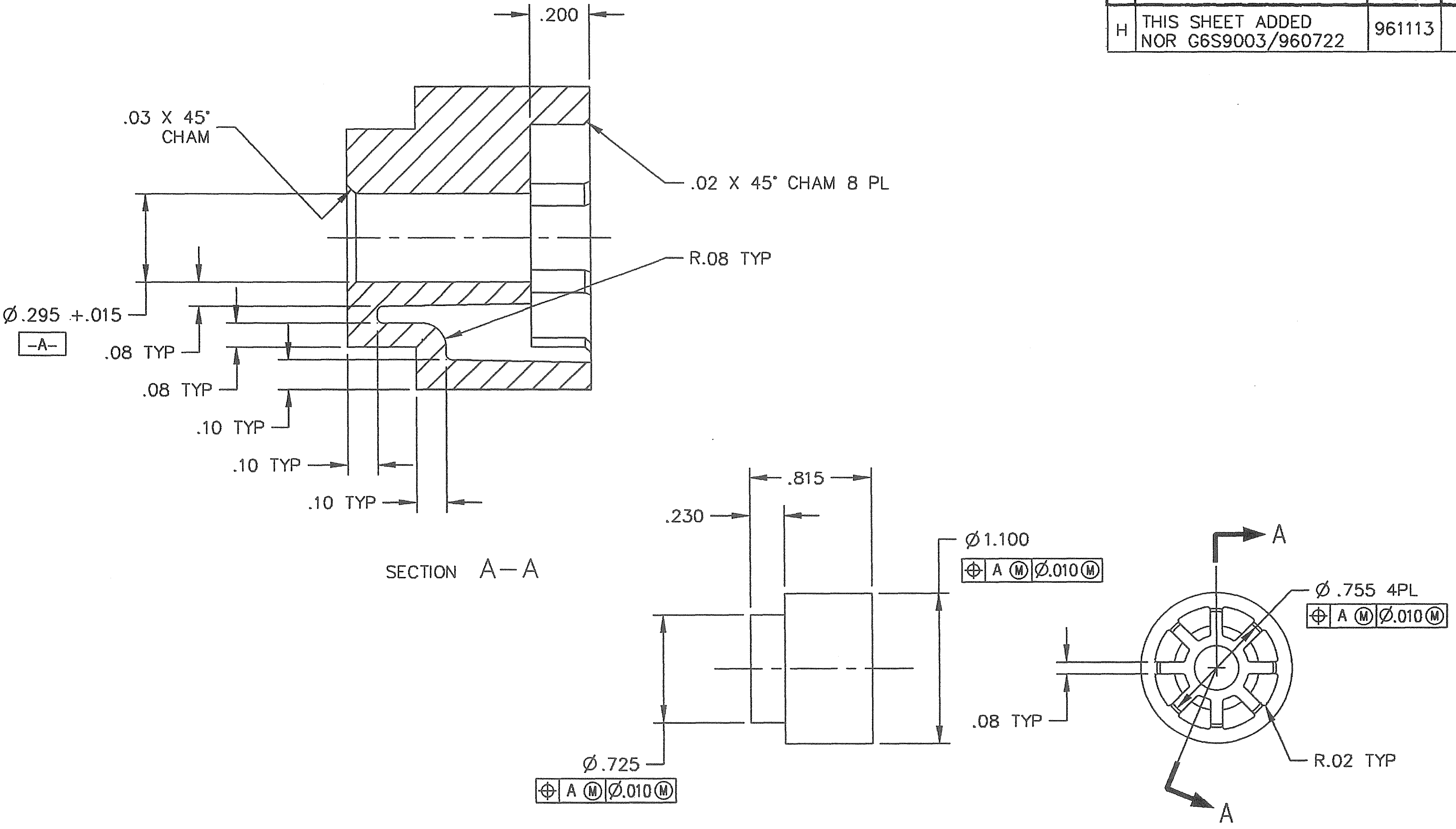
SPACER, BUTTCAP

SIZE C
FSCM NO. 19200
12597640
SCALE 2/1
UNIT WT.
SHEET 1 OF 2

SMCAR FORM 67. 1 JUN 86(TEMP) REPLACES SMCAR FORM 67. 1 FEB 85. WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:16 AM

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
H	THIS SHEET ADDED NOR G6S9003/960722	961113	MG



.200
.03 X 45° CHAM
.02 X 45° CHAM 8 PL
R.08 TYP
Ø.295 +.015
-A-
.08 TYP
.08 TYP
.10 TYP
.10 TYP
.10 TYP
SECTION A–A
.815
.230
Ø1.100
⊕ A Ⓜ Ø.010 Ⓜ
Ø.725
⊕ A Ⓜ Ø.010 Ⓜ
A
A
Ø .755 4PL
⊕ A Ⓜ Ø.010 Ⓜ
.08 TYP
R.02 TYP

ALTERNATE PLASTIC MOLDED CONFIGURATION

PART NO.12597640

NEXT ASSY	USED ON	MECHANICAL PROPERTIES YP TS EL2 RA BH RH	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS 2 PL ± .01 3 PL ± .005 FRACTIONS ± ANGLES ± THIRD ANGLE PROJECTION	ORIGINAL DATE OF DRAWING 96–11–13 DRAFTSMAN EJL CHECKER MG ENGR ENGR ENGR ENGR	U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER DOVER, NEW JERSEY 07801-5001 SPACER, BUTTCAP SIZE C FSCM NO. 19200 12597640 SCALE 2/1 UNIT WT. SHEET 2 OF 2
APPLICATION					

October 15, 2004 11:16 AM

5 4 3 2 1

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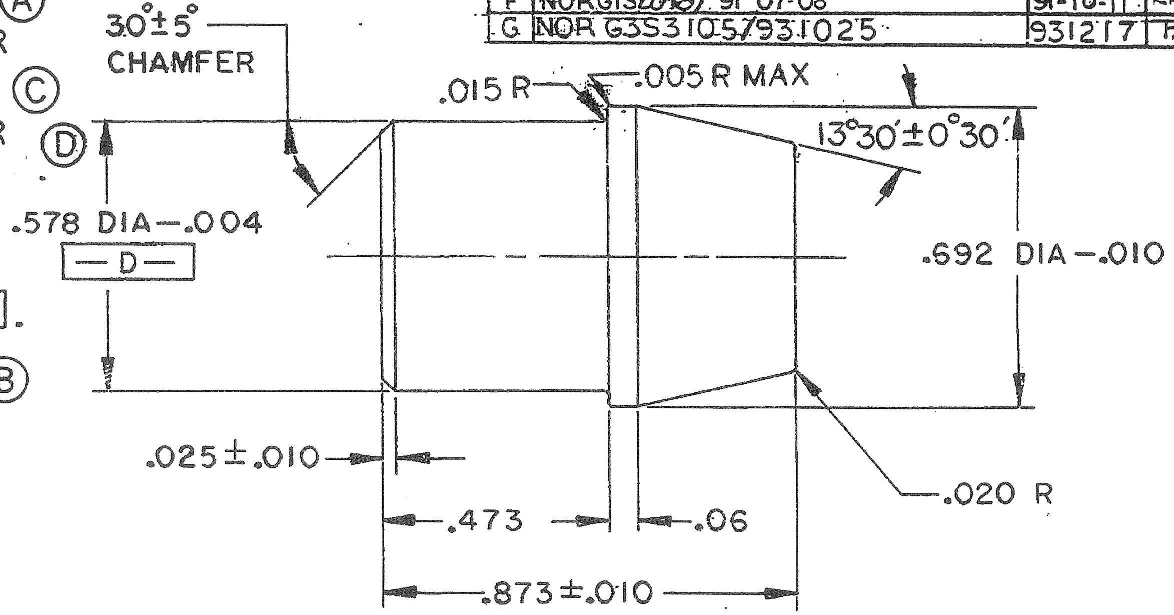
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62384 REVISION A	27 APR 70	
		A	SEE ERR HQR 20651	24 APR 72	LB
M		B	SEE ERR HQR 20778	6 OCT 72	R.E.
		C	SEE ERR HQR 30660	12 MAR 73	LB
		D	(2) SEE ERR HQR 40620	2 MAY 74	LB
		E	NORW280026 82-05-21	83-02-03	
		F	NORGIS2018/ 91 07-08	91-10-11	RR
		G	NOR G3S3105/931025	931217	SR

NOTES:

1. RUBBER, POLYETHER URETHANE, CASTABLE, SHORE A DUROMETER 95±3. Ⓐ
2. RESILIENCE, WHEN TESTED PER ASTM D2632 SHALL BE 40±4.
3. NO PARTING LINE PERMISSIBLE ON -D-.
4. ALL DIAMETERS ⌖ D .005 DIA.
5. MIL-W-13855 APPLIES. Ⓑ



CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				
YS MIN				
YS MAX		9390023	M4	
EL 2			M16	
RA		C8448615	M16A1	
BH		NEXT ASSY	USED ON	
RH		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO.
DATE 27 APR 1970
PREP RGD
CHK
ENGR D. Billiot
SUBMITTED F.P. Gilleroy
APPROVED R. S. Henry

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS, 61201

BUMPER, BUFFER

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448619
SCALE 4/1
SHEET 1 OF 1

B8448619

AMSWE Form 403B, 29 Jul 69

CDI

October 15, 2004 11:12 AM

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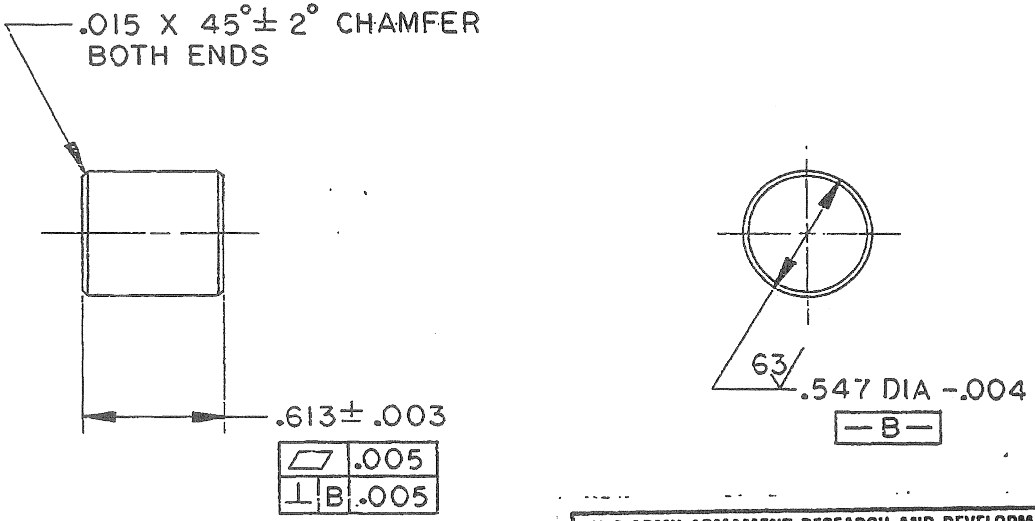
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B62342 REVISION B	27 APR 70	
		A	(2)SEE ERR HQR 20778	6 OCT 72	R.E.
		B	NOR W9S2009-80-02-13	80-05-16	
		C	ERR Z9Z1182AU (ECP G8S3115 881109)	[illegible]	
		D	NOR G1S2018 91 07 08	91-10-11	RR
		E	NOR G3S3118 931130	940317	

8448617

NOTES: Ⓐ

1. STEEL, CMPSN 1013, 1015, 1213 OR 1215, ASTM A108
2. FINISH 125√ EXCEPT AS NOTED.
3. MIL-W-13855 APPLIES. Ⓐ



DISTRIBUTION STATEMENT F
DISTRIBUTION IS AUTHORIZED TO DOD AGENCIES AND DOD QUALIFIED US ORDNANCE CONTRACTORS. FURTHER DISSEMINATION ONLY AS DIRECTED BY COMMANDER ARDEC ATTN: SMCAR-FSM, PICATINNY ARSENAL, NJ 07806-5000. THIS TECHNICAL DATA PACKAGE CONTAINS SENSITIVE TECHNOLOGY ON A NEW WEAPON SYSTEM. THIS DETERMINATION WAS MADE ON JULY 1987.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT
CODE IDENT NO.
19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390023	M4
EL 2			M16
RA		C8448615	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± ——

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO
DATE 27 APR 1970
PREP RGA G.J. [illegible]
CHK
ENGR
SUBMITTED F. P. [illegible]
APPROVED R. S. Henry

DEPT OF THE ~~ARMY~~
~~US ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

WEIGHT, BUFFER

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448617
SCALE 2/1
SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

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October 15, 2004 11:12 AM

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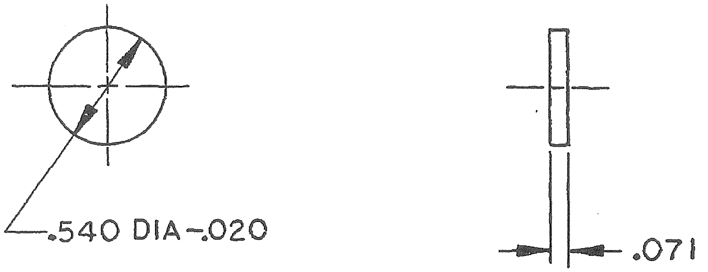
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B62343 REVISION A	27 APR 70	
		A	(1) SEE EO HRD 02197-3	15 JUL 70	
		B	(1) SEE ERR HQR 20778	6 OCT 72	R.S.
		C	NORW280026 82-05-21	83-02-03	
		D	NOR GIS2018 91 07 08	91-10-11	
		E	NOR G9S3108 891117	970303	JB

B8448618

NOTES:

1. MATERIAL:- RUBBER, SYNTHETIC, CLASS I, GRADE 70, SPEC MIL-R-6855. VALCANIZED RUBBER SHALL NOT INITIATE CORROSION UPON THE METALS THAT IT COMES INTO CONTACT.
2. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± —— 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± ——	CONTRACT NO DATE 27 APR 1970
YS MIN				PREP RGR
YS MAX	9390023	M4	MATERIAL SEE NOTE 1	CHK
EL 2		M16		ENGR D. Smart D. Billet
RA	C8448615	M16A1		SUBMITTED
BH	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED R. S. Henry
RH	APPLICATION			

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DISC, BUFFER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448618

SCALE 2/1 SHEET 1 OF 1

CDI

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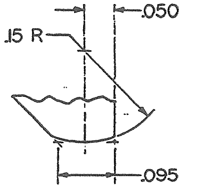
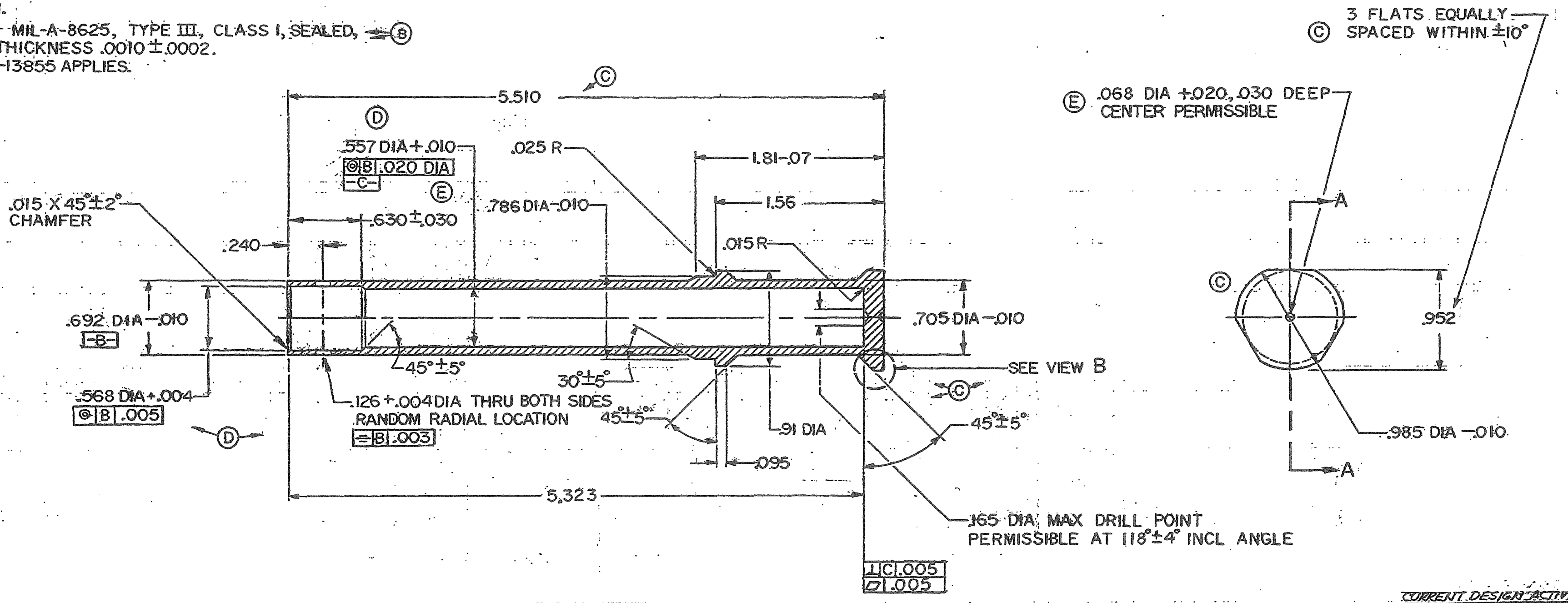
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D 52340 REV. B	27 APR 70	
M		A	(1) SEE EO HRD 02197-3	15 JULY 70	JWS
M		B	(1) SEE EO HRD 02257	15 OCT 70	
M		C	(6) SEE EO HQR 10649	20 FEB 71	
M		D	(3) SEE ERR HQR 10836	13 SEP 71	
M	-	E	(4) SEE ERR HQR 20778	6 OCT. 72	R.E.
		F	NOR W4S3048/84-10-09 (ECP W4S0041/84-12-18)	85-02-14	RHD

NOTES:

1. AL ALLOY, 7075-T6 OR T651, COLD DRAWN PER QQ-A-225/9 OR AL ALLOY, 7075-T6 OR T6510 EXTRUDED PER QQ-A-200/11.
2. FINISH 125√.
3. FILLET RADII TO BE .03.
4. BREAK SHARP EDGES .010 MAX.
5. ALL DIAMETERS TO BE ◎|B|.010 DIA| EXCEPT AS NOTED. Ⓐ Ⓔ
6. ALL DIMENSIONS APPLY BEFORE FINISH.
7. FINISH MIL-A-8625, TYPE III, CLASS I, SEALED, ⟸ Ⓑ FILM THICKNESS .0010 ± .0002.
8. MIL-W-13855 APPLIES.



VIEW B
SCALE 10/1 Ⓒ



3 FLATS EQUALLY SPACED WITHIN ±10°
Ⓒ
Ⓔ .068 DIA +.020, .030 DEEP CENTER PERMISSIBLE
5.510
Ⓓ
.557 DIA +.010
◎|B|.020 DIA|
-C-
Ⓔ
.025 R
1.81 -.07
1.56
.015 X 45° ±2° CHAMFER
.630 ±.030
.786 DIA -.010
.240
.015 R
.692 DIA -.010
-B-
.705 DIA -.010
45° ±5°
30° ±5°
SEE VIEW B
.568 DIA +.004
◎|B|.005|
.126 +.004 DIA THRU BOTH SIDES RANDOM RADIAL LOCATION
=|B|.003|
45° ±5°
.91 DIA
45° ±5°
.095
5.323
.165 DIA MAX DRILL POINT PERMISSIBLE AT 118° ±4° INCL ANGLE
⊥|C|.005|
▱|.005|
A
A
.952
.985 DIA -.010

SECTION A-A

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		
YS MIN		
YS MAX		
EL 2		
RA		
BH		M16
RH	C8448615	M16A1
	NEXT ASSY	USED ON
	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 7

CONTRACT NO:

DATE 27 APR 1970

PREPARED	REB	A. Jeff
CHECKED		V. Kiolak
ENGINEER		O. Gilliat
SUBMITTED	F. P. Gilliat	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BODY, BUFFER

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448616
SCALE 2/1		SHEET 1 OF 1

CDI

D 8448616

AMSWE-Form 403D, 29 Jul 69

October 15, 2004 11:11 AM

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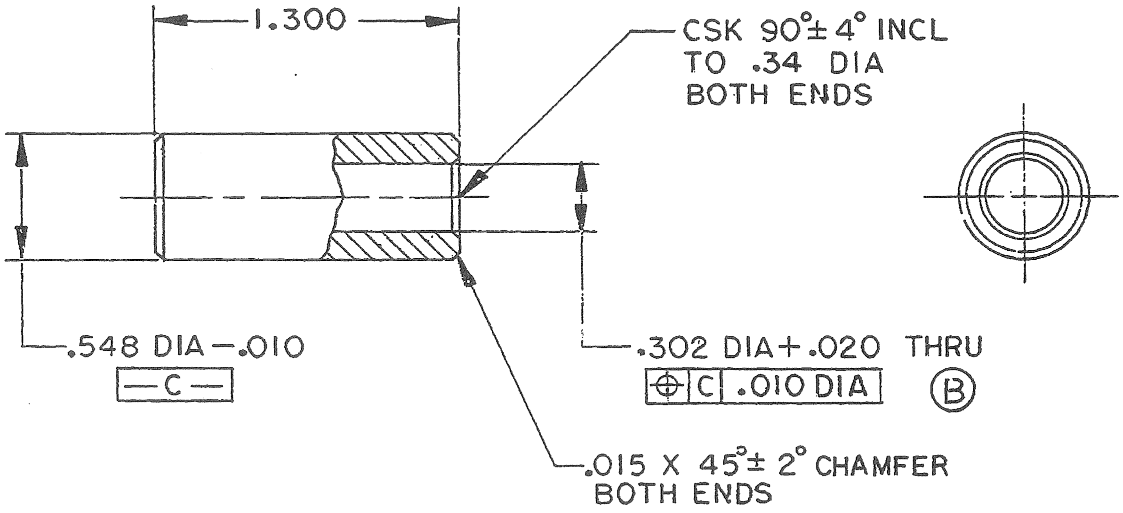
REVISIONS

ME	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B62412 REVISION A	27 APR 70	
M		A	(2) SEE HQR 10689	26 APR 71	[illegible] B
M		B	SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NORW2S0026 82-05-21	83-02-03	[illegible]

B 8448620

NOTE:

1. AL ALLOY, 7075-T6 OR T651, COLD DRAWN PER QQ-A-225/9 OR AL ALLOY 7075-T6 OR T6510, EXTRUDED PER QQ-A-200/11.
2. FINISH 125/√.
3. ALL DIMENSIONS APPLY BEFORE FINISH.
4. FINISH MIL-A-8625, TYPE III, CLASS 1, FILM THICKNESS .0010 ± .0002. Ⓐ
5. MIL-W-13855 APPLIES.


1.300
CSK 90° ± 4° INCL TO .34 DIA BOTH ENDS
.548 DIA -.010
-C-
.302 DIA +.020 THRU
⌖ C .010 DIA
Ⓑ
.015 X 45° ± 2° CHAMFER BOTH ENDS

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

Ⓐ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			M16
RA		C8448615	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO:
DATE 27 APR 1970
PREP R.G.H. A.J.D.
CHK [illegible] H. Leadham
ENGR S. Smart D. Billiot
SUBMITTED H.P. Gillooly
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPACER, BUFFER

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448620
SCALE 2/1
SHEET 1 OF 1

CDI

AMSWE Form 4038, 29 Jul 69

October 15, 2004 11:11 AM

ARMAMENT RESEARCH & DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801-5001

PARTS LIST PL-8448615 CURRENT FSCM NO. 19200 - ORIGINAL FSCM NO. 19204 REV. DATE 25 July 85
DOCUMENT/PART NUMBER C 8448615 REVISION LETTER C
BUFFER ASSEMBLY SHEET 1
CHANGE CONTROL NUMBER W5S2023 AUTHENTICATION- Edward J ORIG. DATE

FND NO.	QTY REQ	UNIT MEAS	FSCM NO.	PART OR IDENTIFYING NO	DRAWING/DOCUMENT SZE	DRAWING/DOCUMENT NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP LST
	1			8448521-1	B	8448521	PIN, SPRING	
	1			8448616	D	8448616	BODY, BUFFER	
	5			8448617	B	8448617	WEIGHT, BUFFER	
	5			8448618	B	8448618	DISC, BUFFER	
	1			8448619	B	8448619	BUMPER, BUFFER	
	1			8448620	B	8448620	SPACER, BUFFER	

TOTAL NUMBER OF SHEETS 1

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

October 15, 2004 11:10 AM

4 3 2 1

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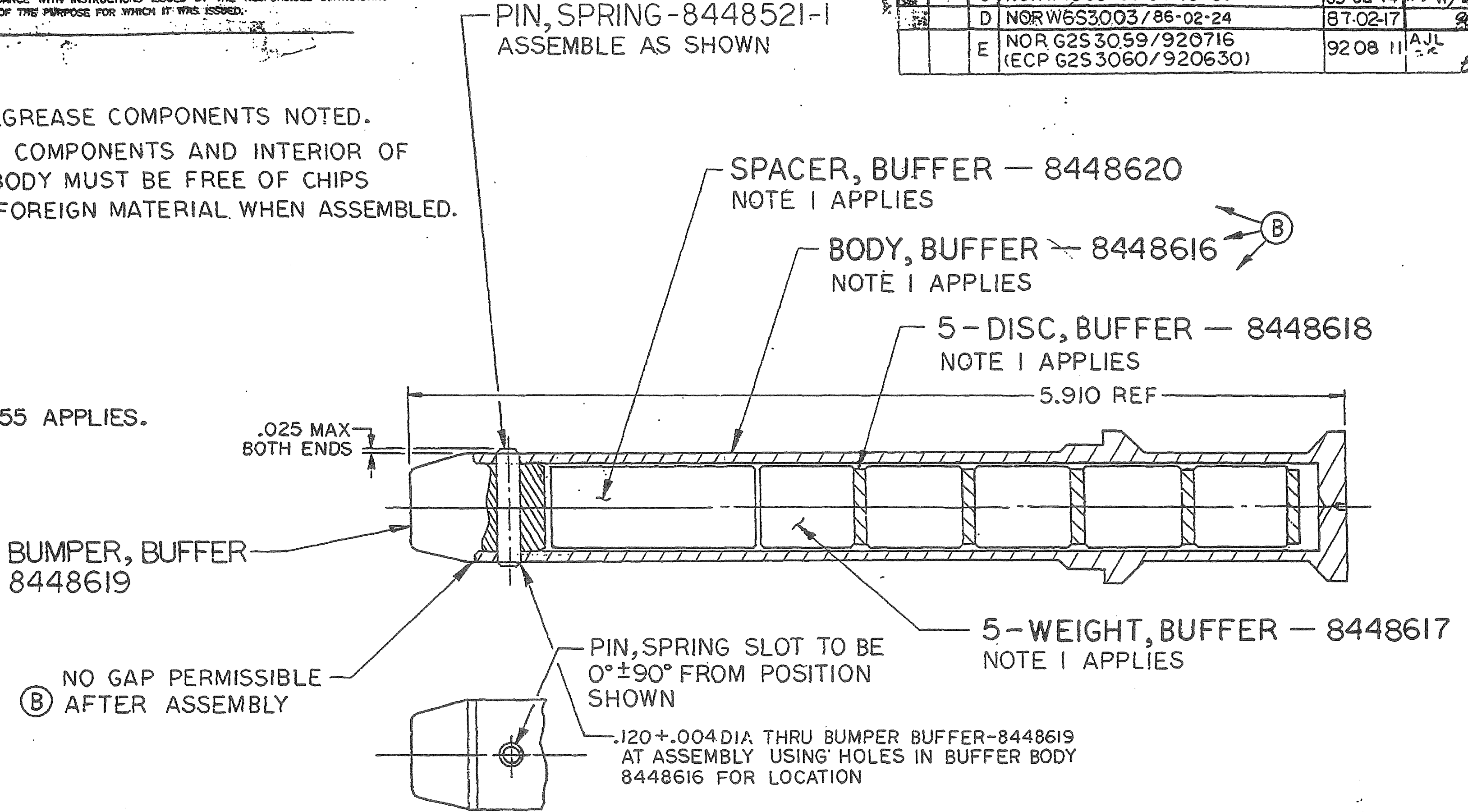
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C 62339 REV A	27 APR 70	
		A	SEE ERR HQR 10836	13 SEP 71	
		B	(2) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NOR W4S3048 / 84-10-09	85-02-14	
		D	NOR W6S3003 / 86-02-24	87-02-17	
		E	NOR G2S3059/920716 (ECP G2S3060/920630)	92 08 11	AJL

NOTE:

1. VAPOR DEGREASE COMPONENTS NOTED.
2. INTERNAL COMPONENTS AND INTERIOR OF BUFFER BODY MUST BE FREE OF CHIPS AND/OR FOREIGN MATERIAL WHEN ASSEMBLED.
4. MIL-W-13855 APPLIES.


PIN, SPRING-8448521-1
ASSEMBLE AS SHOWN
SPACER, BUFFER — 8448620
NOTE 1 APPLIES
BODY, BUFFER — 8448616
NOTE 1 APPLIES
B
5-DISC, BUFFER — 8448618
NOTE 1 APPLIES
5.910 REF
.025 MAX
BOTH ENDS
BUMPER, BUFFER
8448619
5-WEIGHT, BUFFER — 8448617
NOTE 1 APPLIES
PIN, SPRING SLOT TO BE 0°±90° FROM POSITION SHOWN
NO GAP PERMISSIBLE
B AFTER ASSEMBLY
.120+.004 DIA THRU BUMPER BUFFER-8448619 AT ASSEMBLY USING HOLES IN BUFFER BODY 8448616 FOR LOCATION

C8448615

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

SEE PL-8448615

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		F8448604	M16
RH		F8448578	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970
PREPARED G-R
CHECKED
ENGINEER B. Billiet
SUBMITTED
APPROVED K. S. Kenney

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BUFFER ASSEMBLY

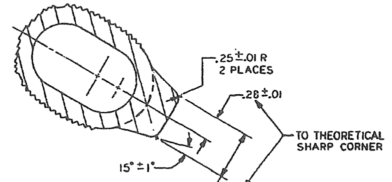
SIZE C | CODE IDENT NO. 19204 | DRAWING NO. 8448615
SCALE 2/1 | SHEET 1 OF 1

CDI

AMSWE Form 403C, 29 Jul 69

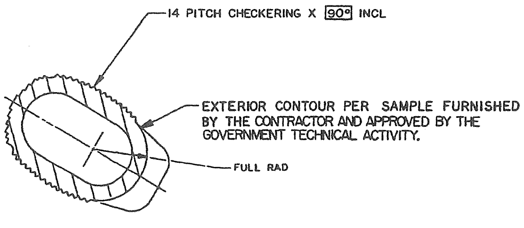
October 15, 2004 11:10 AM

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S 3259/82-12-30	83-08-26	
B	NOR W3S 3145/83-09-28	83-11-04	
C	NOR W4S 0010/84-06-20	84-07-20	
D	NOR W4S 0030/84-11-15	850402	
E	NOR W5S 3016/85-03-25	850625	
F	NORW[illegible]	870219	
G	NOR W5S8004/860204	890215	
H	ERR Z92126188 (ECP G8S3018, 88-03-29) (ECP G9S3031, 89-05-23) (ECP G0S3015, 90-03-07)	90-03-06	
J	NOR G1S2018 91-07-08	911011	PP



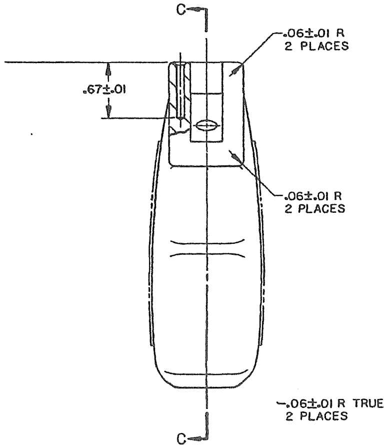
.25±.01 R
2 PLACES
.28±.01
TO THEORETICAL
SHARP CORNER
15°±1°
.56±.01

SECTION B—B

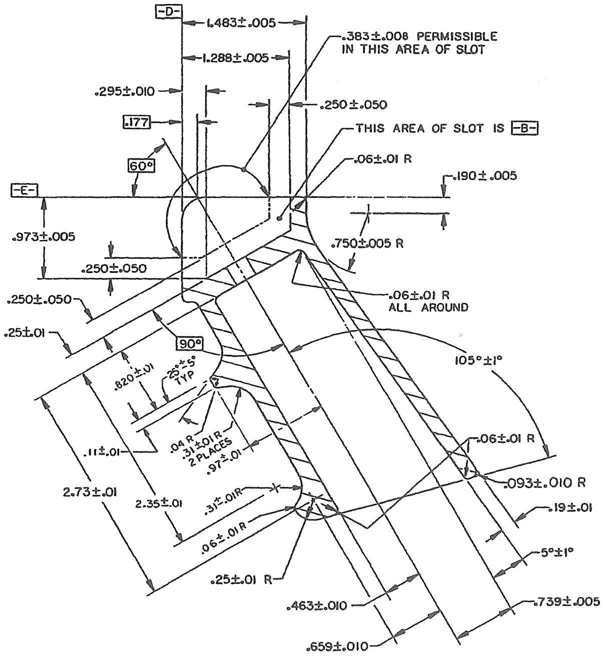


14 PITCH CHECKERING X 90° INCL
EXTERIOR CONTOUR PER SAMPLE FURNISHED BY THE CONTRACTOR AND APPROVED BY THE GOVERNMENT TECHNICAL ACTIVITY.
FULL RAD

SECTION D—D



C
.67±.01
.06±.01 R
2 PLACES
.06±.01 R
2 PLACES
.06±.01 R TRUE
2 PLACES
C



-D-
1.483±.005
1.288±.005
.383±.008 PERMISSIBLE
IN THIS AREA OF SLOT
.295±.010
.250±.050
.177
THIS AREA OF SLOT IS -B-
60°
.06±.01 R
-E-
.190±.005
.973±.005
.750±.005 R
.250±.050
.250±.050
.06±.01 R
ALL AROUND
.25±.01
90°
105°±1°
.820±.01
25°±5°
TYP
.04 R
.31±.01 R
2 PLACES
.97±.01
.11±.01
.06±.01 R
2.73±.01
2.35±.01
.31±.01R
.093±.010 R
.19±.01
.06±.01 R
5°±1°
.25±.01 R
.463±.010
.739±.005
.659±.010

SECTION C—C

F-2/2

PART NO. 9349127

		MECHANICAL PROPERTIES	
		YP	
9390011	M4	TS	
F9327230	M231	ELP	
F8448604	M16	RA	
F8448578	M16A1	BH	
9349100	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN SMI CHECKER A B
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

GRIP, PISTOL

SIZE J
FSCM NO. 19200
9349127
SCALE 2/1
UNIT WT
SHEET 1

SH REV J

2-FR.

October 15, 2004 11:13 AM

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NOTES:-

1 — SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 — MATERIAL:- PLASTIC COMPOUND PER ASTM D4066, PA 162. COLOR SHALL BE LUSTERLESS (FLAT), APPROX. BLACK NO. 37038, TABLE IX. BUT NOT LIGHTER THAN GRAY, NO. 36076 TABLE VIII OF FED-STD-595.

3 — BREAK SHARP EDGES .010±.005 UNLESS OTHERWISE NOTED.

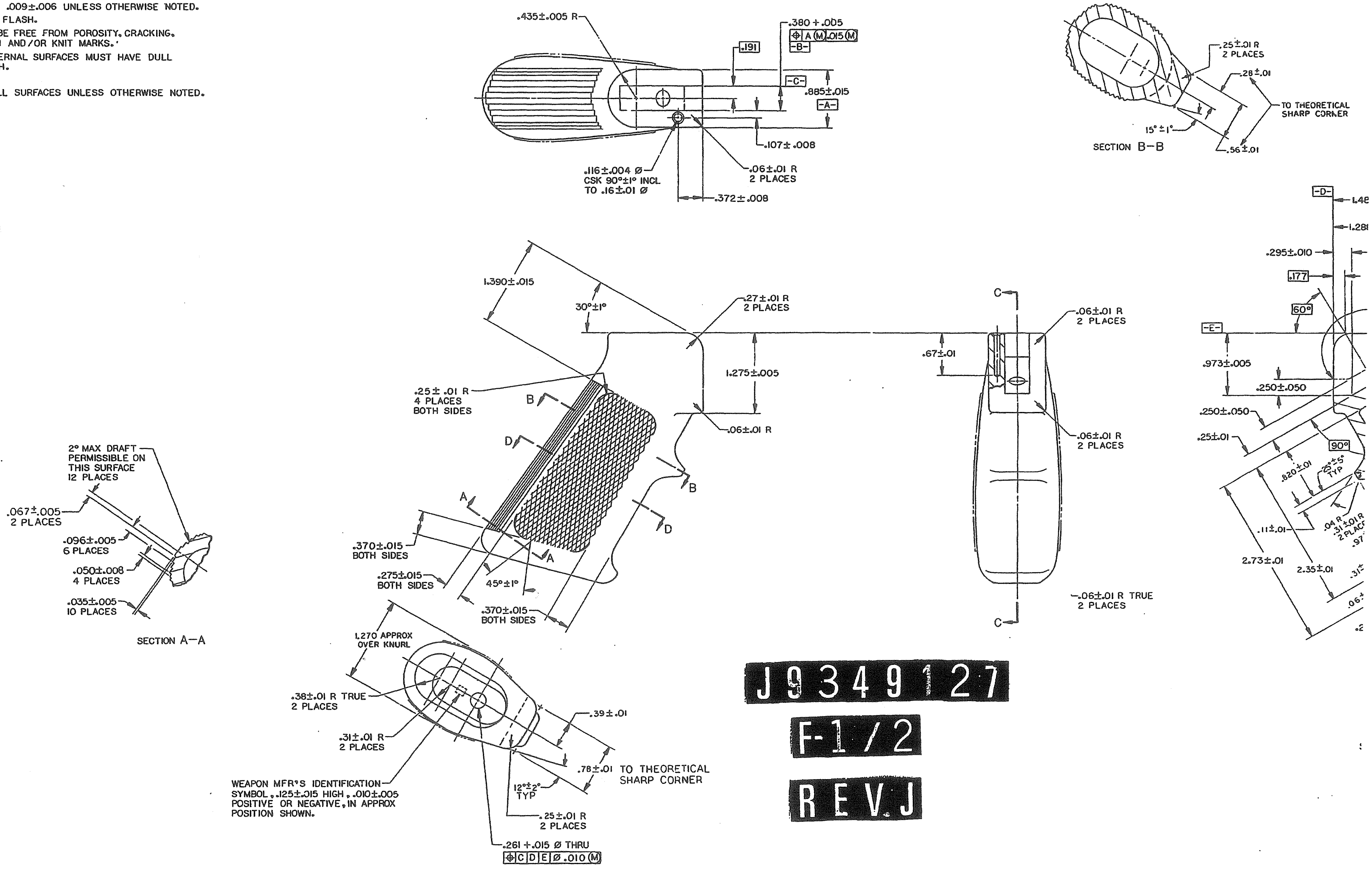
4 — FILLET RADII .009±.006 UNLESS OTHERWISE NOTED.

5 — REMOVE ALL FLASH.

6 — PART SHALL BE FREE FROM POROSITY, CRACKING, DEFORMATION AND/OR KNIT MARKS.

7 — FINISH:- EXTERNAL SURFACES MUST HAVE DULL MATTE FINISH.

8 — FINISH $\sqrt{}^{125}$ ALL SURFACES UNLESS OTHERWISE NOTED.


.435±.005 R
.380 +.005
⌖ A Ⓜ .015 Ⓜ
-B-
.191
-C-
.885±.015
-A-
.107±.008
.116±.004 Ø
CSK 90°±1° INCL
TO .16±.01 Ø
.06±.01 R
2 PLACES
.372±.008
.25±.01 R
2 PLACES
.28±.01
TO THEORETICAL
SHARP CORNER
15°±1°
SECTION B-B
.56±.01
1.390±.015
30°±1°
.27±.01 R
2 PLACES
1.275±.005
.25±.01 R
4 PLACES
BOTH SIDES
B
D
B
A
A
D
.06±.01 R
.370±.015
BOTH SIDES
.275±.015
BOTH SIDES
45°±1°
.370±.015
BOTH SIDES
C
.67±.01
.06±.01 R
2 PLACES
.06±.01 R
2 PLACES
.06±.01 R TRUE
2 PLACES
C
2° MAX DRAFT
PERMISSIBLE ON
THIS SURFACE
12 PLACES
.067±.005
2 PLACES
.096±.005
6 PLACES
.050±.008
4 PLACES
.035±.005
10 PLACES
SECTION A-A
1.270 APPROX
OVER KNURL
.38±.01 R TRUE
2 PLACES
.31±.01 R
2 PLACES
WEAPON MFR'S IDENTIFICATION
SYMBOL, .125±.015 HIGH, .010±.005
POSITIVE OR NEGATIVE, IN APPROX
POSITION SHOWN.
.39±.01
.78±.01 TO THEORETICAL
SHARP CORNER
12°±2°
TYP
.25±.01 R
2 PLACES
.261 +.015 Ø THRU
⌖ C D E Ø .010 Ⓜ
-D-
1.48
1.28
.295±.010
.177
60°
-E-
.973±.005
.250±.050
.250±.050
.25±.01
90°
.820±.01
25°±5°
TYP
.11±.01
.04 R
.31±.01 R
2 PLACES
.97
2.73±.01
2.35±.01
.31
.06
.2

J9349127

F-1/2

REV J

DWG. NO. 9349127 SH REV J

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	B
M		C	NOR W9S2009 80-02-13	80-05-16	R
		D	NORW2S2C15 82-08-20	83-02-03	R
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07	83-11-04	
		F	NOR W5S8004/860204	890215	ORFI-BB

B8448659

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0340±.0005
COIL DIAMETER (O.D)	.300 MAX
FREE LENGTH	1.579 REF
TOTAL COILS	15 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .644	7.0 LB ± .7LB
LOAD AT COMPRESSED LENGTH OF .902	5.0 LB ± .5LB
SPRING RATE	7.5 LB/IN REF
SOLID LENGTH	.5175 MAX
TYPE OF ENDS	CLOSED, GROUND

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313
2. PRECIPITATION HEAT TREAT AFTER FORMING, TO CONDTN CH900. HOLD AT 900° F±10° FOR ONE HOUR. AIR COOL.
3.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 +.012

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448659

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		C9381380	M16A2
EL 2			M16
RA		C8448658	M16A1
BH		NEXT ASSY.	USED ON
RH	15N84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO.
DATE 5 JUN 70
PREP P. Vernon
CHK D. Krolek
ENGR R. Elbe L. Bunton
SUBMITTED A. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

SPRING, HELICAL, COMPRESSION

SIZE	CODE IDENT NO.	DRAWING NO
B	19204	8448659

SCALE NONE SHEET 1 OF 1

DUPLICATE ORIGINAL

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

October 15, 2004 11:09 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

NOTES:

1- SPEC: MIL-W-13855 APPLIES.
2- MATERIAL: ALUMINUM ALLOY 7075-T73, SPEC. QQ-A-367 OR ASTM B221.
3- FINISH: 7.5.2 OF MIL-STD-171, FILM THICKNESS .0020 ± .0004. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY. NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL.
4- FINISH $\overset{125}{\surd}$ EXCEPT AS NOTED.
5- ALL DIMENSIONS APPLY BEFORE FINISH.
6- GRIT BLAST BEFORE FINISH, TO PRODUCE NON-REFLECTIVE MATTE SURFACE.
7- BREAK SHARP EDGES .005 + .010 EXCEPT AS NOTED.

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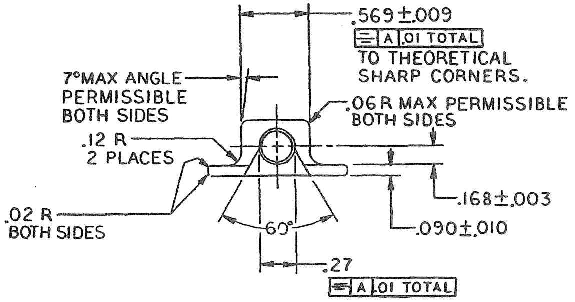
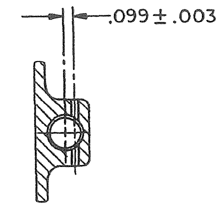
REVISIONS

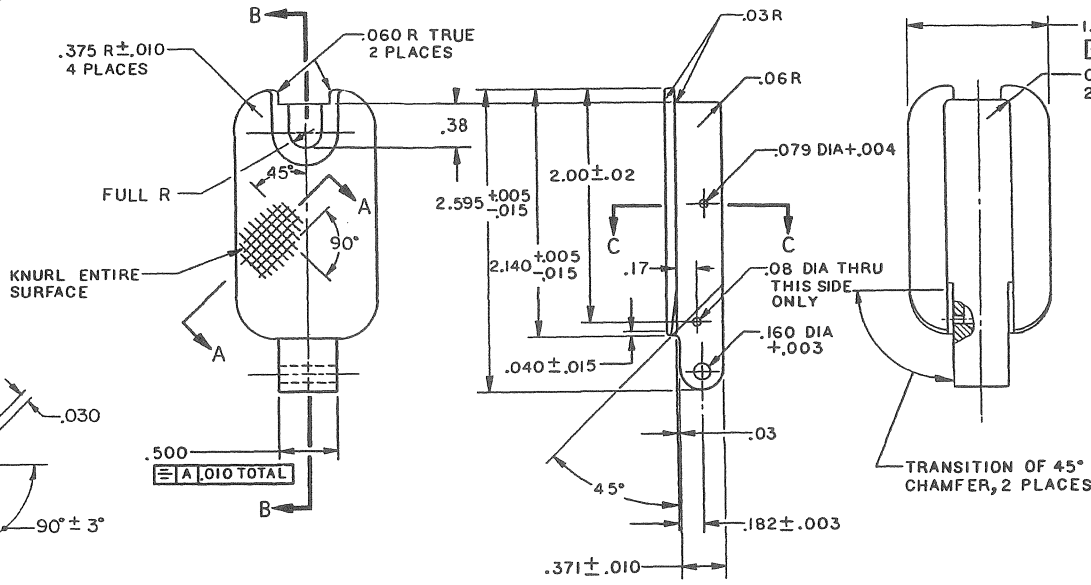
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W3S3149/83-11-14	840210	TT
A	NOR W4S 0030 / 84-11-15	850402	EB
B	NOR W6S0002 860117 (ECP W6S0048 860523)	870204	
C	NOR W5S8004/860204	890215	
D	NOR G6S2008 960328	960523	RLV



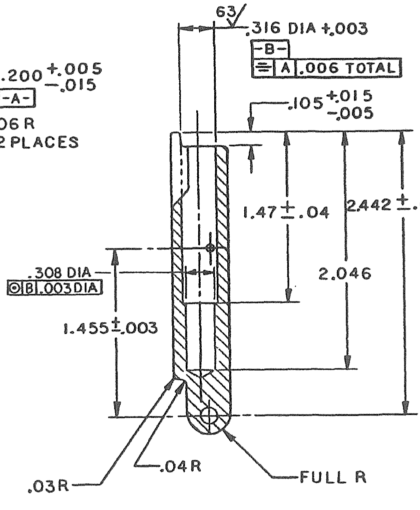
.569 ± .009
⌯ A .01 TOTAL
TO THEORETICAL SHARP CORNERS.
7° MAX ANGLE PERMISSIBLE BOTH SIDES
.06 R MAX PERMISSIBLE BOTH SIDES
.12 R 2 PLACES
.168 ± .003
.02 R BOTH SIDES
60°
.090 ± .010
.27
⌯ A .01 TOTAL



SECTION C-C

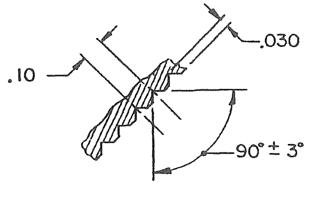


B
.060 R TRUE 2 PLACES
.375 R ± .010 4 PLACES
.38
FULL R
45°
A
90°
KNURL ENTIRE SURFACE
A
.500
⌯ A .010 TOTAL
B
.03 R
.06 R
2.595 +.005 −.015
2.00 ± .02
.079 DIA + .004
C
C
2.140 +.005 −.015
.17
.08 DIA THRU THIS SIDE ONLY
.160 DIA +.003
.040 ± .015
.03
45°
.182 ± .003
.371 ± .010
1.200 +.005 −.015
-A-
.06 R 2 PLACES
TRANSITION OF 45° CHAMFER, 2 PLACES



63
.316 DIA +.003
-B-
⌯ A .006 TOTAL
.105 +.015 −.005
1.47 ± .04
2.442 ± .003
.308 DIA
◎ B .003 DIA
2.046
1.455 ± .003
.03R
.04R
FULL R

SECTION B-B



SECTION A-A

SCALE-NONE

PART NO. 9381379

	M16
	M16A1
9381380	M16A2
NEXT ASSY	USED ON
APPLICATION	

MECHANICAL PROPERTIES	
YP	
TS	
EL2	
RA	
BH	
RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS .000 ± .005 .00 ± .01
FRACTIONS ± ANGLES ± 1°

ORIGINAL DATE OF DRAWING 83-12-21

DRAFTSMAN T.T.	CHECKER
ENGR RJH	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DOOR

SIZE	FSCM NO.	9381379
D	19200	
SCALE 2/1	UNIT WT.	SHEET

ARRADCOM FORM 60 AUG 77 REPLACES SARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:09 AM

5 | 4 | 3 | 2 | 1

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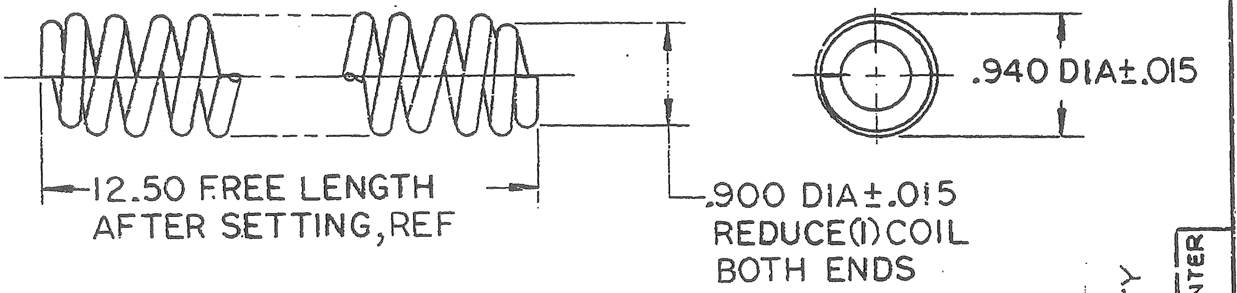
C	NOR W2S 0011 (ECP W2S 0034 (ECP W3S 3120	82-04-13 82-07-15 83-07-07	83JUL04	

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C 61581 REV A	27 APR 70	
M		A	(1) SEE EO HRD 02197-3	15 JULY 70	
M	-	B	(4) SEE ERR HQR 20778	6 OCT 72	

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH 900. HOLD AT 900°F±10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES. Ⓑ
4. BREAK SHARP EDGES .003+.012.



12.50 FREE LENGTH AFTER SETTING, REF
.900 DIA±.015 REDUCE (1) COIL BOTH ENDS
.940 DIA±.015

SPRING DATA
WIRE DIA: .072±.001
TOTAL COILS: 44 REF
DIRECTION OF HELIX: OPTIONAL
LOAD AT COMPRESSED LG OF 4.415 IN MIN OPERATING
LENGTH = 10.9 LBS ±1.0 LBS
LOAD AT COMPRESSED LG OF 8.190 MEAN ASSEMBLED
LENGTH = 5.8 LBS±.5 LBS
SOLID LENGTH: 3.285 MAX
TYPE OF ENDS: CLOSED, REDUCED AND SQUARED

Ⓑ MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

CURRENT DESIGN ACTIVITY
FSCM No. 19200.
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

Ⓑ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.10F MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970

PREP		
CHK		
ENGR		D. Billiet
SUBMITTED	F. P. Wellworthy	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, ACTION

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448629

SCALE NONE | SHEET | OF

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:10 AM

(ARRADCOMR 70-12)

NOTE:
1-SPEC MIL-W-13855 APPLIES
2-MATERIAL:-STEEL BAR, CARBON GRADE 1117 COLD FINISHED PER ASTM A108.
ALTERNATIVE MATERIAL: STEEL AISI 1018.
3-CARBURIZE(TOTAL CASE DEPTH .006 TO .011) HARDEN AND TEMPER. HARDNESS TO BE FILE HARD.
4-FINISH:-125/√ EXCEPT AS NOTED.
5-PROTECTIVE FINISH:-5.3.1.3 OR 5.3.2.3 PLUS 30.7 OF MIL-STD-171.

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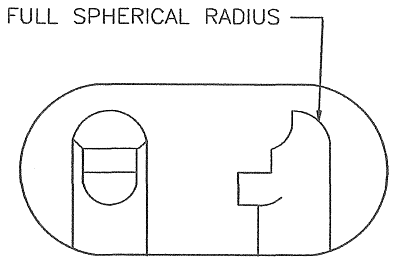
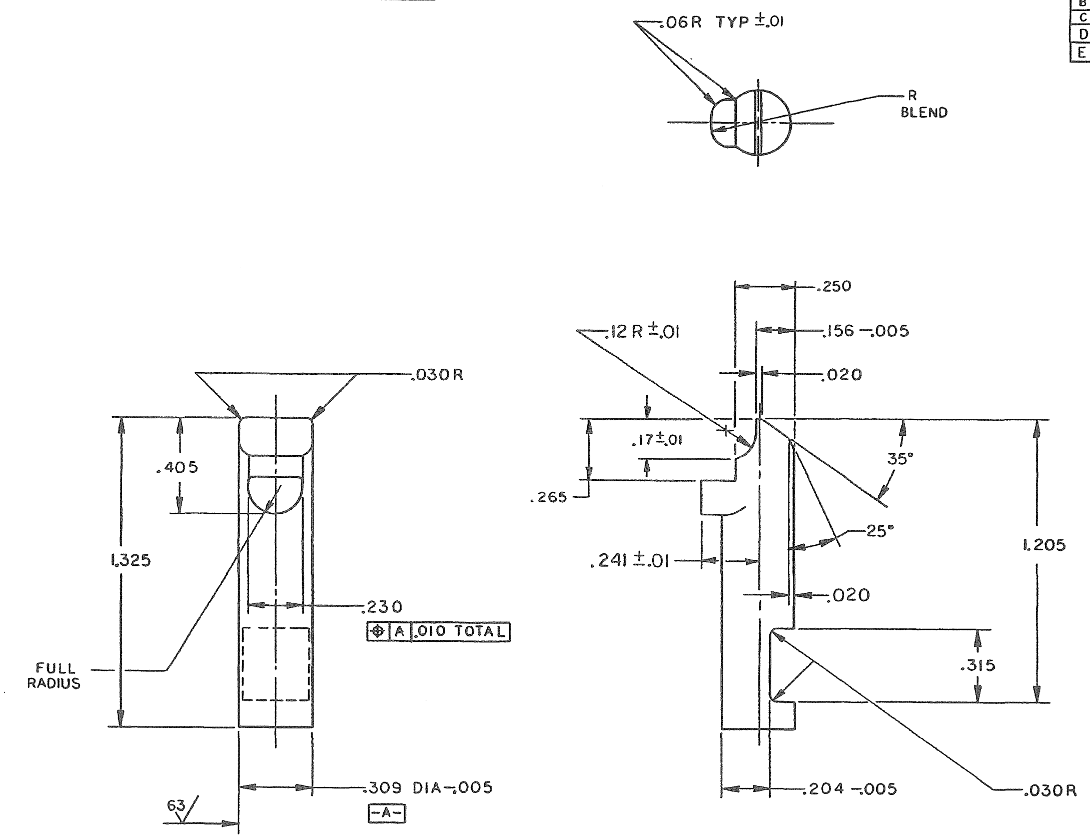
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W3S3149/83-11-14	F9OCL86	TT
A	NOR W4S3013/84-06-01	840913	
B	NOR W4S0030/84-11-15	850402	
C	NORW6S3004/86-02-24	870218	
D	NOR W5S8004/860204	890215	ORFI-BB
E	NOR L7S3006/970224	970321	DR



ALTERNATE CONFIGURATION



PART NO. 9381378

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
	M16	RA	
	M16A1	BH	
9381380	M16A2		
NEXT ASSY	USED ON	BH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±.005
FRACTIONS ± ANGLES ± 2°

ORIGINAL DATE OF DRAWING 83-12-21
DRAFTSMAN T.T. CHECKER
ENGR AJH ENGR
ENGR ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PLUNGER

SIZE D FSCM NO. 19200 9381378
SCALE 4/1 UNIT WT. SHEET

ARRADCOM FORM 60 AUG 77 REPLACES SARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:08 AM

DRAWING SIZE C
(ARRADCOMR 70-12)

NOTES:
1-SPEC MIL-W-13855 APPLIES.

PROPRIETARY INFORMATION

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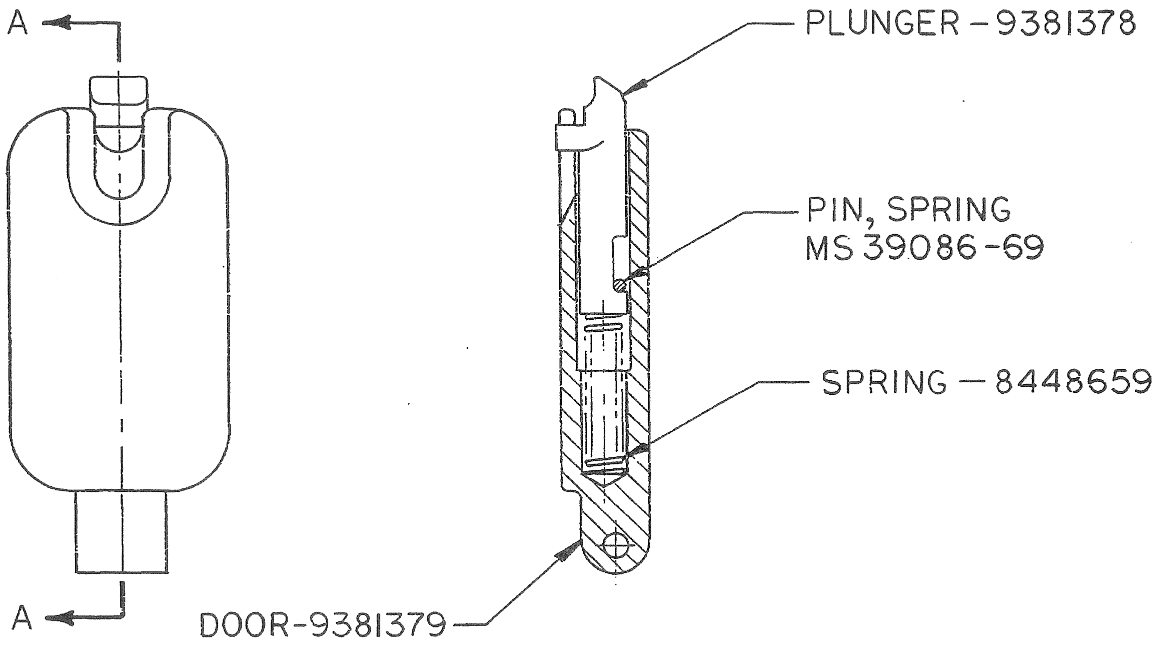
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W3S3149/83-11-14	84 02 10	—
A	NOR W5S8004/860204	890215	



SECTION A-A

SEE SEPARATE PARTS LIST-9381380

PART NO. 9381380

	M16, M16A1
9349119	M16A2
NEXT ASSY	USED ON
APPLICATION	

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 84-02-02
DRAFTSMAN
CHECKER
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DOOR ASSEMBLY,
THUMB LATCH

SIZE C
FSCM NO. 19200
9381380
SCALE 2/1
UNIT WT.
SHEET

ARRADCOM FORM 87 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:04 AM

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NOTES:—

1— SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2— MATERIAL :—
  A. PLASTIC COMPOUND PER 9349122.
  B. PLASTIC PER MIL-P-21929, CLASS 2, USING POLYETHER COMPOUND WITH PAPI CATALYST. THE STOCK CAVITY SHALL BE ROUGHENED FOR FOAMING BY SANDING, WIRE BRUSHING OR GRIT BLASTING. THE CAVITY SHALL THEN BE CLEANED AND PRIMED WITH A MIXTURE OF EQUAL VOLUMES OF PRIMER PER ASTM-D-4701 THE PRIMER CAN BE USED AS IS FOR BRUSH OR SWAB APPLICATION, OR DILUTED TO DESIRED VISCOSITY FOR SPRAY APPLICATION WITH SOLVENT PER 9349125. THE PRIMER SHOULD DRY FOR AT LEAST ONE (1) MINUTE AT ROOM TEMPERATURE BEFORE APPLICATION OF FOAM. THE STOCK CAVITY SHALL BE COMPLETELY FILLED WITH PLASTIC AS SHOWN AND BE PROVIDED WITH A CAVITY HAVING A HARD, SMOOTH SURFACE OF .03 MINIMUM THICKNESS. THIS THICKNESS SHALL INCLUDE THE ENTIRE DENSITY GRADIENT BETWEEN MASS AND HARD SURFACE. THERE SHALL BE NO BLOW HOLES EITHER IN THE SKIN ITSELF OR ADJACENT TO THE SKIN.

3— BREAK EDGES .02 MAX EXCEPT AS NOTED.

4— FILLET RADII .03 MAX EXCEPT AS NOTED.

5— DIMENSIONS APPLY AT INTERSECTION OF STRAIGHT LINES.

6— WITHIN DIMENSIONAL REQUIREMENTS ALL CHANGING SECTIONS SHALL BE SMOOTHLY BLENDED.

7— SURFACES UNIFORMLY REDUCED TO BLEND INTO AREA -F-.

8— SURFACES UNIFORMLY INCREASE IN AREA -F- FROM -G-.

9— REMOVE ALL FLASH.

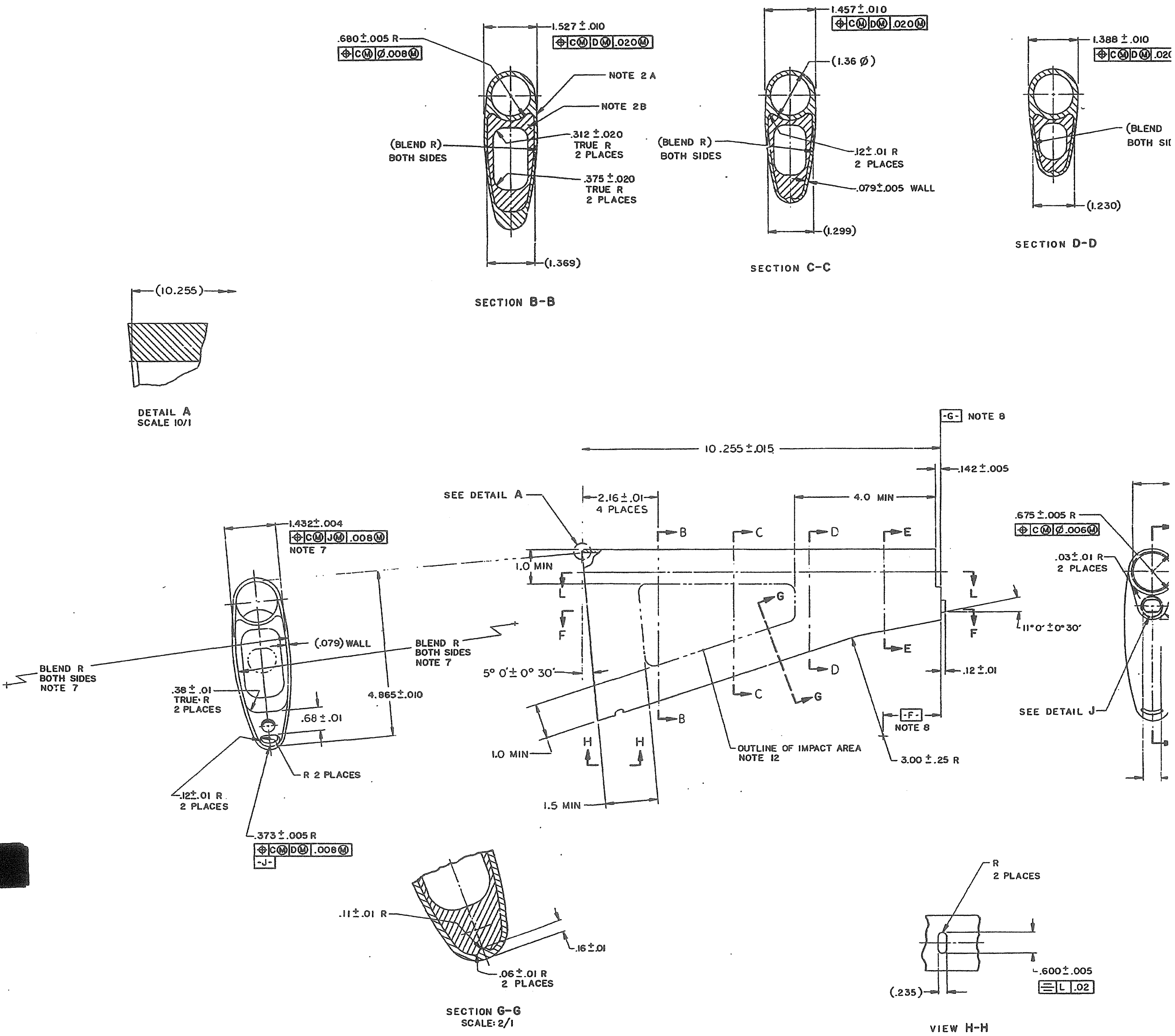
10— NO CRACKS PERMISSIBLE ON HARD MOLDED SHELL.

11— IRREGULARITIES PERMISSIBLE ON EXTERIOR SURFACES, NOT TO EXCEED .156 Ø, .010 HIGH OR BE WITHIN 1.00 MIN OF EACH OTHER.

12— THE MOLDED SHELL SHALL BE CAPABLE OF WITHSTANDING AN IMPACT OF 5 IN-LB WITHOUT VISIBLE EVIDENCE OF FAILURE, SUCH AS CRACKING OR CHIPPING. THE IMPACTING MASS SHALL BE STEEL, AND SHALL HAVE A SPHERICAL RADIUS OF .125 ± .010 INCHES ON THE STRIKING SURFACE. THE SHELL SHALL BE SUPPORTED (SEE NOTE IN ZONE C-6) SO THAT THE IMPACT BLOW WILL BE GRAVITY ACCELERATED AND STRIKE PERPENDICULAR TO THE INDICATED AREA ON THE SHELL (SEE NOTE IN ZONE C-9).

13— FINISH ON ALL EXTERIOR SURFACES SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595.

14— FINISH $\sqrt[125]{}$ ALL SURFACES EXCEPT AS NOTED.

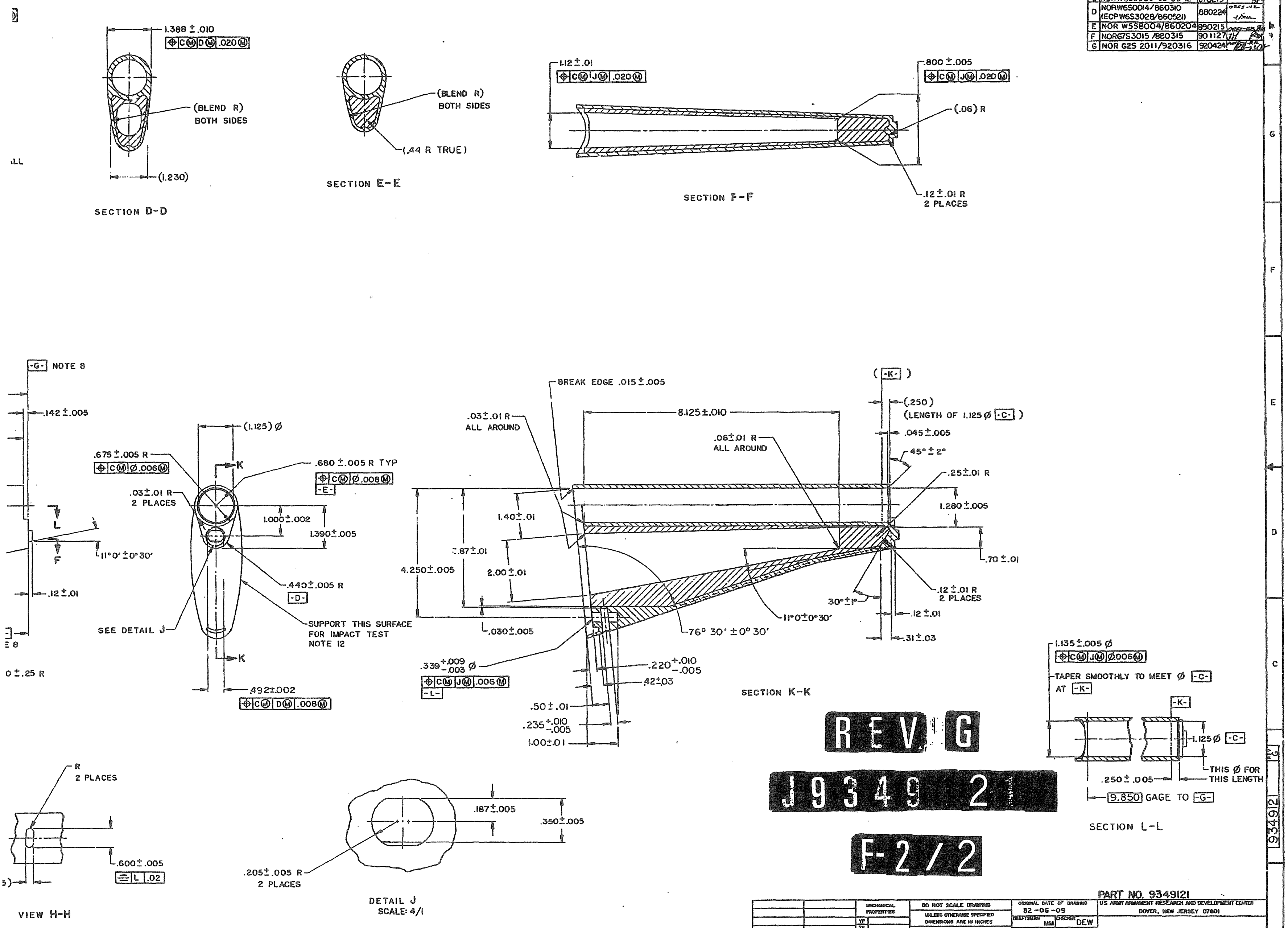


.680 ± .005 R
⊕ C Ⓜ Ø .008 Ⓜ
1.527 ± .010
⊕ C Ⓜ D Ⓜ .020 Ⓜ
NOTE 2 A
NOTE 2B
(BLEND R) BOTH SIDES
.312 ± .020 TRUE R 2 PLACES
.375 ± .020 TRUE R 2 PLACES
(1.369)
SECTION B-B
1.457 ± .010
⊕ C Ⓜ D Ⓜ .020 Ⓜ
(1.36 Ø)
(BLEND R) BOTH SIDES
.12 ± .01 R 2 PLACES
.079 ± .005 WALL
(1.299)
SECTION C-C
1.388 ± .010
⊕ C Ⓜ D Ⓜ .02
(BLEND BOTH SI
(1.230)
SECTION D-D
(10.255)
DETAIL A SCALE 10/1
-G- NOTE 8
10.255 ± .015
.142 ± .005
SEE DETAIL A
2.16 ± .01 4 PLACES
4.0 MIN
B
C
D
E
1.0 MIN
L
F
G
BLEND R BOTH SIDES NOTE 7
5° 0' ± 0° 30'
11° 0' ± 0° 30'
.12 ± .01
1.0 MIN
H
1.5 MIN
OUTLINE OF IMPACT AREA NOTE 12
-F- NOTE 8
3.00 ± .25 R
.675 ± .005 R
⊕ C Ⓜ Ø .006 Ⓜ
.03 ± .01 R 2 PLACES
SEE DETAIL J
1.432 ± .004
⊕ C Ⓜ J Ⓜ .008 Ⓜ
NOTE 7
(.079) WALL
BLEND R BOTH SIDES NOTE 7
.38 ± .01 TRUE R 2 PLACES
4.865 ± .010
.68 ± .01
R 2 PLACES
.12 ± .01 R 2 PLACES
.373 ± .005 R
⊕ C Ⓜ D Ⓜ .008 Ⓜ
-J-
.11 ± .01 R
.16 ± .01
.06 ± .01 R 2 PLACES
SECTION G-G SCALE: 2/1
R 2 PLACES
.600 ± .005
⌯ L .02
(.235)
VIEW H-H

J9349121
REV G
F-1/2

DWG NO 9349121 SH REV G

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S0030/84-11-15	850402	
B	NORW5S0127 851106	871107	
C	NORW6S3006/86-03-12	870219	
D	NORW6S0014/860310 (ECPW6S3028/860521)	880224	
E	NOR W5S8004/860204	890215	
F	NORG7S3015 /880315	901127	JH
G	NOR G2S 2011/920316	920424	



1.388 ± .010
⊕ C Ⓜ D Ⓜ .020 Ⓜ
(BLEND R) BOTH SIDES
(1.230)
SECTION D-D
(BLEND R) BOTH SIDES
(.44 R TRUE)
SECTION E-E
1.12 ± .01
⊕ C Ⓜ J Ⓜ .020 Ⓜ
.800 ± .005
⊕ C Ⓜ J Ⓜ .020 Ⓜ
(.06) R
.12 ± .01 R 2 PLACES
SECTION F-F
-G- NOTE 8
.142 ± .005
L
F
11°0' ± 0°30'
.12 ± .01
0 ± .25 R
(1.125) Ø
.675 ± .005 R
⊕ C Ⓜ Ø.006 Ⓜ
.680 ± .005 R TYP
⊕ C Ⓜ Ø.008 Ⓜ
-E-
K
.03 ± .01 R 2 PLACES
1.000 ± .002
1.390 ± .005
.440 ± .005 R
-D-
SEE DETAIL J
SUPPORT THIS SURFACE FOR IMPACT TEST NOTE 12
K
.492 ± .002
⊕ C Ⓜ D Ⓜ .008 Ⓜ
BREAK EDGE .015 ± .005
.03 ± .01 R ALL AROUND
8.125 ± .010
.06 ± .01 R ALL AROUND
(-K-)
(.250)
(LENGTH OF 1.125 Ø -C-)
.045 ± .005
45° ± 2°
.25 ± .01 R
1.280 ± .005
1.40 ± .01
2.87 ± .01
4.250 ± .005
2.00 ± .01
.70 ± .01
.12 ± .01 R 2 PLACES
30° ± 1°
11°0' ± 0°30'
.12 ± .01
.030 ± .005
76° 30' ± 0° 30'
.31 ± .03
.339 +.009 -.003 Ø
⊕ C Ⓜ J Ⓜ .006 Ⓜ
-L-
.220 +.010 -.005
.42 ± .03
.50 ± .01
.235 +.010 -.005
1.00 ± .01
SECTION K-K
1.135 ± .005 Ø
⊕ C Ⓜ J Ⓜ Ø.006 Ⓜ
TAPER SMOOTHLY TO MEET Ø -C- AT -K-
-K-
1.125 Ø -C-
THIS Ø FOR THIS LENGTH
.250 ± .005
9.850 GAGE TO -G-
SECTION L-L
R 2 PLACES
.600 ± .005
⌯ L .02
VIEW H-H
.187 ± .005
.350 ± .005
.205 ± .005 R 2 PLACES
DETAIL J SCALE: 4/1

REV G

J9349 2

F-2/2

DISTRIBUTION STATEMENT F
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR
OR HIGHER DoD AUTHORITY 91-10-25

PART NO. 9349121

	M16 M16A1 M16A2	MECHANICAL PROPERTIES	YP TS EL2 RA BH RH
9349119			
NEXT ASSY	USED ON		
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN MM
CHECKER DEW
ENGR
ENGR
ENGR
ENGR

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

BUTTSTOCK

SIZE J
FSCM NO 19200
9349121
SCALE 1/1
UNIT WT.
SHEET 1 OF 1

9349121 G

2-FK.

October 15, 2004 11:06 AM

PARTS LIST PL-8448612 ROCK ISLAND ARSENAL REV. DATE 16 APR 76
DOCUMENT/PART NUMBER C 8448612 ROCK ISLAND IL REVISION LETTER B
HAMMER AND HAMMER PIN RETAINER ASSY CODE ID 19204 SHEET 1
CHANGE CONTROL NUMBER 76V0018 AUTHENTICATION- Loren Brunton ORIG. DATE

FND NO.	QTY REQ	UNIT MEAS	CODE ID	PART OR IDENTIFYING NO	DRAWING/DOCUMENT SZE	NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP LST
	1			8448613	F	8448613	HAMMER	
	1			8448614	B	8448614	RETAINER,HAMMER PIN	

TOTAL NUMBER OF SHEETS 1

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

October 15, 2004 11:36 AM

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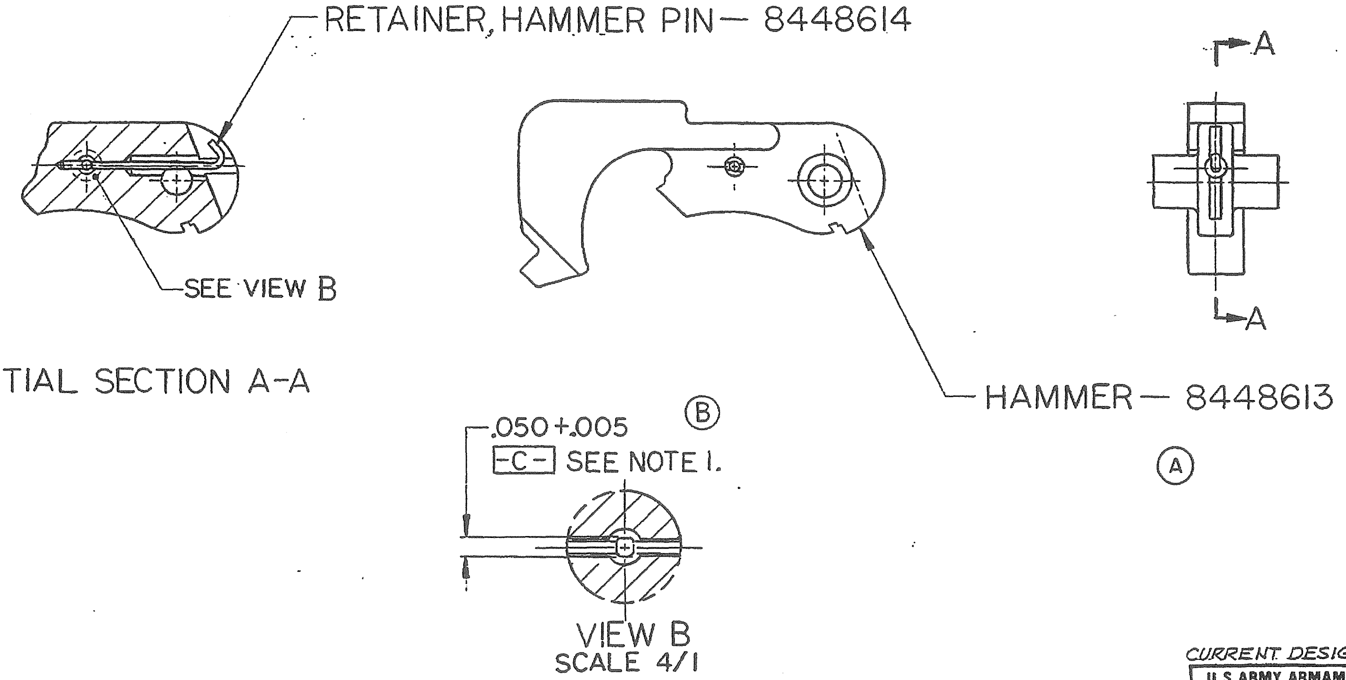
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C62317 REV A	27 APR 70	
		A	(2) SEE EO HQR-10651	20 FEB 71	
		B	(2) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NORW250026 82-05-21	83-02-03	

NOTES:

1. COIN BOTH SIDES OF RETAINER, 8448614 TO -C-. AFTER COINING, RETAINER SHALL HAVE .010 MIN LONGITUDINAL MOVEMENT. Ⓑ
2. MIL-W-13855 APPLIES. Ⓐ



SEE PL — 8448612

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		
YS MIN		
YS MAX		
EL 2		
RA		
BH		M16
RH	B8448610	M16A1
	NEXT ASSY	USED ON
	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970

PREPARED	GEW	A. J. St.
CHECKED	DHH	V. Gulham
ENGINEER	S. Smit	B. Billiet
SUBMITTED	T. P. Gilhooly	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HAMMER AND HAMMER PIN RETAINER ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448612

SCALE 2/1 SHEET OF

C8448612

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:36 AM

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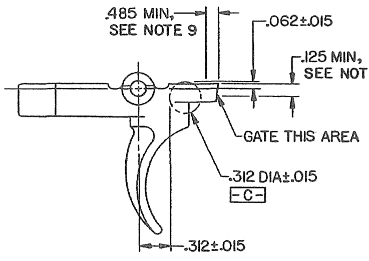
NOTES:

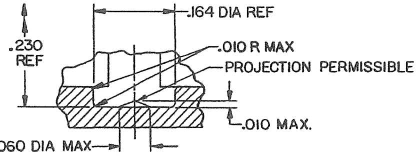
1. STEEL, INVESTMENT CASTING, CMPSN IC 8620, SPEC MIL-S-22141, EXCEPT THAT MANGANESE CONTENT SHALL BE .70 TO 1.20%. Ⓒ
2. ALL DIMENSIONS ARE BEFORE FINAL PROTECTIVE FINISH EXCEPT THOSE IDENTIFIED BY NOTE 9.
3. FILLET, EDGE AND CORNER RADII .031, UNLESS OTHERWISE SPECIFIED.
4. EJECTOR PIN MARK .005 NEGATIVE ONLY.
5. CASTING SHALL MEET FOUNDARY PRACTICE CLASS 3, GRADE A OF MIL-STD-2175; CLASS 3, GRADE D PERMISSIBLE IN AREA -C-.
6. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014 TO .018. HARDEN AND TEMPER.
7. .007 MIN CASE DEPTH REQUIRED IF SURFACE IS MACHINED AFTER HEAT TREATMENT.
8. .005 MIN CASE DEPTH REQUIRED IF SURFACE IS MACHINED AFTER HEAT TREATMENT.
9. NO FINAL PROTECTIVE FINISH IN THIS AREA. COAT WITH LUBRICATING OIL PER MIL-L-3150.
10. FINISH $\sqrt{125}$ EXCEPT AS NOTED. Ⓒ
11. BREAK ALL EDGES PRODUCED BY MACHINING .010 MAX, UNLESS OTHERWISE SPECIFIED.
12. MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV (A) W/CHANGE SEE EO HRD 02275	15 OCT 70	
		C	(4) SEE ERR HQR 20778	6 OCT 72	R.E.
		D	SEE ERR HQR 50611	19 FEB 75	
		E	SEE ERR HQR 50619	6 MAR 75	
		F	NOR W9S2009 80-02-13	80-05-16	
		G	NORW1S2506 81-10-29	81-11-10	
		H	NORW5S2004 / 85-02-08	850510	
		J	NORW5S2099/ 85-11-21	860708	
		K	NOR G1S3050/ 910425	910528	VJ51
		L	G2S3031 /92-04-08	920507	CF



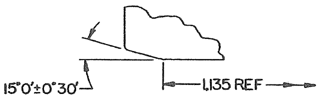
.485 MIN, SEE NOTE 9
.062±.015
.125 MIN, SEE NOTE 9
GATE THIS AREA
.312 DIA±.015
-C-
.312±.015

VIEW F-F



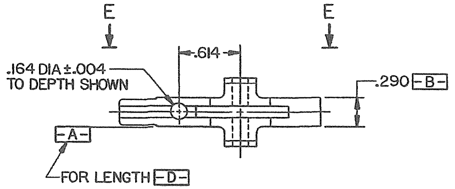
.164 DIA REF
.230 REF
.010 R MAX
PROJECTION PERMISSIBLE
.010 MAX.
.060 DIA MAX

VIEW C
SCALE 10/1

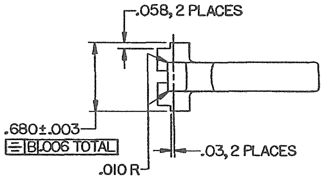


15°0'±0°30'
1.135 REF

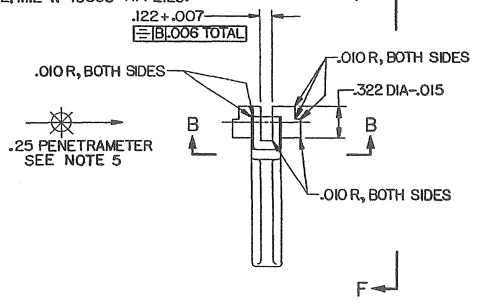
VIEW D
SCALE 10/1
ALTERNATIVE DESIGN



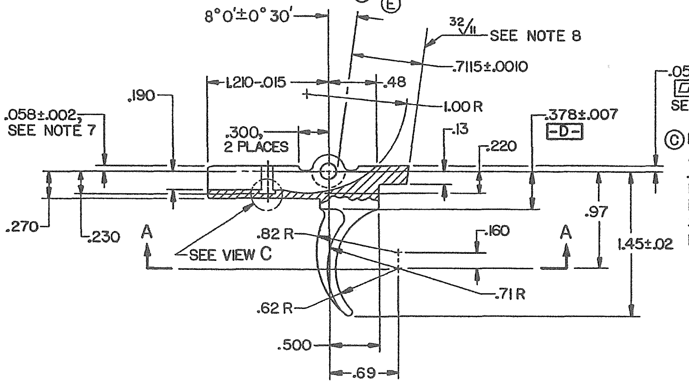
E
E
.614
.164 DIA±.004 TO DEPTH SHOWN
.290 -B-
-A-
FOR LENGTH -D-



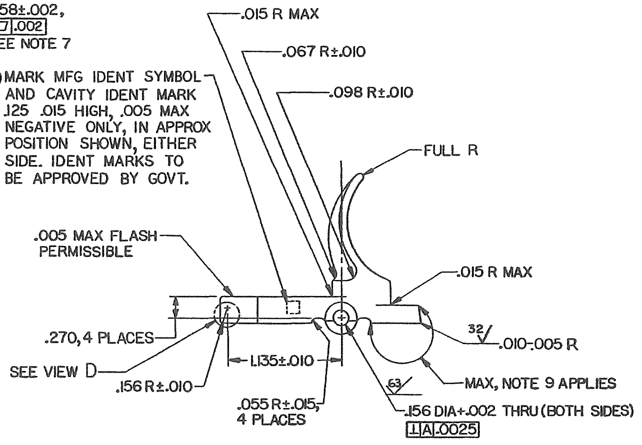
.058, 2 PLACES
.680±.003
⊟ B .006 TOTAL
.010 R
.03, 2 PLACES



F
.122+.007
⊟ B .006 TOTAL
.010 R, BOTH SIDES
.010 R, BOTH SIDES
.322 DIA-.015
B
B
.25 PENETRAMETER SEE NOTE 5
.010 R, BOTH SIDES
F

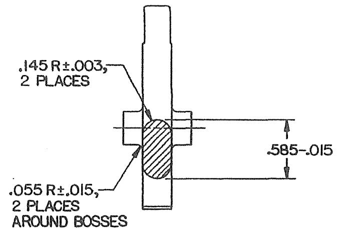


Ⓓ
Ⓔ
8°0'±0°30'
32/11 SEE NOTE 8
.7115±.0010
1.210-.015
.48
.190
1.00 R
.058±.002, SEE NOTE 7
.300, 2 PLACES
.13
.220
.378±.007
-D-
.058±.002, ▱ .002 SEE NOTE 7
.270
.230
A
SEE VIEW C
.82 R
.160
A
.97
1.45±.02
.71 R
.62 R
.500
.69
Ⓒ MARK MFG IDENT SYMBOL AND CAVITY IDENT MARK .125 .015 HIGH, .005 MAX NEGATIVE ONLY, IN APPROX POSITION SHOWN, EITHER SIDE. IDENT MARKS TO BE APPROVED BY GOVT.



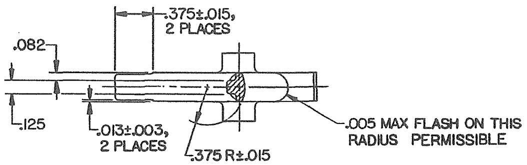
.015 R MAX
.067 R±.010
.098 R±.010
FULL R
.005 MAX FLASH PERMISSIBLE
.015 R MAX
.270, 4 PLACES
32/ .010-.005 R
SEE VIEW D
1.135±.010
.156 R±.010
63/
MAX, NOTE 9 APPLIES
.055 R±.015, 4 PLACES
.156 DIA+.002 THRU (BOTH SIDES)
⊥ A .0025

VIEW E-E



.145 R±.003, 2 PLACES
.585-.015
.055 R±.015, 2 PLACES AROUND BOSSES

SECTION B-B



.375±.015, 2 PLACES
.082
.125
.013±.003, 2 PLACES
.375 R±.015
.005 MAX FLASH ON THIS RADIUS PERMISSIBLE

SECTION A-A

DISTRIBUTION STATEMENT F
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR,SMCAR-ESW-S
ROCK ISLAND, IL.61299,OR HIGHER DOD AUTHORITY. 92-03-19.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			M16
BH	15N 89.5—91	8448591	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

Ⓒ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°0'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 70
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

TRIGGER

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448592

SCALE 2/1 SHEET 1 OF 1

F 8448592

October 15, 2004 11:36 AM

G	NOR G1S2018 910708	91-10-11	RR SN

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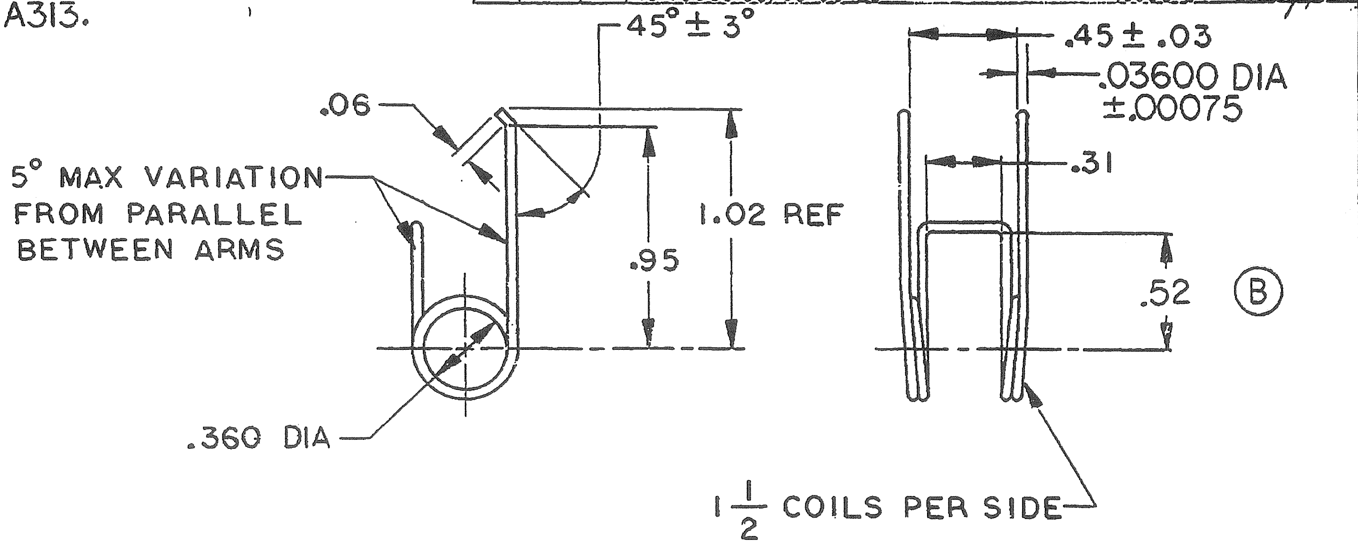
REVISIONS

ME	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61657 REVISION B	27APR 70	
M		A	(1) SEE EO HRD 02197-3	15JULY 70	
		B	(3) SEE EO HQR 10639	20 FEB 71	
		C	(2) SEE ERR HQR 20778	6 OCT 72	
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W2S0011 / 82-04-13 (ECP W2S0034 / 82-07-15)	83-11-04	HW
		F	NOR G0S3100/90.06.28	900815	

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH-900. HOLD AT 900°F ±10° FOR 1 HOUR. AIR COOL.
3. TORQUE REQUIREMENT: 1.5±.27 LB IN. TORQUE AT 45° DEFLECTION
4. FINISH 5.4.1 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.



CURRENT

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	FSCM NO. 19200

MECHANICAL PROPERTIES			
YS MIN		9390011	M4
YS MAX		9349115	M16A2
EL 2		F 9327230	M231
RA			M16
BH		B8448591	M16A1
RH	15N 84.5 MIN	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

~~CONTRACT NO:~~
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, TRIGGER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448593

SCALE 2/1 SHEET 1 OF 1

CD1

B8448593

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:35 AM

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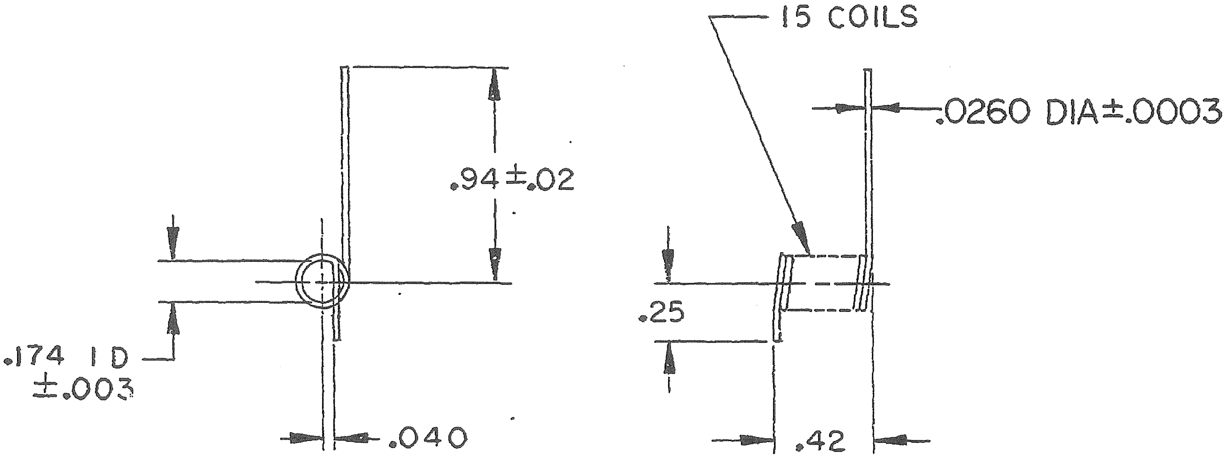
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61616 REVISION B	27 APR 70	
M		A	(1) SEE EO HRD 02197-3	15 JULY 70	
M	-	B	(3) SEE ERR HQR 20778	6 OCT 72	
		~~C~~	~~NOR W250011 / 82-04-13~~ ~~(ECP W250034 / 82-07-15)~~	83-11-04	
		D	NOR GIS2018 91 07 08	91-10-11	RB SR

B8448598

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH-900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
3. 15° MAX VARIATION PERMISSIBLE FROM 180° SPECIFIED RELATIVE TO OPPOSING ARMS.
4. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 84.5 MIN

NEXT ASSY	USED ON
8448595	M4
	M16
B8448595	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970

PREP	RGA	a. J. St.
CHK		H. Lyndham
ENGR	D. Smart	D. Elliot

SUBMITTED F. P. McGillicuddy

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, AUTOMATIC SEAR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448598

SCALE 2/1 SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:35 AM

NOTES:

1-SPEC MIL-W-13855, ANSI Y14.5M-82 AND DOD-STD-100 APPLY.

2-MATERIAL: STEEL, ALLOY, ANNEALED, GRADE 4130, ASTM A505, A506, OR A507. STOCK THICKNESS .093±.002.

3-HEAT TREATMENT: CARBURIZE TO .003-.006 CASE DEPTH TOTAL. HARDNESS: DPH 642-700.

4-ALL DIMENSIONS ARE BEFORE PROTECTIVE FINISH.

5-PROTECTIVE FINISH: 5.3.1.2 OF MIL-STD-171.

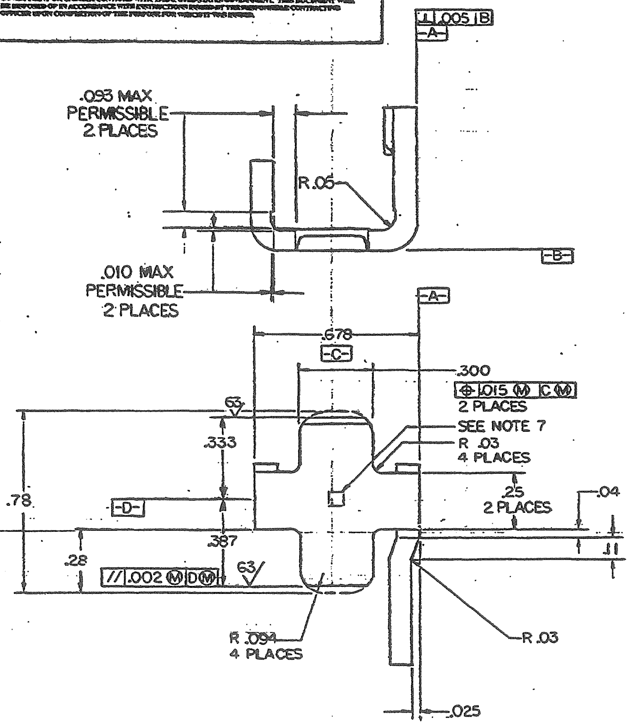
6-UNLESS OTHERWISE SPECIFIED, FINISH ON ROLLED SURFACES 63√, ON SHEARED SURFACES 125√.

7-MARK MFG IDENT SYMBOL, .062±.015 HIGH, .005 MAX DEPTH, APPROX POSITION SHOWN EITHER SIDE.

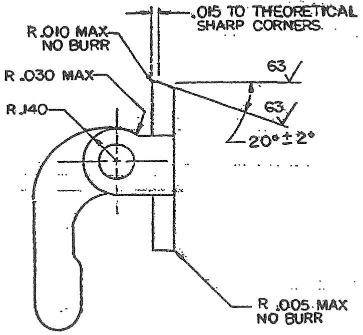
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

[illegible]

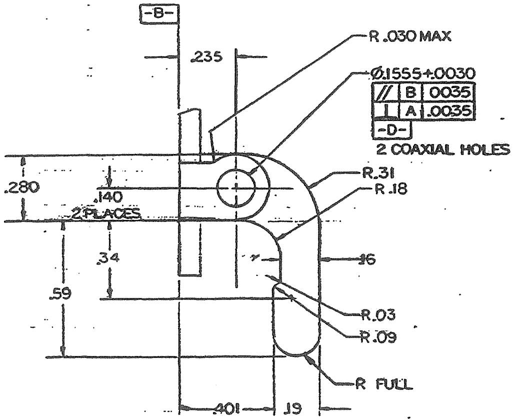
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	F	REDRAWN WITH CHANGE NOR G1S3093 910805 (ECP G1S3148 911021) (ECP G1S3176 911220)	920204	
	G	NOR G2S3044/920526	920625	
	H	NOR G3S3062 930715	930915	



⊥ .005 B
-A-
.093 MAX PERMISSIBLE 2 PLACES
R.05
-B-
.010 MAX PERMISSIBLE 2 PLACES
-A-
.678
-C-
.300
⊕ .015 Ⓜ C Ⓜ
2 PLACES
SEE NOTE 7
R .03 4 PLACES
63
.333
.78
-D-
.387
.28
// .002 Ⓜ D Ⓜ
63
.25 2 PLACES
.04
.11
R .094 4 PLACES
R .03
.025



.015 TO THEORETICAL SHARP CORNERS
R .010 MAX NO BURR
R .030 MAX
R .140
63
63
20° ± 2°
R .005 MAX NO BURR



-B-
R .030 MAX
.235
Ø.1555±.0030
// B .0035
⊥ A .0035
-D-
2 COAXIAL HOLES
.280
.140 2 PLACES
R.31
R.18
.34
.16
.59
R.03
R.09
R FULL
.401
.19

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448596

PMIC			DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL FRACTION 2 PL ±.01 ± 3 PL ±.005	CONTRACT NUMBER CONTRACTOR
MECHANICAL PROPERTIES				DRAWN BY PAR. DMBL. DATE (YR-MO-DA) 27 APR 1970
YP			THIRD ANGLE PROJECTION	CHECKER AJ ST H. LEEDHAM ENGINEER D. SMAKI D. BILLIST
TS		M4		DRAWING APPROVAL F.P. FILHOOLY
ELZ		M16		
RA	8448595	M16A1		
BN	NEXT ASSY	USED ON	MATL ENGR	DESIGN APPROVAL R.S HENRY
RN	APPLICATION			

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SEAR, AUTOMATIC

SIZE	CAGE CODE	
D	19204	8448596
SCALE 4/1	UNIT WT.	SHEET 1 1

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY DoD CONTROLLING OFFICE: ASQNC-ARE-CT OR HIGHER DoD AUTHORITY; DETERMINATION MADE: 91-10-25.

October 15, 2004 11:34 AM

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
REVISIONS					
		E	NOR G5S3110 / 951120	951221	FET

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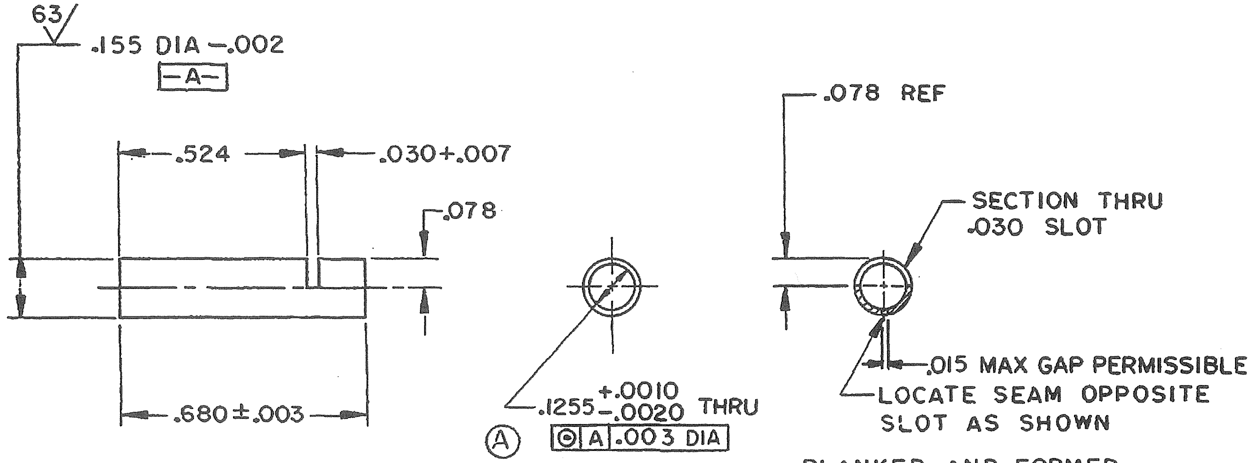
NOTE:

1. STEEL, CORROSION RESISTING, FREE MACHINING, TYPE 303, ASTM A484.
2. FINISH 125/ EXCEPT AS NOTED.
3. BREAK ALL SHARP EDGES .005 R MAX.
4. MIL-W-13855 APPLIES.



BLANKED AND FORMED
— ALTERNATE METHOD —

MATERIAL REQUIRED:

STAINLESS STEEL, AISI TYPE 304, STRIP ANNEALED (.014 THICK REF)

C8448597

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-ARI OR HIGHER DOD AUTHORITY; DATE OF DETERMINATION:

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL2			
RA		8448595	M4
BH			M16
RH		B8448595	M16A1
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ±

MATERIAL
SEE NOTE 1.

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970

PREPARED	KGA	
CHECKED	A. J. St.	
ENGINEER		D. Billet

SUBMITTED

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BUSHING, AUTOMATIC SEAR

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448597

SCALE 4/1 SHEET 1 OF 1

AMSWE Form 403C, 29 Jul 69

CDI

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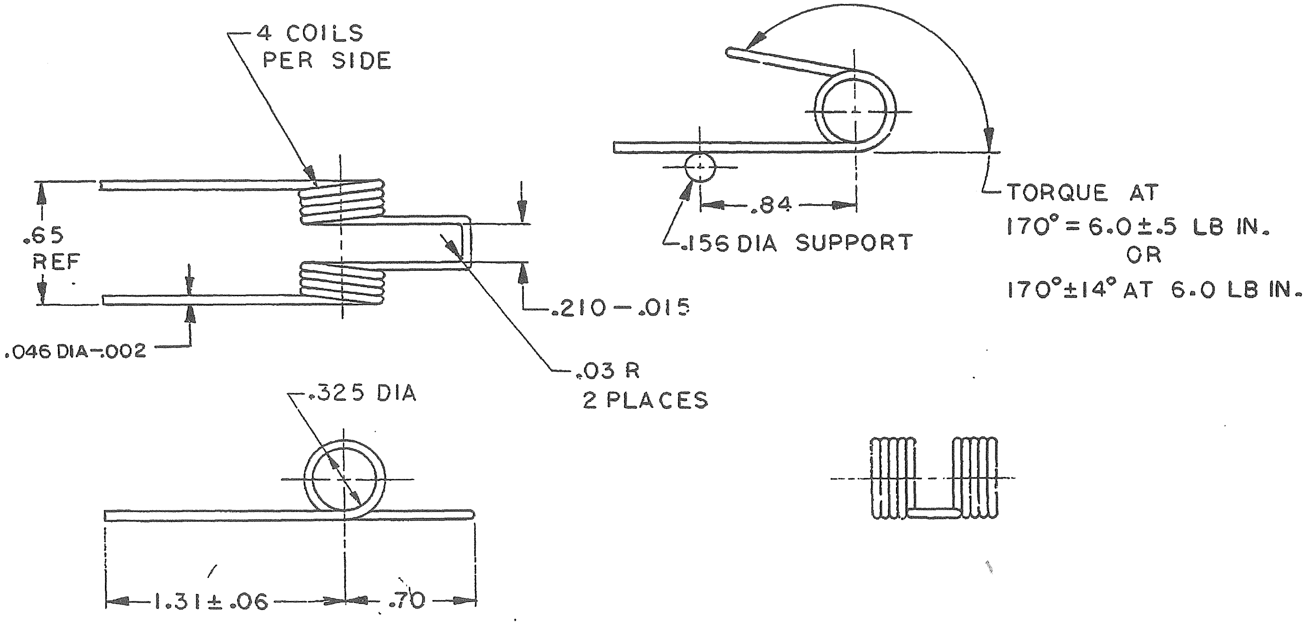
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61697 REVISION A	27APR70	
		A	(1) SEE EO HRD 02197-3	15 JULY 70	
		B	SEE ERR HQR 20600	26 JAN 72	
		C	(3) SEE ERR HQR 20778	6 OCT 72	
		D	NOR W2S0011 /82-04-13 (ECP W2S0034 / 82-07-15	83-11-04	
		E	NOR W2S0010/820413	830601	01 F1

NOTES:

1. WIRE, CORROSION RESISTING, COLD DRAWN, SPEC ASTM A313, TYPE 631, ASTM A555, WIRE DIA .046 - .002.
2. PRECIPITATION HEAT TREAT AFTER FORMING. HOLD AT 900° F ± 10° FOR 1 HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.



C8448611

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES. ANGLES ± —— 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01	CONTRACT NO.	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201
YS MIN				DATE 27 APR 1970	SPRING, HAMMER
YS MAX			MATERIAL SEE NOTE 1	PREPARED	
EL 2				CHECKED	
RA				ENGINEER B. Billiet	
BH		M16		SUBMITTED F. P. Gillooly	SIZE C · CODE IDENT NO 19204 · DRAWING NO. 8448611
RH	15N 84.5 MIN	B8448610	M16A1	FINAL PROTECTIVE FINISH 5.4.1 OF MIL-STD-171	APPROVED R. S. Kenny	SCALE 2 / 1 · SHEET 1 OF 1
		NEXT ASSY	USED ON			
		APPLICATION				

AMSWE Form 403C, 29 Jul 69

CD1

October 15, 2004 11:33 AM

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D	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL SR

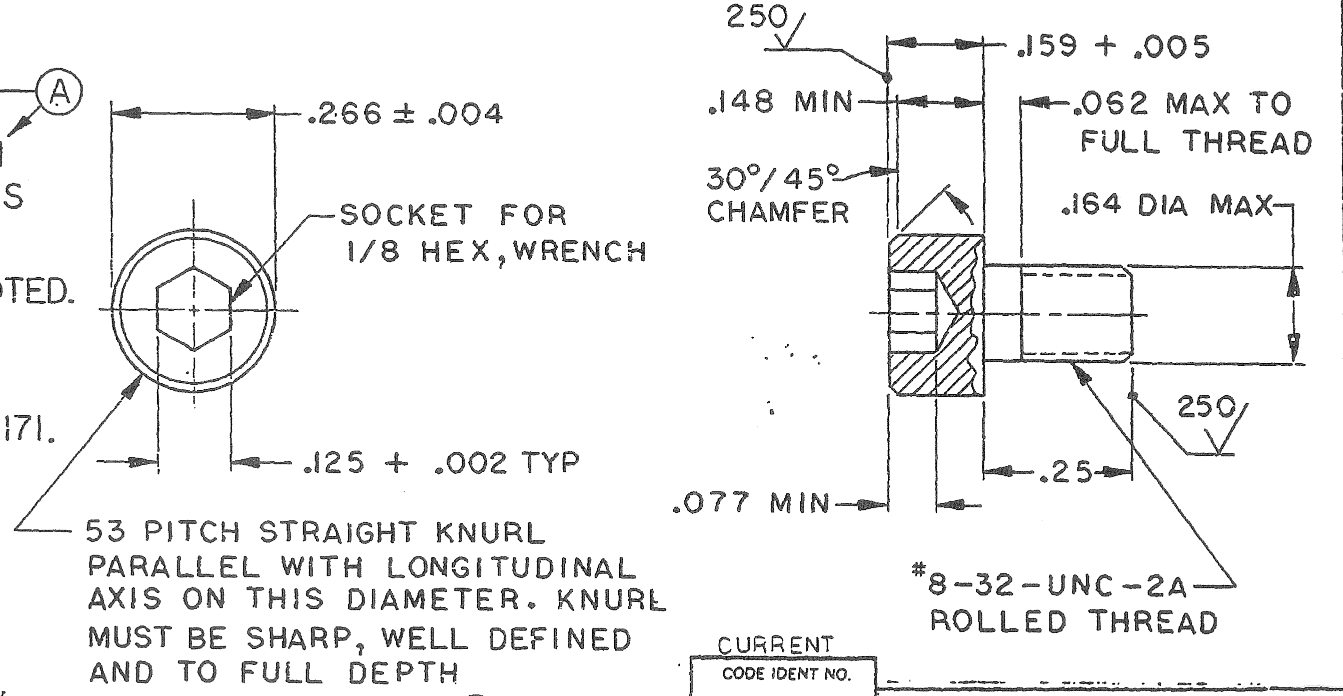
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C92201 REVISION A	27 APR 70	
		A	(4) SEE ERR HQR 20778	6 OCT 72	R.E.
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G1S2018 91-07-03	91-10-11	

B8448508

NOTES:

1. STEEL, CMPSN 4037, SPEC ASTM A322.
2. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓐ
3. FINISH $\sqrt[125]{}$ EXCEPT AS NOTED.
4. BREAK ALL SHARP EDGES .005+.005.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES. Ⓐ



.266 ± .004
SOCKET FOR 1/8 HEX, WRENCH
.125 + .002 TYP
53 PITCH STRAIGHT KNURL PARALLEL WITH LONGITUDINAL AXIS ON THIS DIAMETER. KNURL MUST BE SHARP, WELL DEFINED AND TO FULL DEPTH
Ⓐ
250
.159 + .005
.148 MIN
.062 MAX TO FULL THREAD
30°/45° CHAMFER
.164 DIA MAX
250
.25
.077 MIN
#8-32-UNC-2A ROLLED THREAD

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

CURRENT CODE IDENT NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		8448505	M4
EL 2			M16
RA		C8448505	M16A1
BH		NEXT ASSY	USED ON
RH	15N 78.5-83	APPLICATION	

Ⓐ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO
DATE 27 APR 1970

PREP		R. J. H.
CHK		T. Leadham
ENGR	D. Smart	D. Billiet

SUBMITTED F P Yelhosky

APPROVED R. S. Henry

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SCREW, CAP, HEX SOCKET HEAD

SIZE	CODE IDENT NO	DRAWING NO.
B	19204	8448508

SCALE 5/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CD1

October 15, 2004 11:33 AM

DRAWING SIZE D

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	G	REDRAWN WITH CHANGE NOR G8S2044 /880713	890207	089-BB
	H	NOR GIS2018 91 07 09	91-10-11	RR SP

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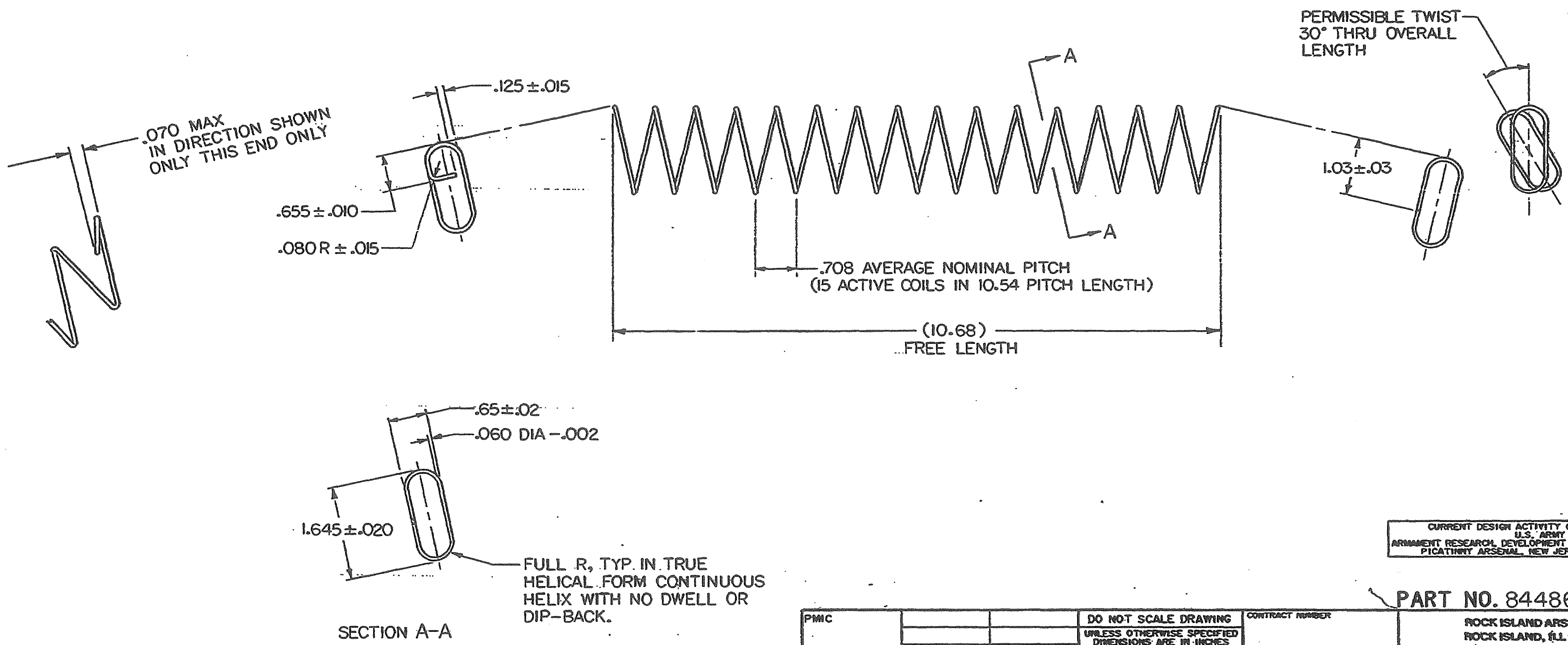
NOTES:
1. MATERIAL: WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. FINISH 125/
3. FINAL PROTECTIVE FINISH: FINISH 5.4.1 OF MIL-STD-171.
4. HEAT TREAT PER MIL-H-6875 EXCEPT AGING OPTIONAL.
5. MIL-W-13855 APPLIES.
6. LOAD HEIGHT REQUIREMENTS:
    LOAD AT 6.565" = 3.1 LB. ± .4 LB..
    LOAD AT 1.500" = 6.3 LB. ± .7 LB..
   SET SPRING TO SOLID HEIGHT THREE TIMES BEFORE MEASURING LOADS.



.070 MAX
IN DIRECTION SHOWN
ONLY THIS END ONLY
.125 ± .015
.655 ± .010
.080 R ± .015
A
A
.708 AVERAGE NOMINAL PITCH
(15 ACTIVE COILS IN 10.54 PITCH LENGTH)
(10.68)
FREE LENGTH
1.03 ± .03
PERMISSIBLE TWIST
30° THRU OVERALL
LENGTH
.65 ± .02
.060 DIA -.002
1.645 ± .020
FULL R, TYP. IN TRUE
HELICAL FORM CONTINUOUS
HELIX WITH NO DWELL OR
DIP-BACK.
SECTION A-A

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448671

PMIC			
MECHANICAL PROPERTIES			
YP			
TS		8448670	M4
EL2			30 ROUND
RA		8448670	MAGAZINE
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
ANGLES ± 1° 0' FRACTION ±
2 PL ± .01
3 PL ±
THIRD ANGLE PROJECTION
MATL ENGR

CONTRACT NUMBER
CONTRACTOR
DRAWN BY M.M. DATE 5 JUN 70
CHECKER J. B. ENGINEER D. B.
SUBMITTED
APPROVED R.S. HENRY

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

SPRING, MAGAZINE,
30 ROUND

SIZE D CODE IDENT NO. 19204 8448671
SCALE :/1 UNIT WT. SHEET 1 OF 1

SMCAR FORM 68.1 DEC 87(TEMP), REPLACES SMCAR FORM 68.1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:25 AM

October 15, 2004 11:26 AM

NOTICE OF REVISION (NOR)

THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.

1. DATE *(YYMMDD)* 990907

Form Approved
OMB No. 0704-0188

Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503.

PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.

2. PROCURING ACTIVITY NO.

3. DODAAC

4. ORIGINATOR

a. TYPED NAME *(First, Middle Initial, Last)*
Skip Winters

b. ADDRESS *(Street, City, State, Zip Code)*
AMSTA-AR-ESW-S
ROCK ISLAND IL, 61299

5. CAGE CODE 19200

6. NOR NO. 0002

7. CAGE CODE 19200

8. DOCUMENT NO. 8448673

9. TITLE OF DOCUMENT
PLATE, BOTTOM, MAGAZINE

10. REVISION LETTER
a. CURRENT G
b. NEW ---

11. ECP NO. L9S3017

12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES
M4A1 CARBINE 5.56mm

13. DESCRIPTION OF REVISION

ZONE B-3,4:
CHANGE FROM: "CONTRACTORS IDENTIFICATION TO BE APPROVED BY THE GOVERNMENT"
TO: "SEE NOTE 8"

UNDER NOTES ADD: "8. CONTRACTORS IDENTIFICATION IS OPTIONAL, IF IDENTIFICATION IS USED, IT MUST BE APPROVED BY THE GOVERNMENT."

REASON: THE CONTRACTORS IDENTIFICATION IS NOW REQUIRED ON THE MAGAZINE BOX, DRAWING 8448674.

14. THIS SECTION FOR GOVERNMENT USE ONLY

a. *(X one)*
☒ (1) Existing document supplemented by this NOR may be used in manufacture.
☐ (2) Revised document must be received before manufacturer may incorporate this change.
☐ (3) Custodian of master document shall make above revision and furnish revised document.

2

b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT

c. TYPED NAME *(First, Middle Initial, Last)*

d. TITLE
Configuration Manager
CH, Cmbt Spt & Sm Cal Wpn Sys Div

for

e. SIGNATURE
Walter J [illegible]

f. DATE SIGNED *(YYMMDD)*
991006

15.a. ACTIVITY ACCOMPLISHING REVISION

b. REVISION COMPLETED *(Signature)*

c. DATE SIGNED *(YYMMDD)*

Form 1695, APR 92 *Previous editions are obsolete.* DISTRIBUTION STATEMENT F: Request approval of SMCRI-IMO-DR

NOTICE OF REVISION (NOR)

THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.

1. DATE *(YYMMDD)* 990907

Form Approved OMB No. 0704-0188

Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1216 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503.
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2. PROCURING ACTIVITY NO.

3. DODAAC

4. ORIGINATOR

a. TYPED NAME *(First, Middle Initial, Last)* Skip Winters

b. ADDRESS *(Street, City, State, Zip Code)*
AMSTA-AR-ESW-S
ROCK ISLAND IL, 61299

5. CAGE CODE

6. NOR NO. 0001

7. CAGE CODE

8. DOCUMENT NO. 8448674 SH 1 OF 2

9. TITLE OF DOCUMENT BOX, MAGAZINE, 30 ROUND

10. REVISION LETTER a. CURRENT R b. NEW

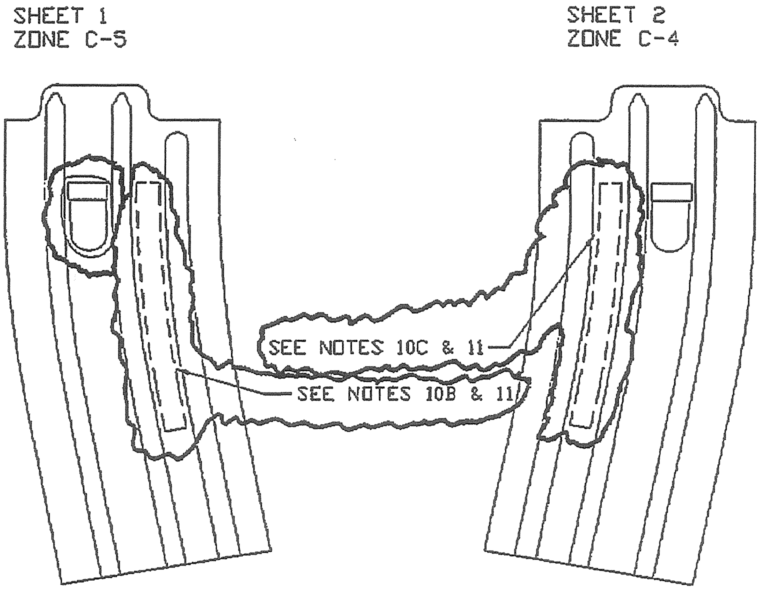
11. ECP NO. L9S3017

12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M4A1 CARBINE 5.56mm

NOR SH 2 OF 2

13. DESCRIPTION OF REVISION

ADD VIEW CALLOUTS AS SHOWN



REASON: THE BATF REQUIRES THESE CHANGES TO BE MADE.

14. THIS SECTION FOR GOVERNMENT USE ONLY

a. *(X one)*
☒ (1) Existing document supplemented by this NOR may be used in manufacture.
☐ (2) Revised document must be received before manufacturer may incorporate this change.
☐ (3) Custodian of master document shall make above revision and furnish revised document.

4

b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT

c. TYPED NAME *(First, Middle Initial, Last)*

d. TITLE
Configuration Manager
CH, Cmbt Spt & Sm Cal Wpn Sys Div

e. SIGNATURE for Walter J [illegible]

f. DATE SIGNED *(YYMMDD)* 991006

15.a. ACTIVITY ACCOMPLISHING REVISION

b. REVISION COMPLETED *(Signature)*

c. DATE SIGNED *(YYMMDD)*

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NOTICE OF REVISION (NOR)

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1. DATE *(YYMMDD)* 990907

Form Approved
OMB No. 0704-0188

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PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.

2. PROCURING ACTIVITY NO.

3. DODAAC

4. ORIGINATOR a. TYPED NAME *(First, Middle Initial, Last)* Skip Winters	b. ADDRESS *(Street, City, State, Zip Code)* AMSTA-AR-ESW-S ROCK ISLAND IL, 61299	5. CAGE CODE 19200 7. CAGE CODE 19200	6. NOR NO. 0001 8. DOCUMENT NO. 8448674 SH 1 OF 2
9. TITLE OF DOCUMENT BOX, MAGAZINE, 30 ROUND	10. REVISION LETTER a. CURRENT R	b. NEW	11. ECP NO. L9S3017
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M4A1 CARBINE 5.56mm			NOR SH 1 OF 2

13. DESCRIPTION OF REVISION

DELETE NOTE 10 IN ITS ENTIRETY AND SUBSTITUTE WITH THE FOLLOWING:

10. INSCRIPTIONS

A. - MANUFACTURER'S CAGE CODE AND MONTH AND YEAR, +/- TWO MONTHS OF MANUFACTURE.

B. - MARKING SHALL READ AS FOLLOWS "RESTRICTED LAW ENFORCEMENT/GOVERNMENT USE ONLY"OR BATF APPROVED EQUIVALENT.

C. - MARKING SHALL BE CONTRACTORS NAME, CITY, AND STATE.

11. MARKINGS ON MAGAZINE BOX SHALL BE INSCRIBED PRIOR TO APPLICATION OF HARD COAT AND SOLID FILM LUBRICANT. LETTERS SHALL BE APPROXIMATELY 0.1 HIGH X .005 + .005 DEEP. MARKING SHALL NOT EXTEND IN AREA 1.0 INCH FROM TOP OR 0.5 INCH FROM BOTTOM OF MAGAZINE BOX.

ZONE C-4, CHANGE FROM: SEE NOTE 10
TO: SEE NOTES 10A & 11

ZONE E-5 ADD PHANTOM LINE AROUND THE CUTOUT FOR THE OPPOSITE SIDE. (SEE NOR SH 2 OF 2)

SEE NOR SH 2 OF 2 FOR THE PLACEMENT OF REQUIRED INSCRIPTIONS.

REASON: THE BATF REQUIRES THESE CHANGES TO BE MADE.

14. THIS SECTION FOR GOVERNMENT USE ONLY

a. *(X one)*
☒ (1) Existing document supplemented by this NOR may be used in manufacture.
☐ (2) Revised document must be received before manufacturer may incorporate this change.
☐ (3) Custodian of master document shall make above revision and furnish revised document.

3

b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT	c. TYPED NAME *(First, Middle Initial, Last)*	
d. TITLE Configuration Manager CH, Cmbt Spt & Sm Cal Wpn Sys Div	e. SIGNATURE for Walter J Gonzalez	f. DATE SIGNED *(YYMMDD)* 991006
15.a. ACTIVITY ACCOMPLISHING REVISION	b. REVISION COMPLETED *(Signature)*	c. DATE SIGNED *(YYMMDD)*

DRAWING SIZE F

[illegible] RESTRICTED AS TO USE AND DISCLOSURE

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REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR-MO-DA)	APPROVED
	–	PRODUCTION RELEASE ERR G3S2038	93-09-02	
	A	NOR L7S3056 970909	971209	JB

NOTES:-

1-SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.

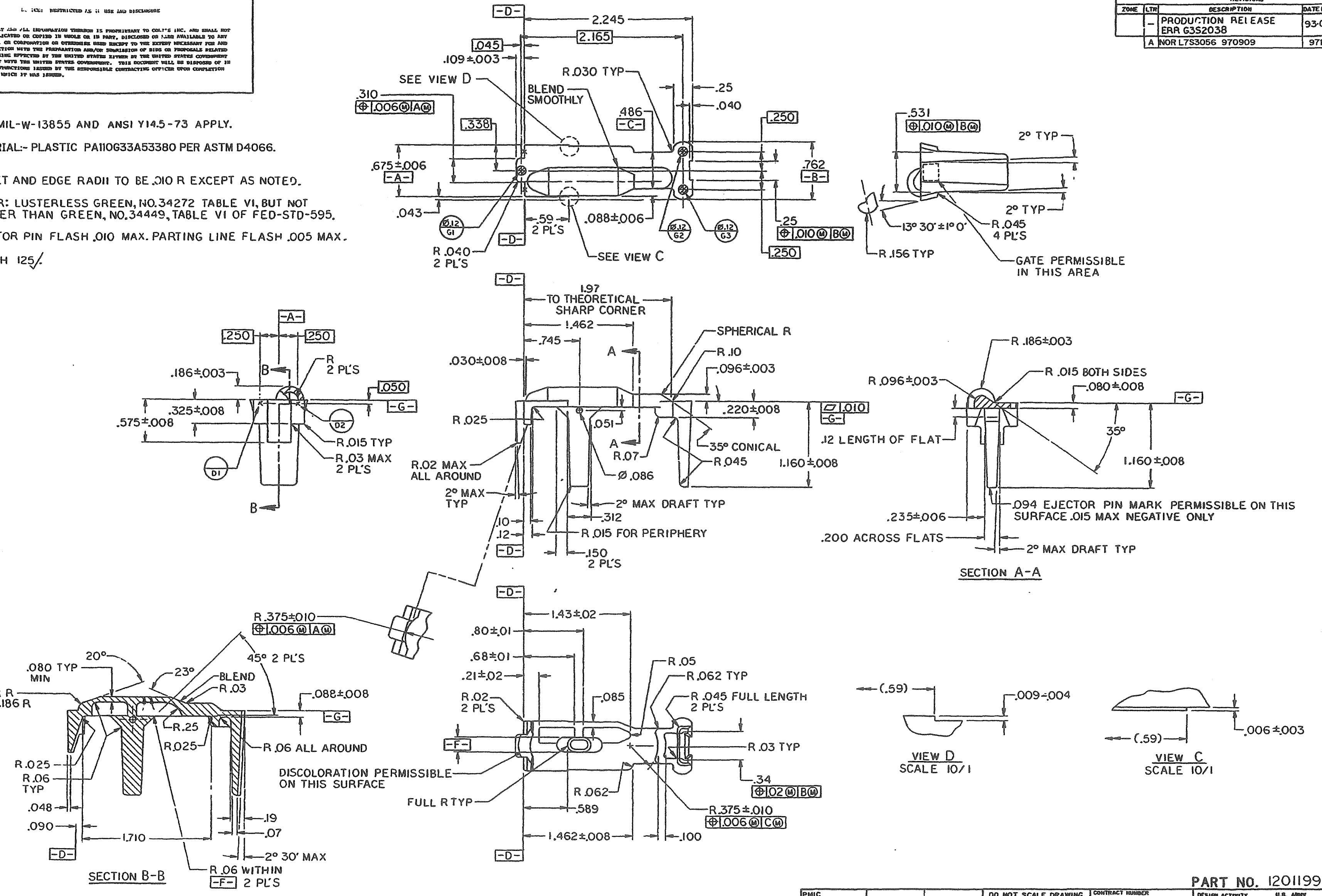
2-MATERIAL:- PLASTIC PA110G33A53380 PER ASTM D4066.

3-FILLET AND EDGE RADII TO BE .010 R EXCEPT AS NOTED.

4-COLOR: LUSTERLESS GREEN, NO.34272 TABLE VI, BUT NOT LIGHTER THAN GREEN, NO.34449, TABLE VI OF FED-STD-595.

5-EJECTOR PIN FLASH .010 MAX. PARTING LINE FLASH .005 MAX.

6-FINISH 125/



-D-
2.245
2.165
.045
.109±.003
SEE VIEW D
R.030 TYP
.25
.040
BLEND SMOOTHLY
.310
⊕ .006 Ⓜ A Ⓜ
.338
.486
-C-
.250
.762
-B-
.675±.006
-A-
.043
Ø.12 G1
.59 2 PL'S
.088±.006
Ø.12 G2
Ø.12 G3
.25
⊕ .010 Ⓜ B Ⓜ
.250
R.040 2 PL'S
SEE VIEW C
.531
⊕ .010 Ⓜ B Ⓜ
2° TYP
2° TYP
13° 30' ±1° 0'
R.045 4 PL'S
R.156 TYP
GATE PERMISSIBLE IN THIS AREA
-A-
.250
.250
.186±.003
B
R 2 PL'S
.050
-G-
.325±.008
.575±.008
D2
R.015 TYP
R.03 MAX 2 PL'S
D1
B
1.97 TO THEORETICAL SHARP CORNER
1.462
.745
.030±.008
A
SPHERICAL R
R.10
.096±.003
R.025
.051
.220±.008
.010
-G-
35° CONICAL
.12 LENGTH OF FLAT
A
R.07
R.045
1.160±.008
R.02 MAX ALL AROUND
Ø.086
2° MAX TYP
2° MAX DRAFT TYP
.312
.10
.12
R.015 FOR PERIPHERY
-D-
.150 2 PL'S
R.186±.003
R.096±.003
R.015 BOTH SIDES
.080±.008
-G-
35°
1.160±.008
.235±.006
.094 EJECTOR PIN MARK PERMISSIBLE ON THIS SURFACE .015 MAX NEGATIVE ONLY
.200 ACROSS FLATS
2° MAX DRAFT TYP
SECTION A-A
R.375±.010
⊕ .006 Ⓜ A Ⓜ
20°
45° 2 PL'S
.080 TYP MIN
23°
BLEND
R.03
.088±.008
.116 SPHER R BLEND TO .186 R
-G-
R.25
R.025
R.06 ALL AROUND
R.025
R.06 TYP
.048
.090
1.710
.19
.07
2° 30' MAX
-D-
R.06 WITHIN -F- 2 PL'S
SECTION B-B
-D-
1.43±.02
.80±.01
.68±.01
.21±.02
R.05
R.062 TYP
R.02 2 PL'S
.085
R.045 FULL LENGTH 2 PL'S
-F-
R.03 TYP
DISCOLORATION PERMISSIBLE ON THIS SURFACE
R.062
.34
⊕ .02 Ⓜ B Ⓜ
FULL R TYP
.589
R.375±.010
⊕ .006 Ⓜ C Ⓜ
1.462±.008
.100
-D-
(.59)
.009±.004
VIEW D SCALE 10/1
(.59)
.006±.003
VIEW C SCALE 10/1

PART NO. 12011994

PMIC			DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL 2 PL ±.01 3 PL ±.005 ANGLES ±1° 0'	CONTRACT NUMBER CONTRACTOR
MECHANICAL PROPERTIES YP TS EL2 RA BH RH	8448670 NEXT ASSY	30 ROUND MAGAZINE USED ON	THIRD ANGLE PROJECTION MATL ENGR	DRAWN BY K.AUGUSTIN DATE (YR-MO-DA) 91-11-12 CHECKER ENGINEER DRAWING APPROVAL DESIGN APPROVAL
	APPLICATION			

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

FOLLOWER, MAGAZINE, PLASTIC

SIZE	CAGE CODE	
F	19200	12011994
SCALE 2/1	UNIT WT.	SHEET 1 OF 1

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

SMCAR FORM 69, 1 DEC 87(TEMP) REPLACES SMCAR FORM 69, 1 JUL 87(TEMP) WHICH MAY BE USED UNTIL EXHAUSTED

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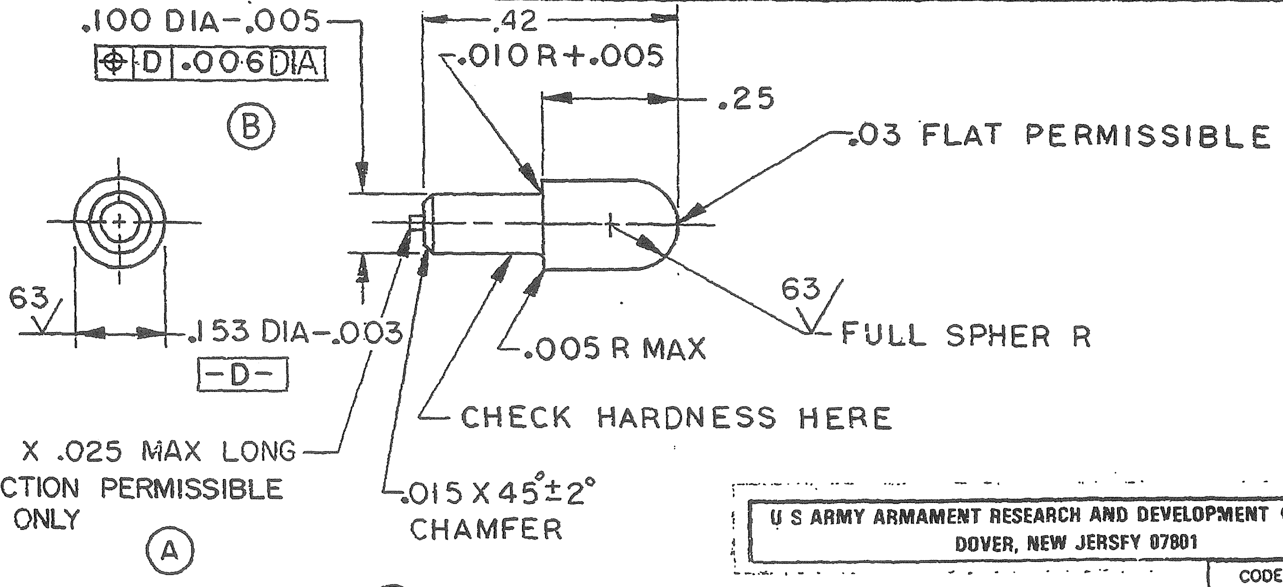
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C62178 REVISION B	27APR 70	
		A	(2). SEE EO HRD 02254	15 OCT 70	
		B	(2) SEE ERR HQR 20778	6 OCT 72	
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR G7S3114/870911	880112	
		E	NOR G1S2018/ 91-07-08	91-10-11	RR
		F	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL

B8448634

NOTE:

1. FINISH $\overset{125}{\checkmark}$ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT: LIQUID CARBURIZE AT 1550° F TO OBTAIN A TOTAL CASE DEPTH OF .003 TO .006. HARDEN AND TEMPER.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. MIL-W-13855 APPLIES. Ⓐ



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

Ⓑ

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		9390011	M4
YS MAX		F 9327230	M 231
EL 2		F8448604	M16
RA		F8448578	M16A1
BH			
RH	FILE HARD	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
STEEL, CMPSN 1117
ASTM A108

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO.
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 612

PLUNGER, BOLT CATCH

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448634

SCALE 5/1 SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:22 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M	-	B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W2S 0011 / 82-04-13 (ECP W2S 0034 / 82-07-15) (ECP W3S 3120 / 83-07-07)	83-11-04	
		E	NOR G1S2018/ 91 07 08	91-10-11	RS

B8448633

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0180 ±.0005
COIL DIAMETER (O.D.)	.148 ±.004
FREE LENGTH AFTER SETTING	.404 REF
TOTAL COILS	9 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .290	1.1 LB ±.1 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	
SOLID LENGTH	.185 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900° F ±10° FOR 1 HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT PART NO. 8448633

FSCM NO. 19200

MECHANICAL PROPERTIES			
YS MIN		9390011	M4
YS MAX		F9327230	M 231
EL 2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 70

PREP	P. Vernon	L. Gutman
CHK	G. Duesselhaus	D. Krolak
ENGR	R. Elbe	L. Brunton

SUBMITTED D. A. Cole

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, BOLT CATCH

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448633

SCALE — SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

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5 4 3 2 1

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REVISIONS

MF.	ZONE	LTR	DESCRIPTION	DATE	APPROVED
~~M~~	-	B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	LB
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W2S0011 / 82-04-13 (ECP W2S0034 / 82-07-15) (ECP W3S3120 / 83-07-07)	83-11-04	
		E	NOR G1S2018 / 91-07-08	91-10-11	RR

B8448586

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0160 ± .0005
COIL DIAMETER (O.D.)	.088 ± .003
FREE LENGTH	1.10 REF
TOTAL COILS	40 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .750	2.20 LBS ± .22 LBS
LOAD AT COMPRESSED LENGTH OF	—
SPRING RATE	—
SOLID LENGTH	.670 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH 900. HOLD AT 900°F ±10° FOR 1 HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003-.012.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT PART NO. 8448586

FSCM NO. 19200

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 84.5 MIN

APPLICATION

NEXT ASSY	USED ON
9390011	M4
F9327230	M231
F8448604	M16
F8448578	M16A1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970

PREP	L. Gutman	P. Vernon
CHK	J. Desselhaus	D. Krolak
ENGR	R. Elbe	L. Brunton

SUBMITTED
A. A. Cole

APPROVED
R. S. Henry

~~DEPT. OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

SPRING, DETENT, TAKEDOWN PIN

SIZE B
CODE IDENT NO. ~~19204~~
DRAWING NO. 8448586
SCALE NONE
SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

October 15, 2004 11:21 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778	6 OCT 72	LB
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)	83-11-04	
		F	ERR ~~Z9Z~~1251W (ECP G9S2036/890721)	900403	ORFI-CHT
		G	NOR G1S2018 91-07-08	91-10-11	RR SL

B8448516

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC ASTM-A228. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ± 25° FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003+.012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0240 ± .0003
COIL DIAMETER (O.D)	.103 ± .003
FREE LENGTH AFTER SETTING	.926 REF
TOTAL COILS	27 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .850	2.94 LB ± .30 LB
LOAD AT COMPRESSED LENGTH OF .784	5.50 LB ± .25 LB
SPRING RATE	
SOLID LENGTH	.650 MAX
TYPE OF ENDS	SQUARED, GROUND

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

FSCM NO.
19200

CURRENT

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448516

MECHANICAL PROPERTIES		8448509	M4
YS MIN		F9327230	M 231
YS MAX			M16
EL 2		C8448509	M16A1
RA		F8448604	M16
BH		F8448578	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 27 APR 70

PREP	P.V.	L.P.
CHK	G.D.	D.K.
ENGR	R.E.	L.B.

SUBMITTED
A.A. COLE

APPROVED
R.S. HENRY

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

SPRING, EJECTOR AND SAFETY DETENT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448516

SCALE NONE SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

SCANNED DUPLICATE ORIGINAL

October 15, 2004 11:21 AM

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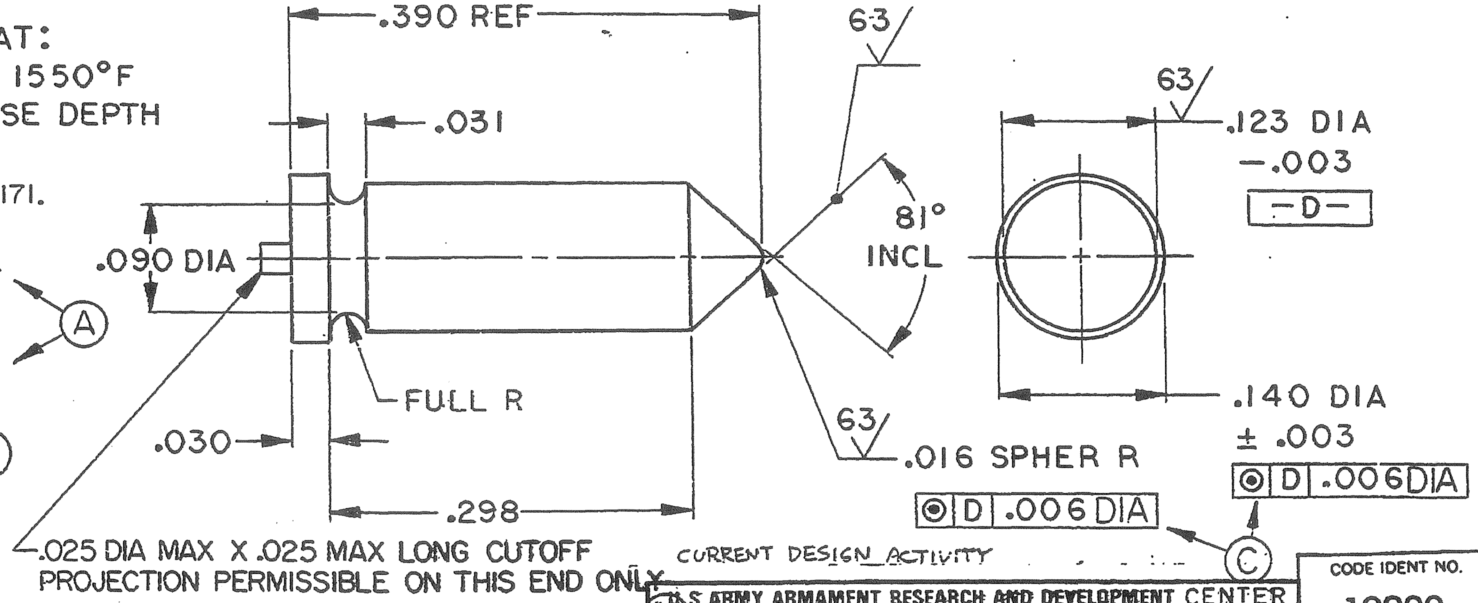
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61785 REVISION C	27 APR70	
M		A	(1) SEE EO HRD 02197-3	15 JUL 70	
M		B	(2) SEE EO HRD 02252	15 OCT 70	
M		C	(3) SEE ERR HQR 20778	6 OCT 72	R.E.
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR G7S3065 / 870515	880112	ORFI-V.Z.
		F	NOR GIS2018 / 91 07 08	91-10-11	RR

NOTE:

1. FINISH $^{125}\surd$ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT: LIQUID CARBURIZE AT 1550°F TO OBTAIN A TOTAL CASE DEPTH OF .010 / .015.
3. FINISH 1.1.2.1 OF MIL-STD-171. DO NOT BAKE FOR EMBRITTLEMENT RELIEF.
4. BREAK SHARP EDGES .005 +.010.
5. ALL DIMENSIONS APPLY AFTER FINISH.
6. MIL-W-13855 APPLIES. Ⓑ



CURRENT DESIGN ACTIVITY
U.S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801 Ⓒ

CODE IDENT NO. 19200

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED- DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ±
YS MIN		9390011	M4	
YS MAX		F 9327230	M 231	MATERIAL STEEL, CMPSN 1117, ASTM A108
EL 2		F8448604	M16	
RA		F8448578	M16A1	
BH		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH
RH	15N 89-91	APPLICATION		SEE NOTE 3

Ⓒ

CONTRACT NO:
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DETENT, FIRE CONTROL SELECTOR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448631

SCALE 10/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CDI

B8448631

October 15, 2004 11:21 AM

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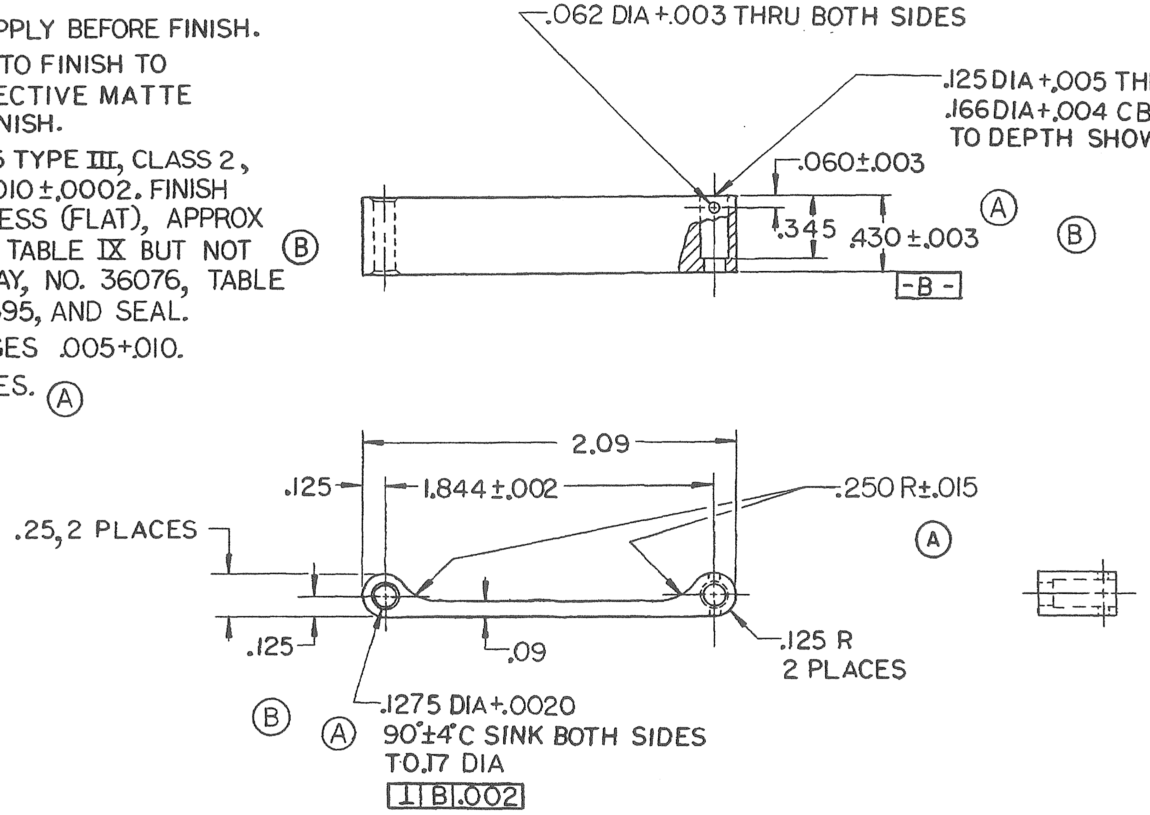
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M	-		REDRAWN FROM COLT'S DRAWING C 61248 REV A AND COLT'S DRAWING C 62497 REV A	27 APR70	
		A	(4) SEE EO HQR 10641	20 FEB 71	
M	-	B	(4) SEE ERR HQR 20778	6 OCT 72	R.E.
M		C	NOR W9S2009 80-02-13	800516	
		D	NOR G1S2018 91-07-08	91-10-11	RR
		E	NOR G6S2008 960328	960523	RLV

NOTE:

1. FINISH $\overset{125}{\surd}$.
2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. SANDBLAST PRIOR TO FINISH TO PRODUCE NONREFLECTIVE MATTE SURFACE AFTER FINISH.
4. FINISH MIL-A-8625 TYPE III, CLASS 2, FILM THICKNESS .0010±.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL. Ⓑ
5. BREAK SHARP EDGES .005+.010.
6. MIL-W-13855 APPLIES. Ⓐ



C8448588

Ⓑ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448587	M4
BH		B8448587	M231
			M16
		B8448587	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
ALUMINUM ALLOY
7075-T6, SPEC
ASTM B221

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO:
DATE 27 APR 1970

PREPARED	G.E.W.	A.J.-St.
CHECKED		D.G.B.
ENGINEER	S. Smart	D. Billiet

SUBMITTED F. P. Gilhooly
APPROVED R. S. Henry

CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

GUARD, TRIGGER

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448588

SCALE 2/1 SHEET 1 OF 1

AMSWE Form 403C, 29 Jul 69

CDI

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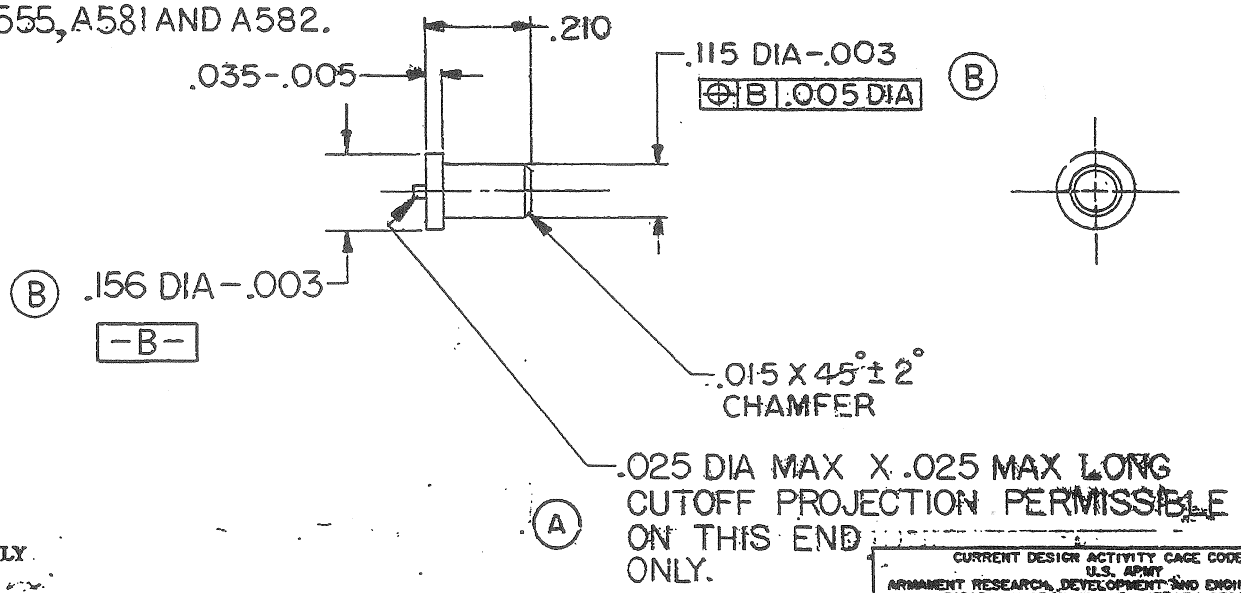
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61250 REVISION A	27 APR 70	
		A	(2) SEE EO HRD 02251	15 OCT 70	
M		B	(3) SEE ERR HQR 20778	6 OCT 72	R.E.
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR GIS3074/910626	91 08 21	PF
		E	NOR GIS2018 91-07-08	91-10-11	RR
		F	NOR G3S3081/930831	931026	DR

B8448589

NOTES:

1. WIRE, STEEL, CORROSION RESISTING, FREE MACHINING STOCK, CLASS 303, ANNEALED, COLD DRAWN, SPEC ASTM A555, A581 AND A582. Ⓑ
2. FINISH $\overset{125}{\surd}$.
3. BREAK ALL SHARP EDGES .005 ±.005.
4. MIL-W-13855 APPLIES. Ⓐ



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DATE OF DETERMINATION:

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN		8448587	M4
YS MAX		B8448587	M231
EL 2			M16
RA		B8448587	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ±

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970
PREP RGH A.J.H.
CHK
ENGR D. Billet
SUBMITTED F. P. Gillooly
APPROVED R. S. Henry

~~DEPT OF THE ARMY~~
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PLUNGER, TRIGGER GUARD

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448589
SCALE 4/1
SHEET 1 OF 1

October 18, 2004 7:11 AM

AMSWE Form 403B, 29 Jul 69

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	RB
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	~~NOR W2S0011 / 82-04-13~~ ~~(ECP W2S0034 / 82-07-15)~~ ~~(ECP W3S3120 / 83-07-07)~~	83-11-04	
		E	NOR GIS2018 91 07 08	91-10-11	RB SE

B8448590

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0160±.0005
COIL DIAMETER (O.D)	.145±.003
FREE LENGTH	.310 REF
TOTAL COILS	6 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .175	1.48 LB ± .15 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	
SOLID LENGTH	.118 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900; HOLD AT 900°F±10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT PART NO 8448590

FSCM NO. 19200

MECHANICAL PROPERTIES			
YS MIN		8448587	M4
YS MAX		B8448587	M 231
EL 2			M16
RA		B8448587	M16A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:		
DATE 27 APR 1970		
PREP		P. Vernon
CHK		W. Krolek
ENGR	R. Elbe	L. Brunton
SUBMITTED	A. A. Cole	
APPROVED	R. S. Henry	

~~DEPT OF THE~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

SPRING, TRIGGER GUARD

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448590

SCALE NONE SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

ctober 18, 2004 7:13 AM

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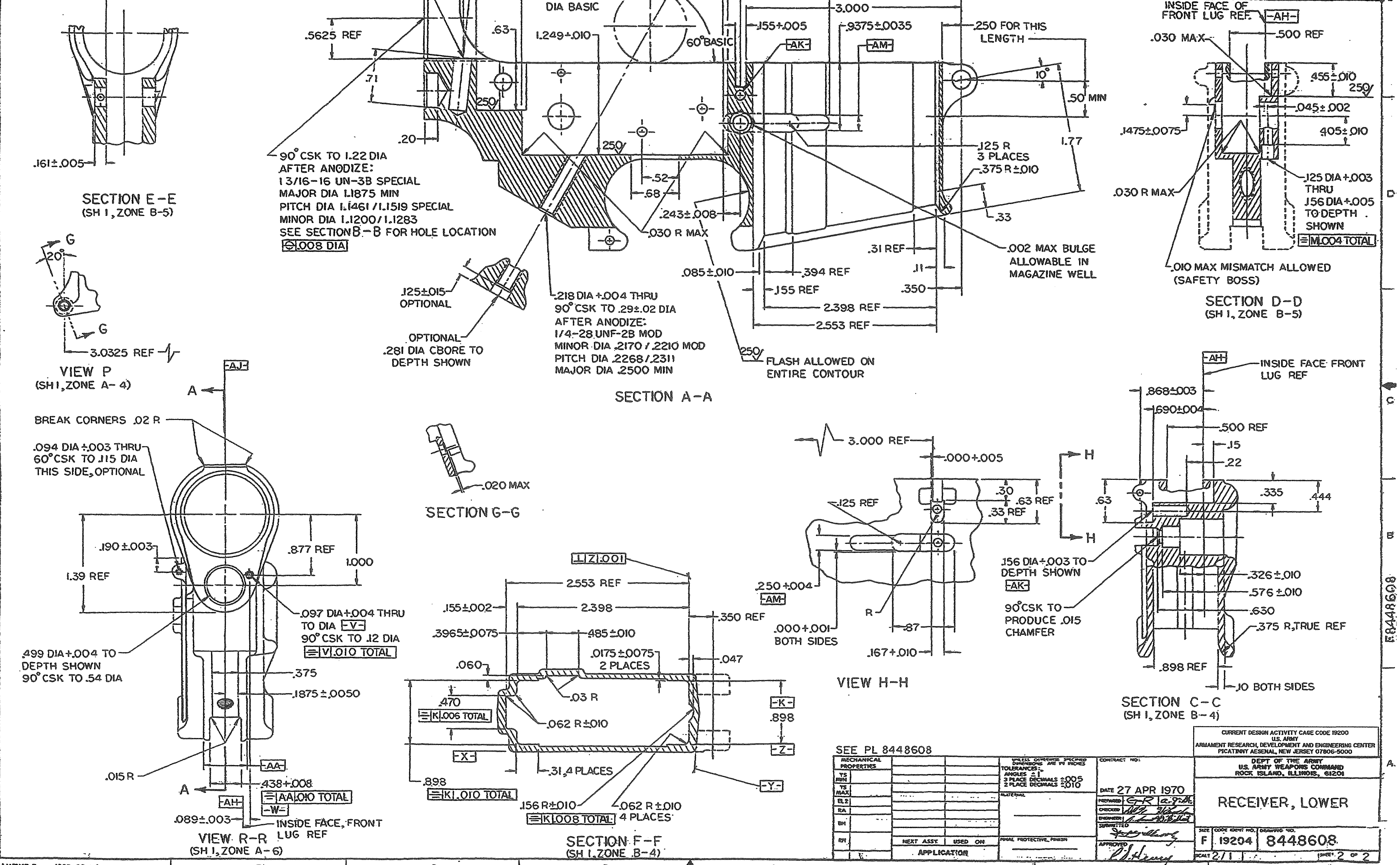
J	NOR G9S3111 89-11-07 (ECP G0S3007 90-02-14)	90-06-18	
P	NOR G6S3144 961025	961215	JB

G	NOR W2S0026 82-05-21	83-02-03	CV
H	NOR G9S3124 891130	900306	

REVISIONS

INF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62300 REV E	27 APR 70	
		A	NO CHANGE	15 JULY 70	
		B	(1) SEE EO HRD. 10640	20 FEB 71	
		C	(3) SEE HQR 10728	26 MAY 71	
		D.	SEE ERR HQR 10832	20 AUG 71	
		E	(5) SEE ERR HQR 20778	5 OCT 72	RE
		F	SEE NOR 75E0012-0002	15 APR 75	


SECTION E-E
(SH 1, ZONE B-5)
-AH-
.161±.005
.565±.002
6°
.255 DIA+.006 TO DEPTH SHOWN
.5625 REF
.71
.63
.20
2.675 BASIC
6.777
2.87
1.000 DIA BASIC
1.249±.010
60° BASIC
S .010
1.509±.008
3.265
3.0795±.0025
3.000
LOCATION OF -AK-
.155±.005
-AK-
.9375±.0035
-AM-
.250 FOR THIS LENGTH
10°
.50 MIN
1.77
.125 R 3 PLACES
.375 R±.010
.33
250
90° CSK TO 1.22 DIA
AFTER ANODIZE:
1 3/16-16 UN-3B SPECIAL
MAJOR DIA 1.1875 MIN
PITCH DIA 1.1461/1.1519 SPECIAL
MINOR DIA 1.1200/1.1283
SEE SECTION B-B FOR HOLE LOCATION
.008 DIA
.52
.68
.243±.008
.030 R MAX
.085±.010
.31 REF
.394 REF
.155 REF
.11
.350
2.398 REF
2.553 REF
.002 MAX BULGE ALLOWABLE IN MAGAZINE WELL
.125±.015 OPTIONAL
OPTIONAL .281 DIA CBORE TO DEPTH SHOWN
.218 DIA+.004 THRU
90° CSK TO .29±.02 DIA
AFTER ANODIZE:
1/4-28 UNF-2B MOD
MINOR DIA .2170/.2210 MOD
PITCH DIA .2268/.2311
MAJOR DIA .2500 MIN
FLASH ALLOWED ON ENTIRE CONTOUR
SECTION A-A
INSIDE FACE OF FRONT LUG REF. -AH-
.030 MAX
.500 REF
.455±.010
.045±.002
.1475±.0075
.405±.010
.030 R MAX
.125 DIA+.003 THRU
.156 DIA+.005 TO DEPTH SHOWN
M .004 TOTAL
.010 MAX MISMATCH ALLOWED (SAFETY BOSS)
SECTION D-D
(SH 1, ZONE B-5)
G
20°
G
3.0325 REF
VIEW P
(SH 1, ZONE A-4)
-AJ-
A
BREAK CORNERS .02 R
.094 DIA+.003 THRU
60° CSK TO .115 DIA THIS SIDE, OPTIONAL
.190±.003
1.39 REF
.877 REF
1.000
.097 DIA+.004 THRU TO DIA -V-
90° CSK TO .12 DIA
V .010 TOTAL
.499 DIA+.004 TO DEPTH SHOWN
90° CSK TO .54 DIA
.375
.1875±.0050
.015 R
-AA-
.438+.008
AA .010 TOTAL
-AH-
-W-
.089±.003
INSIDE FACE, FRONT LUG REF
VIEW R-R
(SH 1, ZONE A-6)
.020 MAX
SECTION G-G
Z .001
2.553 REF
.155±.002
2.398
.350 REF
.3965±.0075
.485±.010
.0175±.0075 2 PLACES
.060
.047
.03 R
.470
K .006 TOTAL
.062 R±.010
-K-
.898
-X-
-Z-
.31, 4 PLACES
-Y-
.898
K .010 TOTAL
.156 R±.010
K .008 TOTAL
.062 R±.010 4 PLACES
SECTION F-F
(SH 1, ZONE B-4)
3.000 REF
.000+.005
.125 REF
.30
.63 REF
.33 REF
.250+.004
-AM-
R
.000+.001 BOTH SIDES
.87
.167+.010
VIEW H-H
H
H
.63
-AH-
INSIDE FACE FRONT LUG REF
.868±.003
.690±.004
.500 REF
.15
.22
.335
.444
.156 DIA+.003 TO DEPTH SHOWN
-AK-
90° CSK TO PRODUCE .015 CHAMFER
.326±.010
.576±.010
.630
.375 R, TRUE REF
.898 REF
.10 BOTH SIDES
SECTION C-C
(SH 1, ZONE B-4)

SEE PL 8448608

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ±1° 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.010
TS MIN			MATERIAL
TS MAX			
EL 2			
RA			
BH			
RH	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH
	APPLICATION		

CONTRACT NO:

DATE 27 APR 1970

PREPARED G R

CHECKED

ENGINEER

SUBMITTED

APPROVED

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY AESENAL, NEW JERSEY 07806-5000

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RECEIVER, LOWER

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448608

SCALE 2/1 SHEET 2 OF 2

CD

AMSWE Form 403F, 29 Jul 69

8448608

October 13, 2004 3:27 PM

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NOTES:-

1 - ALL DIMENSIONS APPLY BEFORE FINISH EXCEPT AS NOTED.

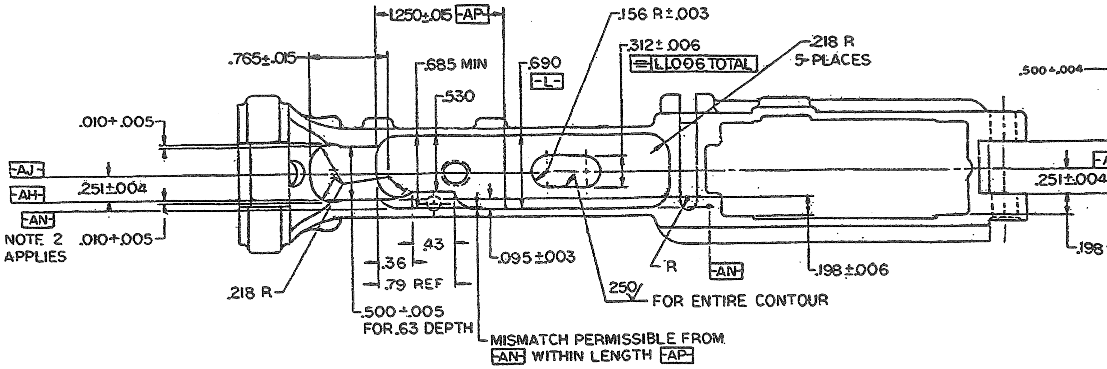
2 - -AN- PARALLEL TO -AH- WITHIN .020 IN 10 INCHES.

3 - PLANE -AJ- ESTABLISHED ON FORGING DRAWING F8448641.

4 - BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE SPECIFIED.

5 - MIL-W-13855 APPLIES.

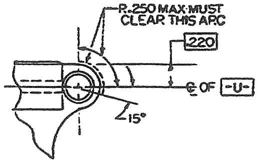
6 - UNLESS OTHERWISE SPECIFIED SURFACE FINISH WILL BE 125√.



1.250±.015 -AP-
.156 R±.003
.312±.006
⌯ L .006 TOTAL
.218 R
5 PLACES
.765±.015
.685 MIN
.690
-L-
.530
.500+.004
.010+.005
-AJ-
-AH-
.251±.004
-AN-
NOTE 2 APPLIES
.010+.005
.36
.43
.79 REF
.095±.003
R
-AN-
.198±.006
.218 R
.500±.005 FOR .63 DEPTH
250√ FOR ENTIRE CONTOUR
MISMATCH PERMISSIBLE FROM -AN- WITHIN LENGTH -AP-
-AJ- REF
.251±.004
-AH- REF
.198±.004

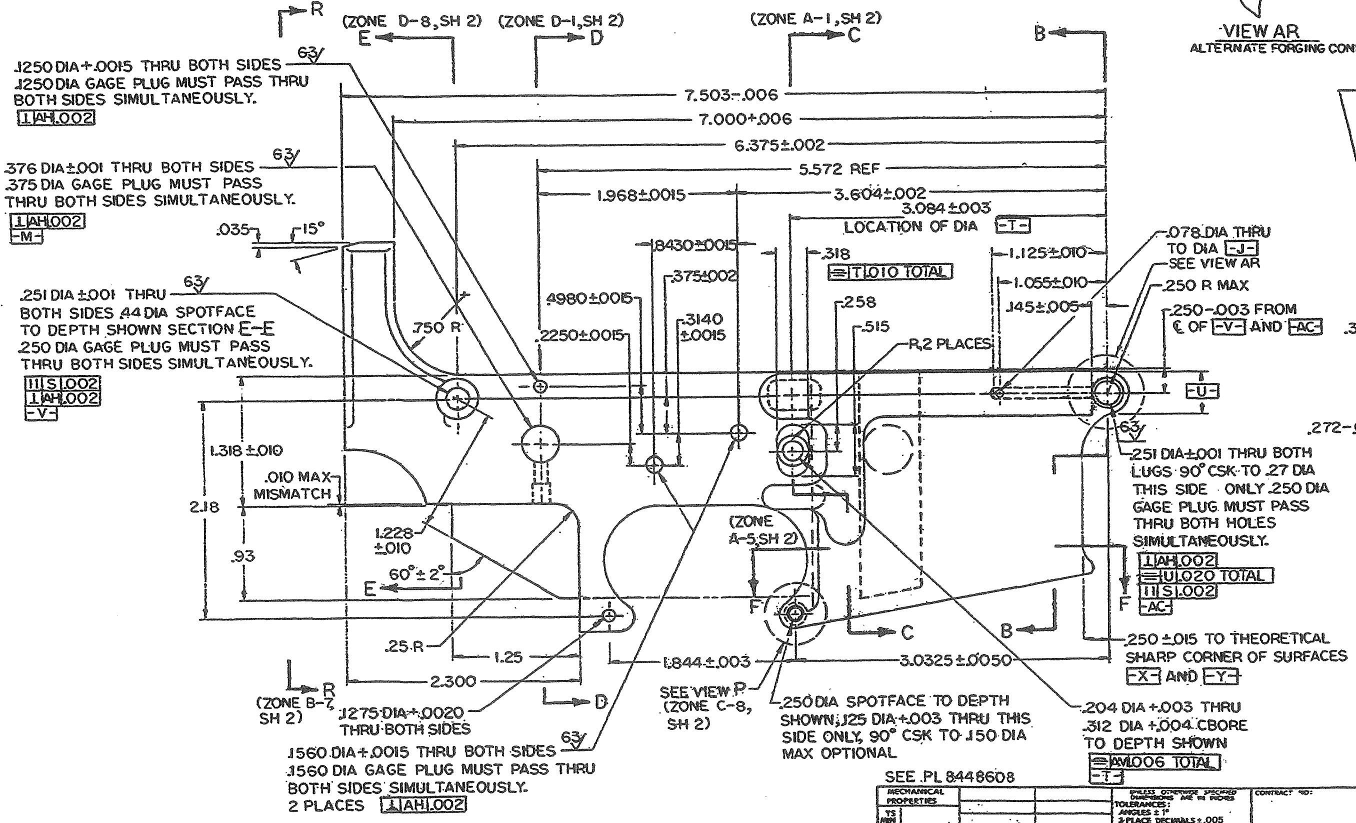
REVISIONS

INF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62300 REV E.	27 APR 70	
		A	(2) SEE EO MRD 02137-3	15 JULY 70	
		B	(9) SEE EO HQR-10640	20 FEB 71	
		C	(4) SEE HQR 10728	26 MAY 71	
		D	SEE ERR HQR 10832	20 AUG 71	
		E	(5) SEE ERR HQR 20778	6 OCT 72	
		F	SEE NOR 76E0012-0002	16 APR 76	
		G	NOR M12300026 82-05-21	830208	
		H	NOR G9S3124 891130	900309	
		J	NOR G9S3111 89-11-07 (ECP G0S3007 90-02-14)	90-05-18	
		K	NOR G1S3041/910516	910613	
		L	NOR G1S2018 91-07-08	91-10-11	
		M	NOR G1S3166/911209	920204	
		N	NOR G3S 3064/930715	930928	
		P	NOR G6S3144 961025	961215	JB

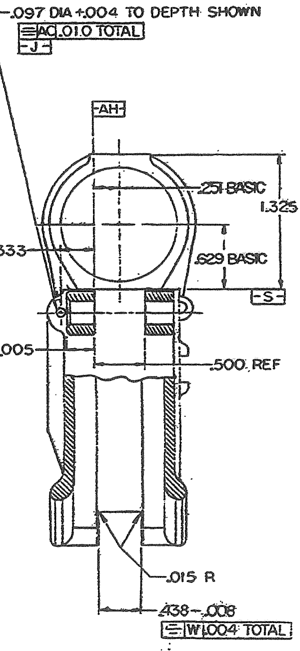


R.250 MAX MUST CLEAR THIS ARC
220
℄ OF -U-
15°

VIEW AR
ALTERNATE FORGING CONFIGURATION



R
(ZONE D-8, SH 2)
E
(ZONE D-1, SH 2)
D
(ZONE A-1, SH 2)
C
B
.1250 DIA +.0015 THRU BOTH SIDES 63√
.1250 DIA GAGE PLUG MUST PASS THRU BOTH SIDES SIMULTANEOUSLY.
⊥ AH .002
7.503-.006
7.000+.006
6.375±.002
5.572 REF
.376 DIA±.001 THRU BOTH SIDES 63√
.375 DIA GAGE PLUG MUST PASS THRU BOTH SIDES SIMULTANEOUSLY.
⊥ AH .002
-M-
1.968±.0015
3.604±.002
3.084±.003
LOCATION OF DIA -T-
.035
15°
.8430±.0015
.318
⌯ T .010 TOTAL
.078 DIA THRU TO DIA -J-
SEE VIEW AR
1.125±.010
1.055±.010
.375±.002
.4980±.0015
.251 DIA ±.001 THRU 63√
BOTH SIDES .44 DIA SPOTFACE TO DEPTH SHOWN SECTION E-E
.250 DIA GAGE PLUG MUST PASS THRU BOTH SIDES SIMULTANEOUSLY.
∥ S .002
⊥ AH .002
-V-
.750 R
.2250±.0015
.3140 ±.0015
.258
.515
R, 2 PLACES
.145±.005
.250 R MAX
.250-.003 FROM ℄ OF -V- AND -AC-
-U-
63√
.251 DIA±.001 THRU BOTH LUGS 90° CSK TO .27 DIA THIS SIDE ONLY .250 DIA GAGE PLUG MUST PASS THRU BOTH HOLES SIMULTANEOUSLY.
⊥ AH .002
⌯ U .020 TOTAL
∥ S .002
-AC-
1.318±.010
.010 MAX MISMATCH
2.18
.93
1.228 ±.010
60°±2°
E
(ZONE A-5, SH 2)
F
F
C
B
.250±.015 TO THEORETICAL SHARP CORNER OF SURFACES -X- AND -Y-
.25 R
1.25
2.300
1.844±.003
3.0325±.0050
R
(ZONE B-7, SH 2)
D
.1275 DIA +.0020 THRU BOTH SIDES
SEE VIEW P (ZONE C-8, SH 2)
.250 DIA SPOTFACE TO DEPTH SHOWN; .125 DIA +.003 THRU THIS SIDE ONLY, 90° CSK TO .150 DIA MAX OPTIONAL
.204 DIA +.003 THRU .312 DIA +.004 CBORE TO DEPTH SHOWN
⌯ AM .006 TOTAL
-T-
63√
.1560 DIA +.0015 THRU BOTH SIDES
.1560 DIA GAGE PLUG MUST PASS THRU BOTH SIDES SIMULTANEOUSLY.
2 PLACES ⊥ AH .002



.097 DIA +.004 TO DEPTH SHOWN
⌯ AC .010 TOTAL
-J-
-AH-
.251 BASIC
1.325
.333
.629 BASIC
-S-
.272-.005
.500 REF
.015 R
.438-.008
⌯ W .004 TOTAL

SECTION B-B

SEE PL 8448608

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

REV STATUS OF SHTS	
SH 1	SH 2
P	P

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		9390015	M4
BH		D8448606	M16
		D8448580	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
MAKE FROM LOWER RECEIVER FORGING F8448641

FINISH PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970
PREPARED G.R.
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RECEIVER, LOWER

SIZE F | CODE IDENT NO. 19204 | DRAWING NO. 8448608
SCALE 2/1 | SHEET 1 OF 2

DISTRIBUTION STATEMENT F.
DISTRIBUTION IS AUTHORIZED TO DoD AGENCIES AND DoD QUALIFIED U.S. ORDNANCE CONTRACTORS. FURTHER DISSEMULATION AS DIRECTED BY:
OR HIGHER DoD AUTHORITY.

AMSWE Form 403F, 29 Jul 69

F8448608

October 13, 2004 3:27 PM

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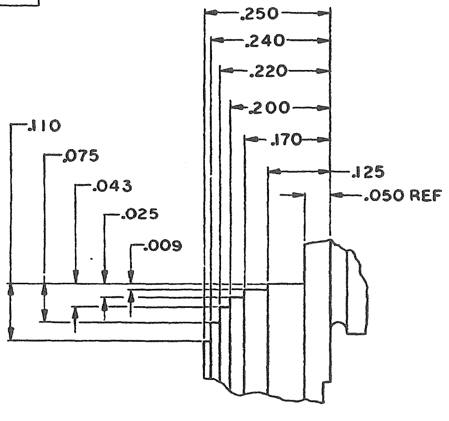
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERR W3S3148	84-01-27	———
A	NOR W5S3026/85-07-23 (ECP W5S2098/85-11-21)	860724	
B	NOR W6S3030/860612 (ECP W6S3035/860717)	880208	
C	NOR G8S3026/880503	880928	
D	NOR G0S3024 90 03 26	900822	
E	NOR G1S2018 91 07 08	91-10-11	
F	NOR G2S9510/920514	920622	

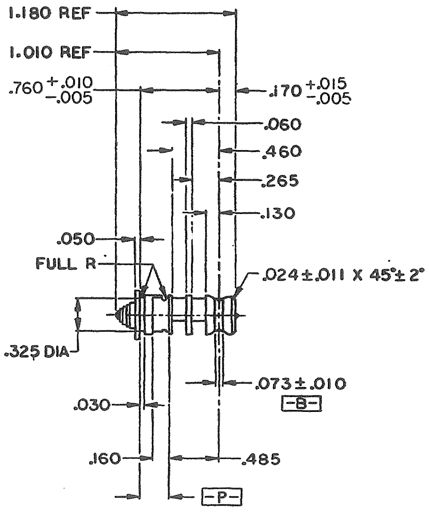
NOTES:

1. STEEL, INVESTMENT CASTING, CMPSN IC 8620, SPEC MIL-S-22141, EXCEPT THAT MAGANESE CONTENT SHALL BE .70 TO 1.20%.
2. CASTING SHALL BE CAPABLE OF MEETING FOUNDRY PRACTICE AS SPECIFIED IN MIL-STD-2175, CLASS 2, GRADE B, IN AREA DESIGNATED -P- REMAINDER OF CASTING CLASS 3, GRADE A.
3. ALL DIMENSIONS APPLY BEFORE FINISH.
4. ALL EDGES AND FILLET RADII .010 MAX EXCEPT AS NOTED.
5. ALL DIAMETERS CONCENTRIC WITHIN .005 DIA.
6. EJECTOR PIN MARKS .005 POSITIVE TO .005 NEGATIVE.
7. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .010 TO .015. HARDEN AND TEMPER.
8. GRIND AFTER HEAT TREAT, .005 MIN CASE DEPTH AFTER GRINDING ON -N-.
9. FINISH 125√ EXCEPT AS NOTED.
10. SEE SHEET 2 FOR ALTERNATIVE DESIGN.
11. PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171.
12. MIL-W-13855 APPLIES.

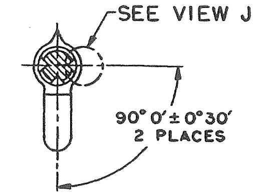


.250
.240
.220
.200
.170
.125
.050 REF
.110
.075
.043
.025
.009

VIEW H
SCALE 10/1

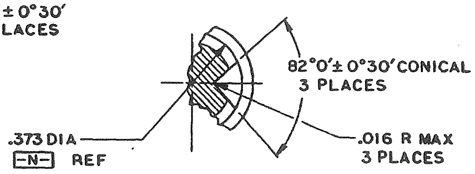


1.180 REF
1.010 REF
.760 +.010 -.005
.170 +.015 -.005
.060
.460
.265
.130
.050
FULL R
.024±.011 X 45°±2°
.325 DIA
.073±.010
-B-
.030
.160
.485
-P-



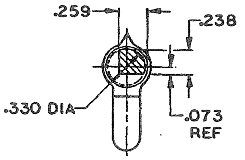
SEE VIEW J
90° 0'± 0°30'
2 PLACES

SECTION G-G

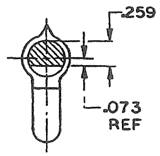


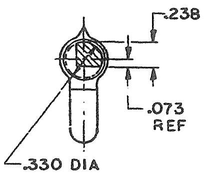
82°0'± 0°30' CONICAL
3 PLACES
.373 DIA
-N- REF
.016 R MAX
3 PLACES

VIEW J
SCALE 5/1



.259
.238
.330 DIA
.073
REF



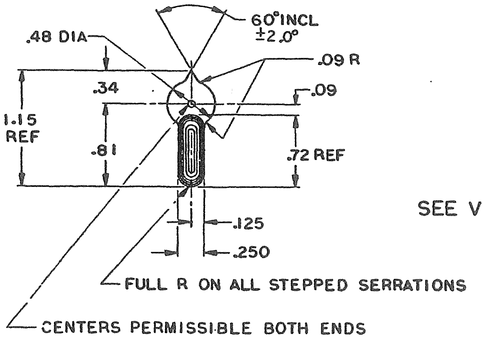


.238
.073
REF
.330 DIA

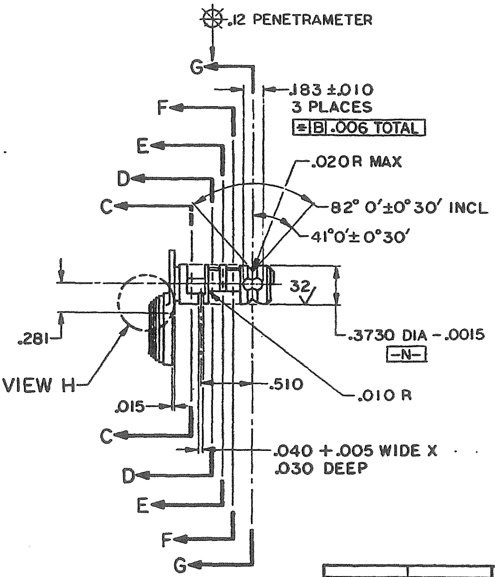
SECTION D-D

SECTION E-E

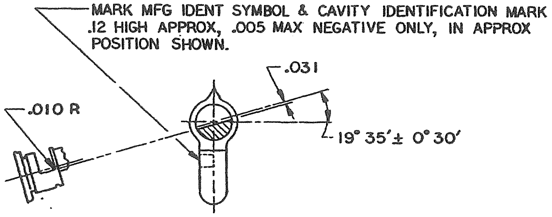
SECTION F-F



60°INCL
±2.0°
.48 DIA
.09 R
.34
.09
1.15
REF
.81
.72 REF
.125
.250
FULL R ON ALL STEPPED SERRATIONS
CENTERS PERMISSIBLE BOTH ENDS



.12 PENETRAMETER
G
F
E
D
C
.183±.010
3 PLACES
⌯ B .006 TOTAL
.020 R MAX
82° 0'±0°30' INCL
41°0'±0°30'
32√
.281
.3730 DIA -.0015
-N-
SEE VIEW H
.510
.010 R
.015
C
D
E
F
G
.040 +.005 WIDE X
.030 DEEP



MARK MFG IDENT SYMBOL & CAVITY IDENTIFICATION MARK .12 HIGH APPROX, .005 MAX NEGATIVE ONLY, IN APPROX POSITION SHOWN.
.031
.010 R
19° 35'± 0° 30'

SECTION C-C

F	F
SH. 2	SH. 1

REVISION STATUS OF SHEETS

PART NO. 9381367

NEXT ASSY	USED ON
8448578	M16A1
8448604	M16
9391001	M4
9349100	M16A2 RIFLE

APPLICATION

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH
15N 88.5 TO 91.0

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS .000 ±.005 .00 ±.01
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 84-01-27
DRAFTSMAN HW
CHECKER
ENGR RJH
ENGR
ENGR
ENGR

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

SELECTOR,
FIRE CONTROL

SIZE F
FSCM NO. 19200
9381367
SCALE 2/1
UNIT WT
SHEET 1 OF 2

DISTRIBUTION STATEMENT E
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASONC-AR OR HIGHER DOD AUTHORITY: 911025.

AMSWE Form 403F, 29 Jul 69

October 13, 2004 3:23 PM

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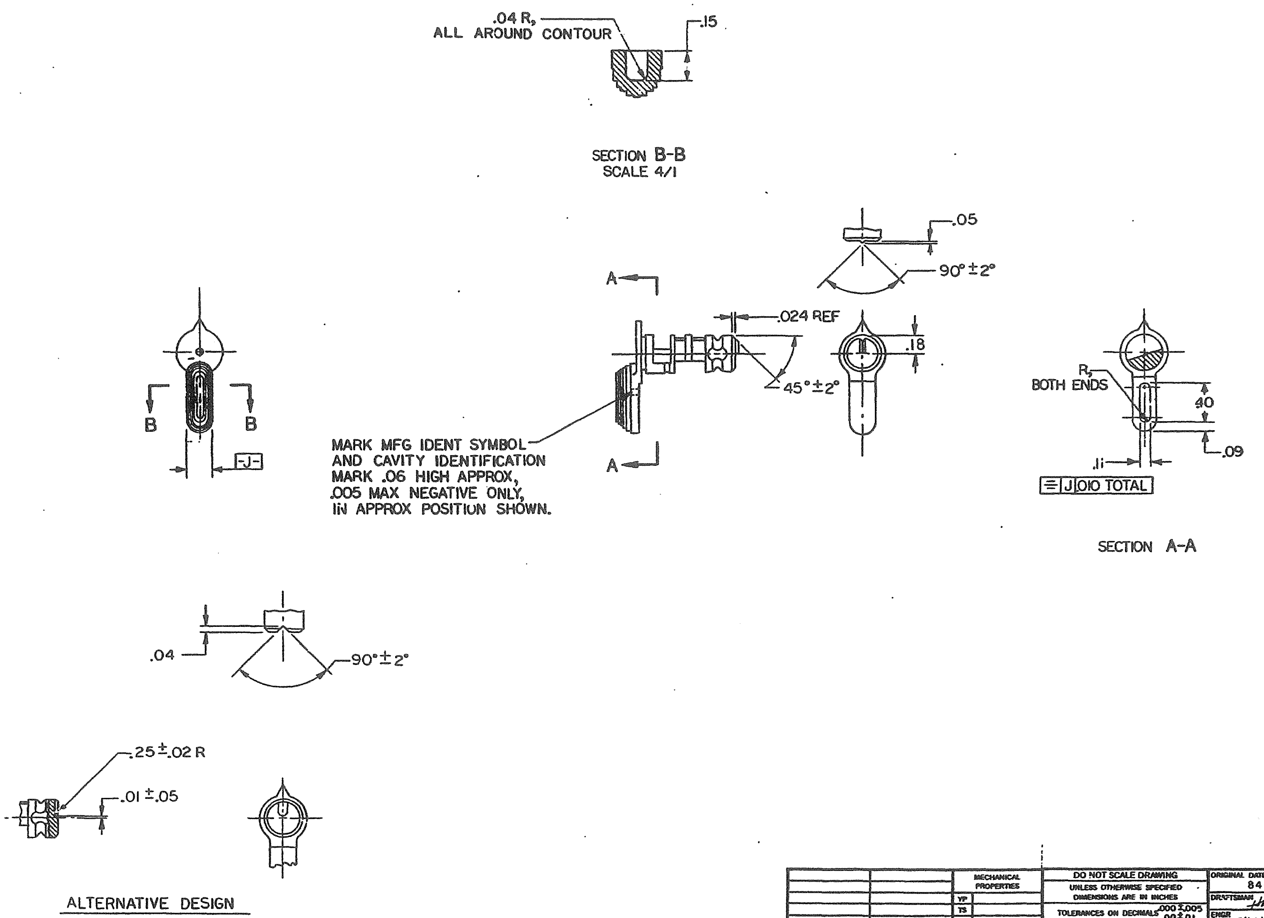
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERR W3S 3148	84 01·27	——
B	NOR. W6S3030 /860612 (ECP G7S3139/870904)	880208	
F	NOR G2S9510/920514	920622	


.04 R,
ALL AROUND CONTOUR
.15
SECTION B-B
SCALE 4/1
.05
90° ± 2°
A
.024 REF
.18
45° ± 2°
A
B
B
-J-
MARK MFG IDENT SYMBOL
AND CAVITY IDENTIFICATION
MARK .06 HIGH APPROX,
.005 MAX NEGATIVE ONLY,
IN APPROX POSITION SHOWN.
R
BOTH ENDS
.40
.09
.11
⌯ J .010 TOTAL
SECTION A-A
.04
90° ± 2°
.25 ± .02 R
.01 ± .05
ALTERNATIVE DESIGN

DISTRIBUTION STATEMENT E
FURTHER DISTRIBUTION ONLY AS DIRECTED BY
ASQNC-X* OR HIGHER DOD AUTHORITY: 911025.

PART NO: 9381367

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING 84-01-25		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER NEW JERSEY 07801
		YP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAFTSMAN HW	CHECKER	SELECTOR, FIRE CONTROL
		TS		TOLERANCES ON DECIMALS .000 ± .005 .00 ± .01	ENGR KJH	ENGR	
		EL2		FRACTIONS ± ANGLES ±	ENGR	ENGR	
8448578	M16A1	RA					
8448604	M16	BH					SIZE F
9349100	M16A2 RIFLE						FSCM NO. 19200
NEXT ASSY	USED ON	RH					9381367
APPLICATION							SCALE 2/1 UNIT WT SHEET 2 OF 2

AMSWE Form 403F, 29 Jul 69

October 13, 2004 3:23 PM

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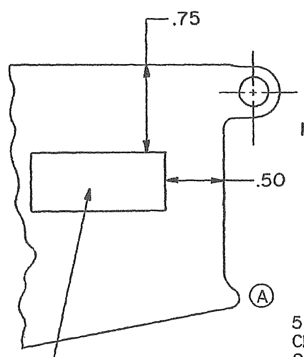
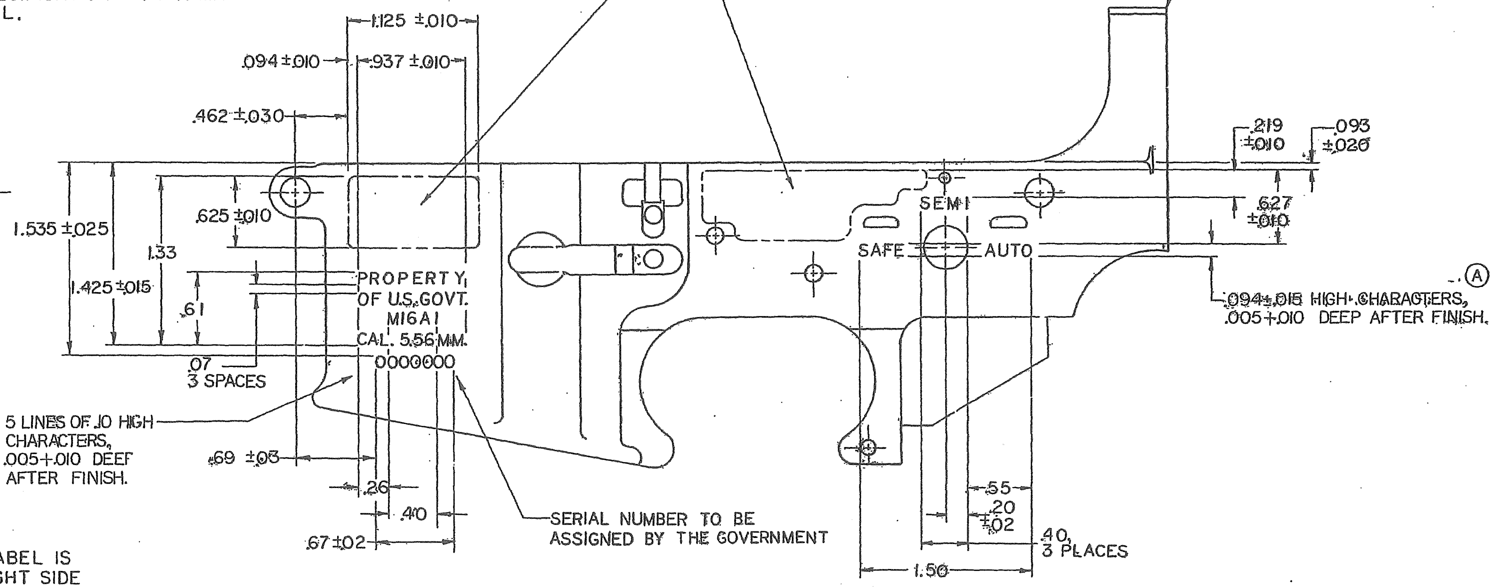
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D62222 REV C	27 APR 70	
		A	(3) SEE ERR HQR 10628	20 FEB 71	
M		B	SEE ERR HQR 20778	6 OCT 72	R.E.
M		C	SEE NOR 76E 0012-0001	16 APR 76	
	–	D	HQCN230026 88-05-21	89-02-03	
		E	NOR G7S3106/870731	881007	ORF1-V7
		F	NOR G9S3130 / 89-12-05	90-01-26	

NOTE

1. GRIT BLAST BEFORE FINISH TO PRODUCE NON-REFLECTIVE MATTE SURFACE AFTER FINAL FINISH.
2. FINISH MIL-A-8625, TYPE III, CLASS 2. FILM THICKNESS .0010 ±.0002 FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL. Ⓑ
3. MIL-W-13855 APPLIES. Ⓐ
4. APPLY BARCODE LABEL AS SHOWN IAW TECHNICAL PURCHASE DESCRIPTION / SPECIFICATION - U.S. ARMY SMALL ARMS WEAPON LABEL.



BARCODE LOCATION
WEAPON BARCODE LABEL IS LOCATED ON THE RIGHT SIDE OF THE RECEIVER. NOTE 4



CONTRACTOR'S IDENTIFICATION TO BE APPROVED BY THE GOVERNMENT.
Ⓒ
RECEIVER, LOWER F 8448608
1.125 ±.010
.094 ±.010
.937 ±.010
.462 ±.030
.625 ±.010
1.535 ±.025
1.33
1.425 ±.015
.61
.07
3 SPACES
PROPERTY
OF U.S. GOVT.
M16A1
CAL. 5.56 MM.
0000000
5 LINES OF .10 HIGH CHARACTERS, .005+.010 DEEP AFTER FINISH.
.69 ±.03
.26
.40
.67 ±.02
SERIAL NUMBER TO BE ASSIGNED BY THE GOVERNMENT
SEMI
SAFE
AUTO
.219 ±.010
.093 ±.020
.627 ±.010
.094±.015 HIGH CHARACTERS,
.005+.010 DEEP AFTER FINISH.
Ⓐ
.55
.20 ±.02
.40, 3 PLACES
1.50

VIEW OF RIGHT SIDE
(REVOLVED 180°)

Ⓒ SEE PL 8448580

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± — 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO:	DEPT OF THE ARMY. U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201
YS MIN				MATERIAL MAKE FROM RECEIVER, LOWER F8448608	DATE 27APR 1970	RECEIVER, LOWER MODEL M16A1
YS MAX					PREPARED RAR	
EL 2					CHECKED	
RA					ENGINEER	
BH		C8448579	M16A1		SUBMITTED F. P.	SIZE D · CODE IDENT NO. 19204 · DRAWING NO 8448580
RH		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH SEE NOTE 2	APPROVED R. S. Henry	SCALE 2/1 · SHEET · OF
		APPLICATION				

D 8448580

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October 13, 2004 3:22 PM

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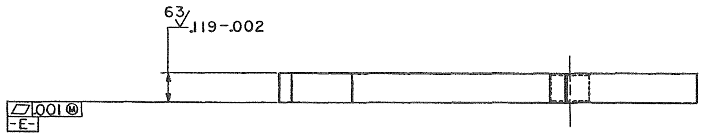
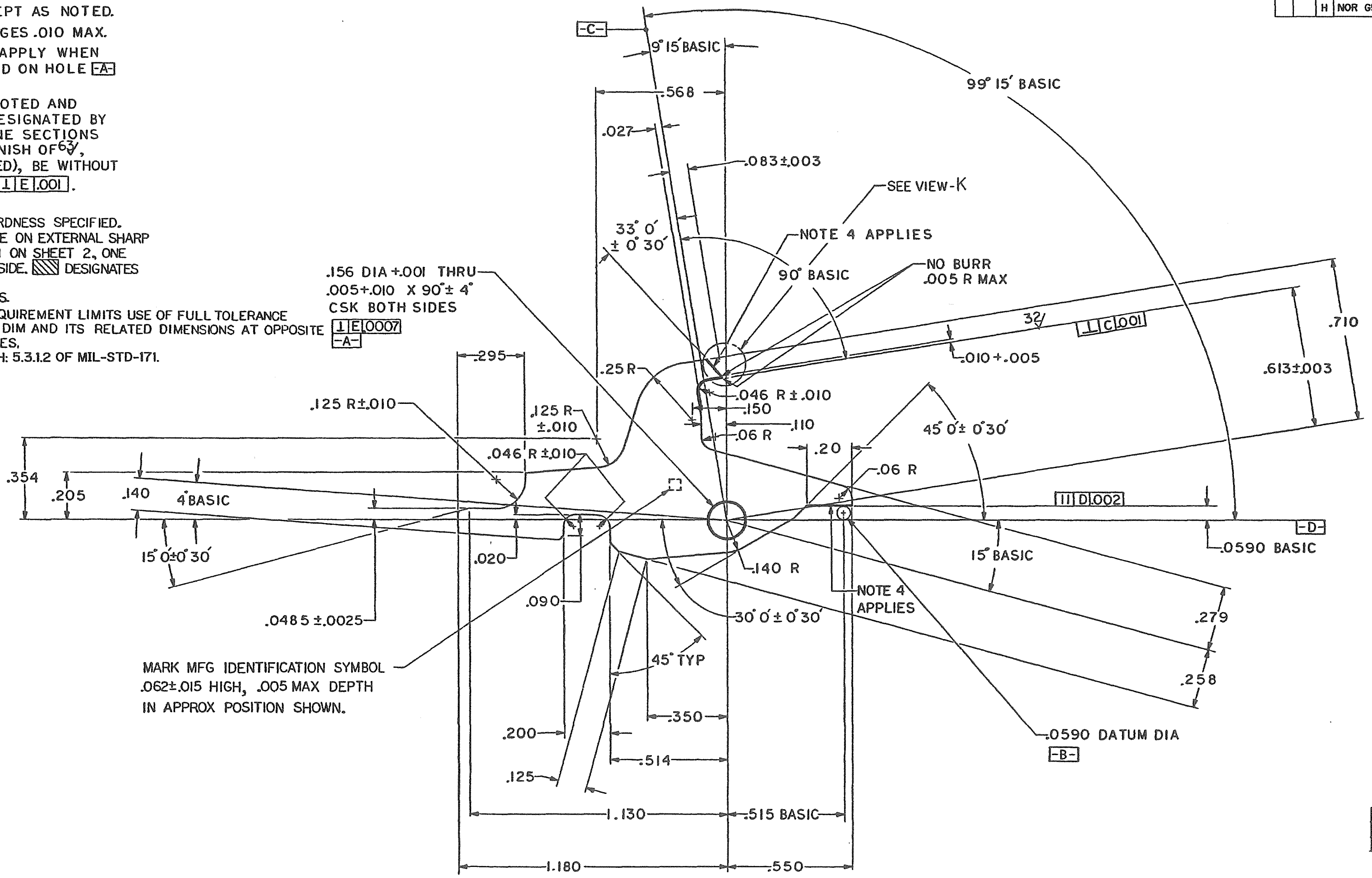


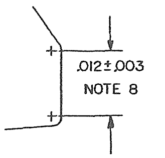
63/ .119-.002
▱ .001 Ⓜ
-E-

NOTE:
1. FINISH 125/√ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 MAX.
3. ALL DIMENSIONS APPLY WHEN PART IS LOCATED ON HOLE -A- AND DATUM -B-.
4. SURFACES SO NOTED AND ADDITIONALLY DESIGNATED BY VERY HEAVY LINE SECTIONS MUST HAVE A FINISH OF 63/√, (EXCEPT AS NOTED), BE WITHOUT DIE BREAK AND ⊥ E .001.
5. HEAT TREATMENT: AUSTEMPER TO HARDNESS SPECIFIED.
6. DIE ROLL PERMISSIBLE ON EXTERNAL SHARP CORNERS, AS SHOWN ON SHEET 2, ONE SIDE ONLY, EITHER SIDE. ▨ DESIGNATES DIE ROLL AREA.
7. MIL-W-13855 APPLIES.
8. .012 ± .003 FLAT REQUIREMENT LIMITS USE OF FULL TOLERANCE BAND ON THE .010 DIM AND ITS RELATED DIMENSIONS AT OPPOSITE TOLERANCE EXTRMES.
9. PROTECTIVE FINISH: 5.3.1.2 OF MIL-STD-171.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62334 REV B	27 APR 70	
		A	(1) SEE EO HRD 02197-3	15 JULY 70	
		B	(3) SEE EO HQR 10624	20 FEB 71	
		C	(3) SEE ERR HQR 20778	6 OCT 72	RE
		D	NOR N2S0026 82-05-21	83-02-05	
		E	NOR G2S3032/920408	920520	CHS SE
		F	NOR G2S3046/92-05-26	920708	CF SE
		G	NOR G2S3121/93-01-08	930324	SE
		H	NOR G5S3099 951002	960117	RLV



-C-
9° 15' BASIC
99° 15' BASIC
.568
.027
.083±.003
SEE VIEW-K
33° 0' ± 0° 30'
NOTE 4 APPLIES
90° BASIC
NO BURR .005 R MAX
.156 DIA +.001 THRU
.005+.010 X 90°± 4°
CSK BOTH SIDES
⊥ E .0007
-A-
32/
⊥ C .001
.010 +.005
.710
.613±.003
.295
.25 R
.046 R ±.010
.150
.110
.06 R
.125 R±.010
.125 R ±.010
.046 R ±.010
.20
.06 R
45° 0' ± 0° 30'
.354
.205
.140
4° BASIC
∥ D .002
-D-
.0590 BASIC
15° 0' ± 0° 30'
.020
.140 R
15° BASIC
.090
NOTE 4 APPLIES
30° 0' ± 0° 30'
.279
.0485 ±.0025
.258
MARK MFG IDENTIFICATION SYMBOL .062±.015 HIGH, .005 MAX DEPTH IN APPROX POSITION SHOWN.
45° TYP
.350
.200
.514
.0590 DATUM DIA
-B-
.125
1.130
.515 BASIC
1.180
.550



.012±.003
NOTE 8

VIEW-K
NO SCALE

F8448635

REV STATUS OF SHT'S	
SH 1	SH 2
H	E

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES ± 1° 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO
YS MIN					DATE 27 APR 1970
YS MAX				MATERIAL	PREPARED
EL 2				STEEL, CMPSN 1065, SPEC QQ-S-700	CHECKED
RA					ENGINEER
BH		F8448604	M16		SUBMITTED
RH	C46-50	F8448578	M16A1	FINAL PROTECTIVE FINISH	APPROVED
		NEXT ASSY	USED ON	5.3.1.2. MIL-STD-171	
		APPLICATION			

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DISCONNECT

SIZE	CODE IDENT NO	DRAWING NO
F	19204	8448635

SCALE 5/1 SHEET 1 OF 2

CDI

DISTRIBUTION STATEMENT E
FURTHER DISTRIBUTION ONLY AS DIRECTED BY DoD CONTROLLING OFFICE ASQNC-AR, SMCAR-ESW, ROCK ISLAND, IL OR HIGHER
DoD AUTHORITY 920318

October 13, 2004 3:19 PM

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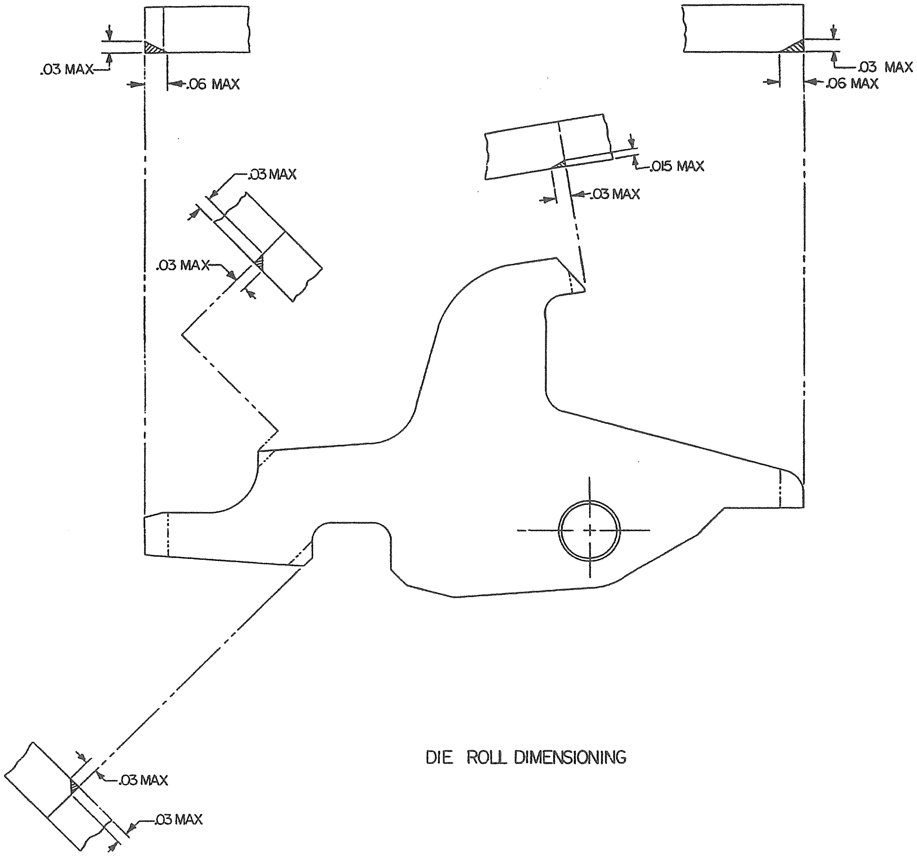
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	SEE EO HQR 10624	20 FEB 71	
M		C	NO CHANGE	6 OCT 72	RE
		D	NORW2S0026 82-05-21	8302-05	
		E	NOR G2S3032/920408	920520	EMS SL



DIE ROLL DIMENSIONING

DISTRIBUTION STATEMENT E.
FURTHER DISTRIBUTION ONLY AS DIRECTED BY DoD CONTROLLING
OFFICE: ASQNC-AR, SMCAR-ESW, ROCK ISLAND, IL OR HIGHER
DoD AUTHORITY [illegible]

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± — 3 PLACE DECIMALS ± — 2 PLACE DECIMALS ± —	CONTRACT NO:	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201
YS MIN			MATERIAL —	DATE FEB 19, 1971	DISCONNECT
YS MAX				PREPARED A. Hendley R.L. Francis	
EL 2				CHECKED A. Kostak	
RA				ENGINEER D. Elliot	
BH				SUBMITTED H. Pillsbury	SIZE F CODE IDENT NO. 19204 DRAWING NO. 8448635
RH	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH —	APPROVED R. S. Henry	SCALE 8/1 SHEET 2 OF 2
	APPLICATION				

AMSWE Form 403F, 29 Jul 69

October 13, 2004 3:19 PM

E 8448635

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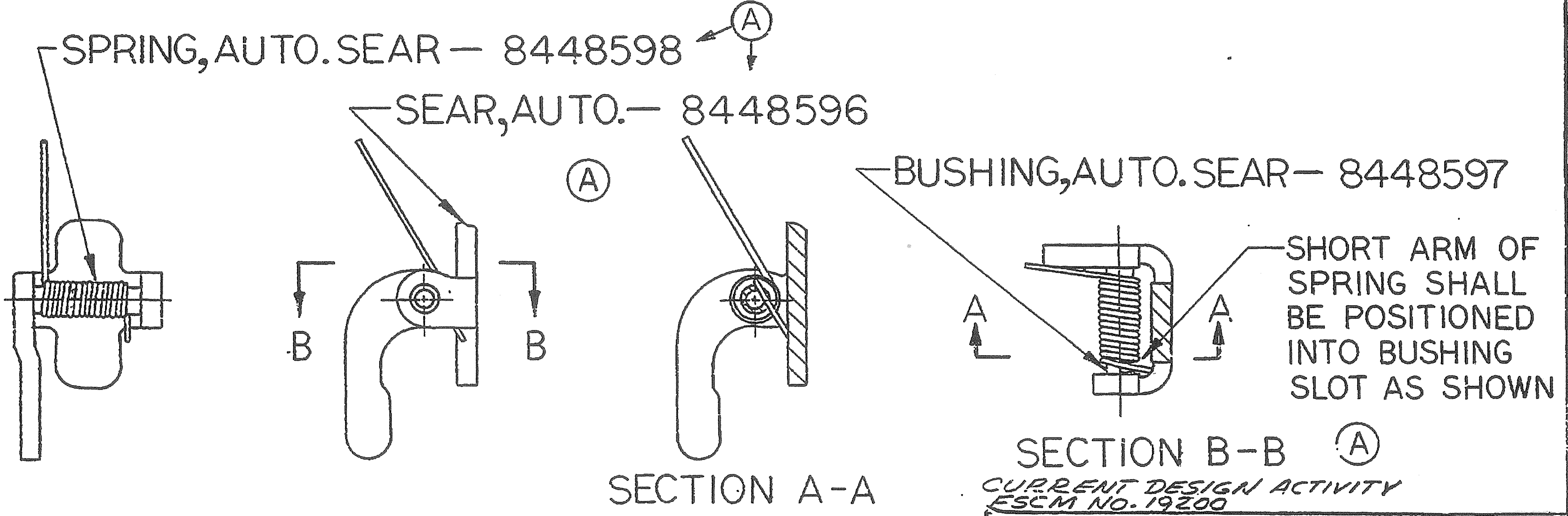
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61622 REV A	27APR70	
-M-		A	(5)SEE ERR HQR 20778	6 OCT 72	R.C.
		B	NOR W2S0026 82-05-21	83-02-03	
		C	NOR GIS2018 91-07-08	91-10-11	SR
		D	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL SR

B8448595

NOTES:

1. MIL-W-13855 APPLIES. Ⓐ


SPRING, AUTO. SEAR — 8448598 Ⓐ
SEAR, AUTO. — 8448596
Ⓐ
BUSHING, AUTO. SEAR — 8448597
SHORT ARM OF SPRING SHALL BE POSITIONED INTO BUSHING SLOT AS SHOWN
B
B
A
A
SECTION A-A
SECTION B-B Ⓐ

Ⓐ SEE PL— 8448595

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390011	M4
EL 2		F8448578	M16A1
RA		F8448604	M16
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——
MATERIAL
——
FINAL PROTECTIVE FINISH
——

CONTRACT NO:
DATE 27 APR 1970

PREP	GEW	A. J. H.
CHK		H. Luchan
ENGR		D. Billiet
SUBMITTED	F.P. Gillooly	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

AUTOMATIC SEAR ASSY

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448595

SCALE 2/1 SHEET OF

AMSWE Form 403B, 29 Jul 69

October 13, 2004 3:18 PM

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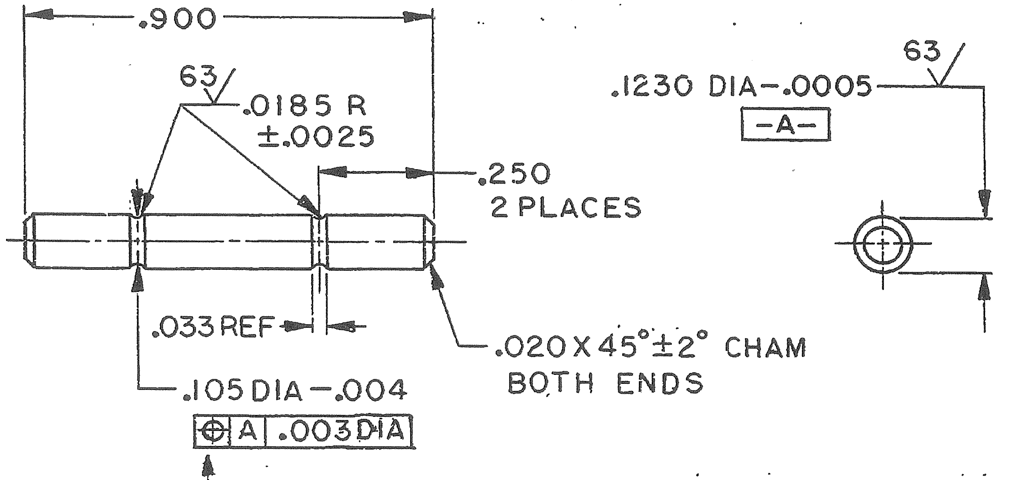
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B61615 REVISION B	27APR 70	
		A	(4) SEE ERR HQ R 20778	6 OCT 72	R.C.
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G8S3003/880229	880926	
		D	NOR G1S2018/ 91 07 08	91-10-11	RR SL
		E	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL SR

NOTES:

1. FINISH $\overset{125}{\surd}$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH Ⓐ AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES. Ⓐ



Ⓐ

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

Ⓐ

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 72.5-76

NEXT ASSY	USED ON
9390011	M4
F8448604	M16
F8448578	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± —

MATERIAL
WIRE, STEEL, CMPSN 4130, OR 4140; ASTM A331

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO:
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, AUTOMATIC SEAR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448599

SCALE 4/1
SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CD1

B8448599

October 13, 2004 3:18 PM

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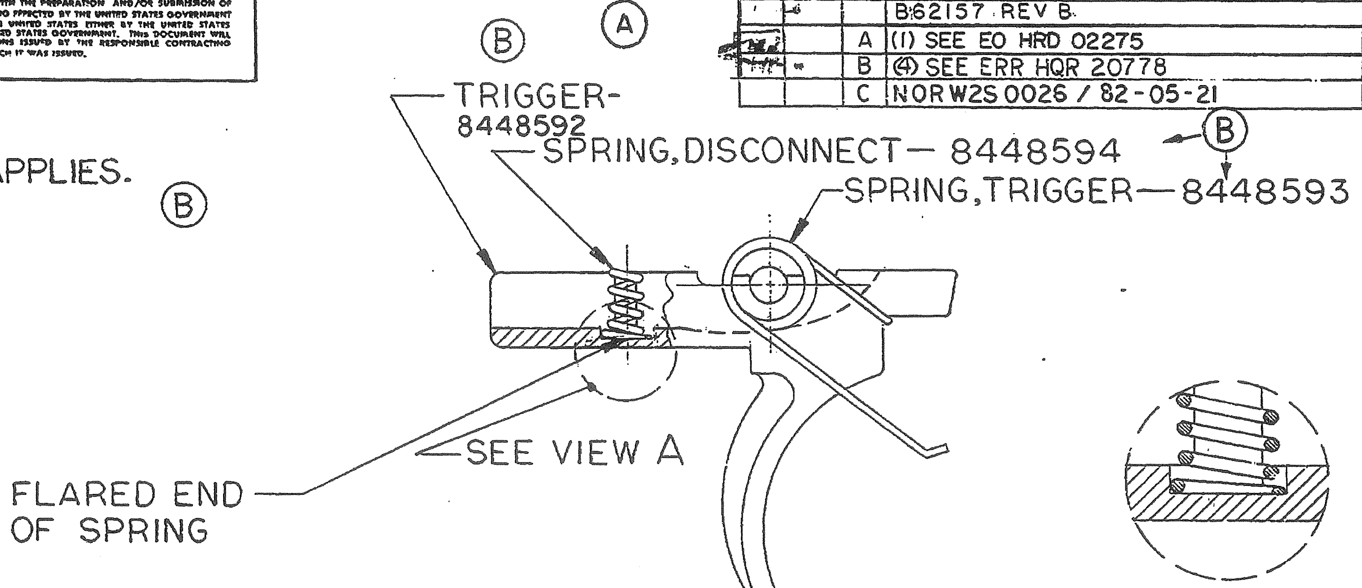
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B62157 REV B	27 APR 70	
		A	(1) SEE EO HRD 02275	15 OCT 70	J.P. Gillooly
		B	④ SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NOR W2S 0026 / 82-05-21	83-02-03	[illegible]

B8448591

NOTES:

1. MIL-W-13855 APPLIES. Ⓑ



VIEW A
SCALE-NONE

Ⓑ SEE PL-8448591

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		F8448604	M16
BH		F8448578	M16A1
		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO	
DATE	27 APR 1970
PREP	B.H. A.J.A.
CHK	[illegible]
ENGR	[illegible] D. Billet
SUBMITTED	F. P. Gillooly
APPROVED	R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

TRIGGER ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448591

SCALE	2/1		SHEET		OF	

CDI

AMSWE Form 403B, 29 Jul 69

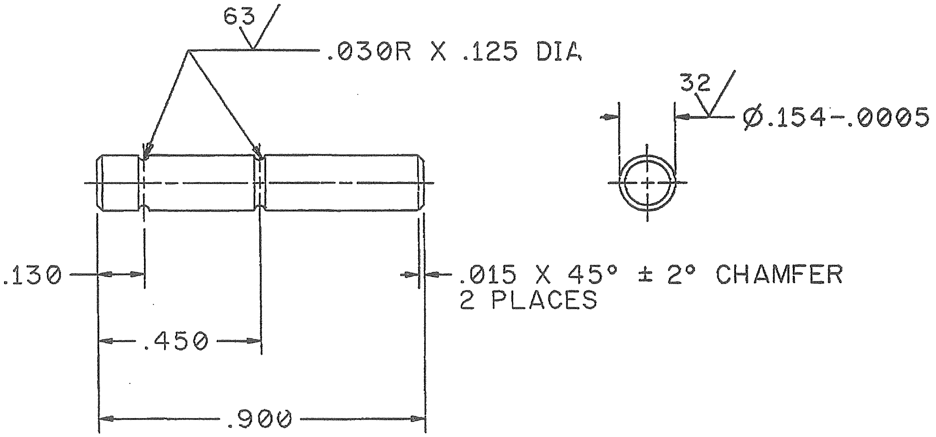
October 13, 2004 3:15 PM

DRAWING SIZE C 4 3 2 1

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	H	NOR G3S2032/930817 (ECP G3S3093/930910)	931108	RJC

NOTE:

1. FINISHED $^{125}\surd$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES.
6. MATERIAL: COLD FINISHED ALLOY STEEL BAR, GRADE 4130 OR 4140, ASTM A331, COLD HEADING QUALITY.



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CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448609

PMIC			
MECHANICAL PROPERTIES			
YP			
TS		9390011	M4
EL2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH	15N 72.5-76	APPLICATION	

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ±.005

THIRD ANGLE PROJECTION

MATL ENGR
CADDS REV A 634

CONTRACT NUMBER
CONTRACTOR

DRAWN BY PEM	DATE(YR-MO-DA) 700427
CHECKER DHW	ENGINEER D. SMART
DRAWING APPROVAL F. P. GILHOOLY	
DESIGN APPROVAL R. S. HENRY	

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND ILLINOIS, 61201

PIN, HAMMER & TRIGGER

SIZE	CAGE CODE	
C	19204	8448609
SCALE 4/1	UNIT WT.	SHEET

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASONC-AR OR HIGHER DOD AUTHORITY: 92-06-22.

SMCAR FORM 67, 1 DEC 87(TEMP), REPLACES SMCAR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

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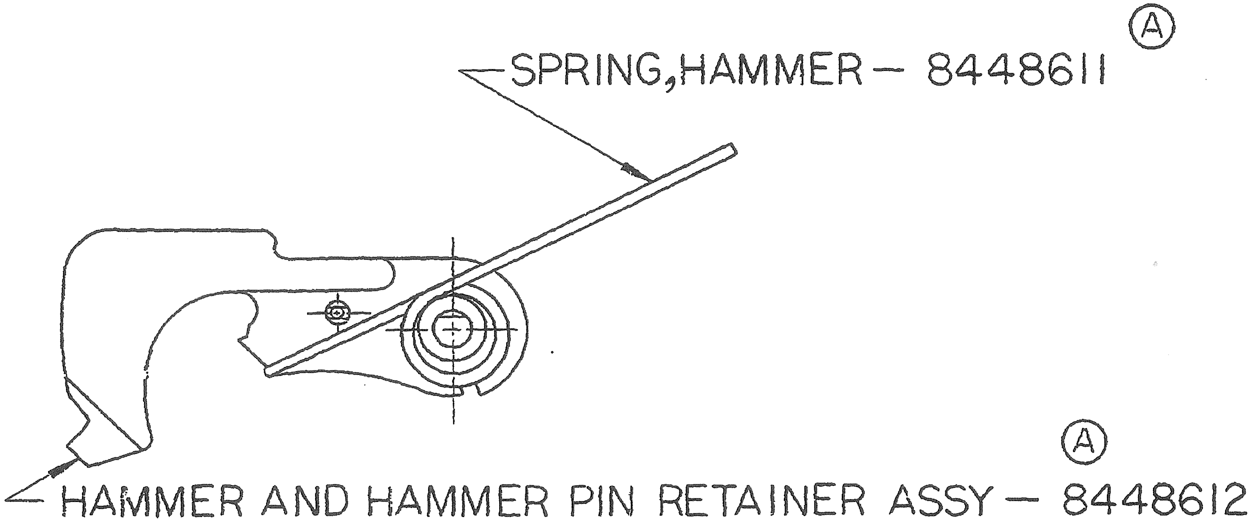
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62117 REV A	27 APR 70	
		A	(4) SEE ERR HQR 20778	6 OCT 72	R.E.

B8448610

NOTES:

1. MIL-W-13855 APPLIES. Ⓐ



Ⓐ

SEE PL – 8448610

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——
MATERIAL ——
FINAL PROTECTIVE FINISH ——

CONTRACT NO.		
DATE	27 APR 1970	
PREP	GEW	a.g.A
CHK	DDH	
ENGR	D. Smart	D. Billiet
SUBMITTED		
APPROVED	R.S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 6,20;

HAMMER ASSY

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448610

SCALE 2/1 SHEET 1 OF 1

3

October 13, 2004 3:13 PM

DRAWING SIZE D

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REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	K	NOR G5S2015 950524	950801	RLV

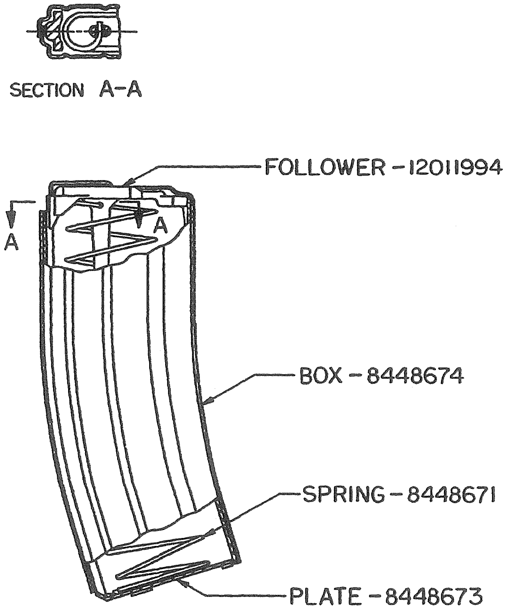
NOTES:

1. MIL-W-13855 APPLIES.
2. SPRING FORCE WITH FOLLOWER DEPRESSED .250 INCH SHALL 3.0 LBS.±.5 LB.
3. EACH MAGAZINE ASSEMBLY SHALL BE CAPABLE OF WITHSTANDING A 30 ROUND FUNCTION FIRING TEST WITHOUT MALFUNCTIONING IN THE FOLLOWING WEAPONS:

   A – M16A2 (9349000), M16A1 (8448500), M16 (8448600) OR M4 CARBINE (9390000) UTILIZING THE BOLT CATCH CONFIGURATION OF DRAWING D8448628 REV A OR LATER.

   B – M231 FPW (9327045) UTILIZING THE CONFIGURATION OF DRAWING D9327059 AND USING M193 BALL AMMUNITION.

   AFTER FIRING THE 30TH ROUND FROM THE MAGAZINE, THE MAGAZINE FOLLOWER SHALL ACTUATE THE WEAPON BOLT CATCH TO HOLD THE BOLT IN THE OPEN POSITION.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SEE SEPARATE PARTS LIST - 8448670

PART NO. 8448670

PMIC		
MECHANICAL PROPERTIES	9390000	M4
	9349000	M16A2
YP	9327045	M231 FPW
TS	8448600	M16
EL2	8448500	M16A1
RA	NEXT ASSY	USED ON
BH	APPLICATION	
RH		

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ±
THIRD ANGLE PROJECTION
MATL ENGR

CONTRACT NUMBER
CONTRACTOR
DRAWN BY RJC
DATE (YR-MO-DA) 700605
CHECKER J BRENNAN
ENGINEER
DRAWING APPROVAL F. GILHOOLY
DESIGN APPROVAL R. S. HENRY

DESIGN ACTIVITY ROCK ISLAND ARSENAL
ROCK ISLAND, IL

MAGAZINE ASSY,
30 ROUND

SIZE	CAGE CODE	
D	19204	8448670
SCALE 1/1	UNIT WT.	SHEET

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL, ASQNC-AR; 911025.

SMCAR FORM 68, 1 DEC 87(TEMP), REPLACES SMCAR FORM 68, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

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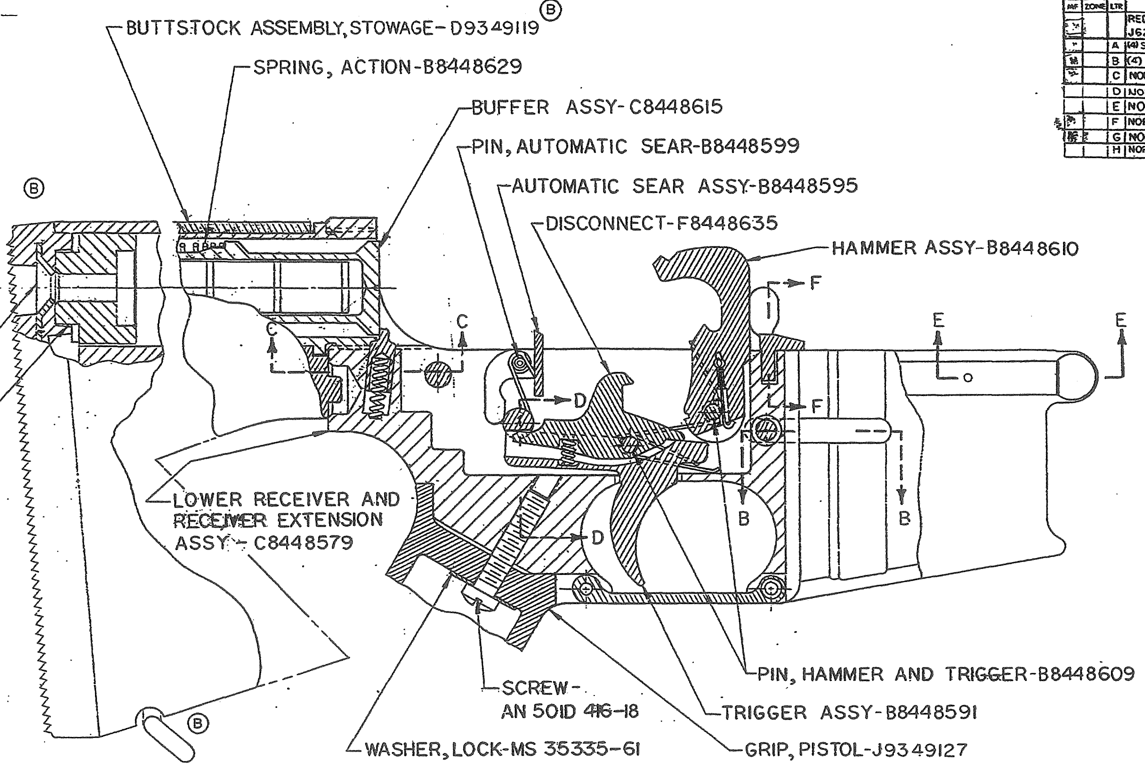
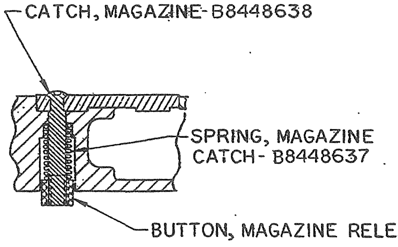
NOTE:

1. APPLY LUBRICANT, MIL-L-46000 AT ASSY OVER A. Ⓐ
2. MIL-W-13855 APPLIES. Ⓑ

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62272 REV. C	27 APR 70	
		A	(4) SEE EO HRD 02197—3	15 JUL 70	
		B	(4) SEE ERR HQR-10822	9 AUG 71	
		C	NORW2S0020 82 06 09	830203	LAM
		D	NOR W2S0026 82-05-21	83-09-22	
		E	NOR W5S8004/860204	890215	
		F	NOR G9S2027, 89-07-06	90-06-12	
		G	NOR G2S9510/920514	920522	
		H	NOR G3S3058/930701	930831	

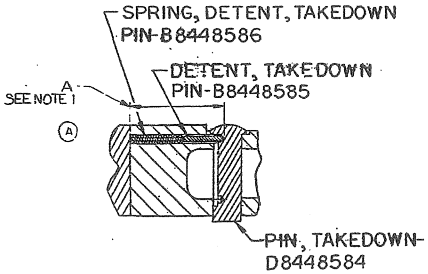


BUTTSTOCK ASSEMBLY, STOWAGE-D9349119 Ⓑ
SPRING, ACTION-B8448629
BUFFER ASSY-C8448615
PIN, AUTOMATIC SEAR-B8448599
AUTOMATIC SEAR ASSY-B8448595
DISCONNECT-F8448635
HAMMER ASSY-B8448610
Ⓑ
F
F
E
E
C
C
D
D
B
B
SCREW, BUTT CAP-C9349128
TORQUE TO 35 LB IN.±5 LB IN.
SPACER, BUTT CAP-C12597640
LOWER RECEIVER AND RECEIVER EXTENSION ASSY-C8448579
PIN, HAMMER AND TRIGGER-B8448609
SCREW-AN 501D 416-18
TRIGGER ASSY-B8448591
WASHER, LOCK-MS 35335-61
GRIP, PISTOL-J9349127
Ⓑ



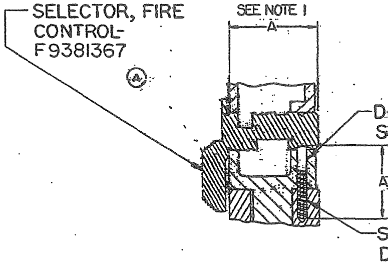
CATCH, MAGAZINE-B8448638
SPRING, MAGAZINE CATCH-B8448637
BUTTON, MAGAZINE RELEASE-C8448636

SECTION B-B



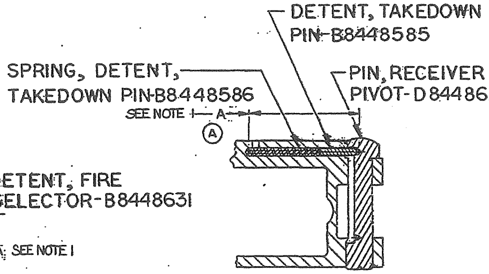
SPRING, DETENT, TAKEDOWN PIN-B8448586
A
SEE NOTE 1
Ⓐ
DETENT, TAKEDOWN PIN-B8448585
PIN, TAKEDOWN-D8448584

SECTION C-C



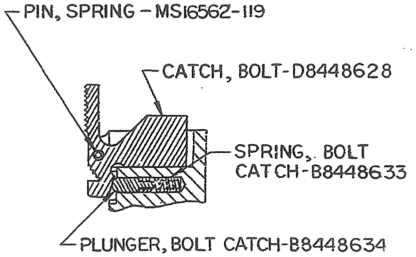
SELECTOR, FIRE CONTROL-F9381367
Ⓐ
SEE NOTE 1
A
DETENT, FIRE SELECTOR-B8448631
A SEE NOTE 1
SPRING, SELECTOR DETENT-C8448516

SECTION D-D



DETENT, TAKEDOWN PIN-B8448585
SPRING, DETENT, TAKEDOWN PIN-B8448586
PIN, RECEIVER PIVOT-D8448621
SEE NOTE 1 A
Ⓐ

SECTION E-E



PIN, SPRING-MS16562-119
CATCH, BOLT-D8448628
SPRING, BOLT CATCH-B8448633
PLUNGER, BOLT CATCH-B8448634

SECTION F-F

SEE EPL-8448578

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 3 PLACE DECIMALS ± 2 PLACE DECIMALS ±	CONTRACT NO:	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201
YS MIN				DATE 27 APR 1970	LOWER RECEIVER AND BUTTSTOCK ASSY
YS MAX			MATERIAL	PREPARED G.R.	
EL 2				CHECKED	
RA				ENGINEER	
BHN	F8448500	M16A1		SUBMITTED F. P. McGillbory	SIZE F · CODE IDENT NO. 19204 · DRAWING NO. 8448578
RN	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED	SCALE 2/1 · SHEET 1 OF 1
	APPLICATION				

DISTRIBUTION STATEMENT E.
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY: 921025.

AMSWE Form 403F, 29 Jul 69

CDR

October 13, 2004 2:47 PM

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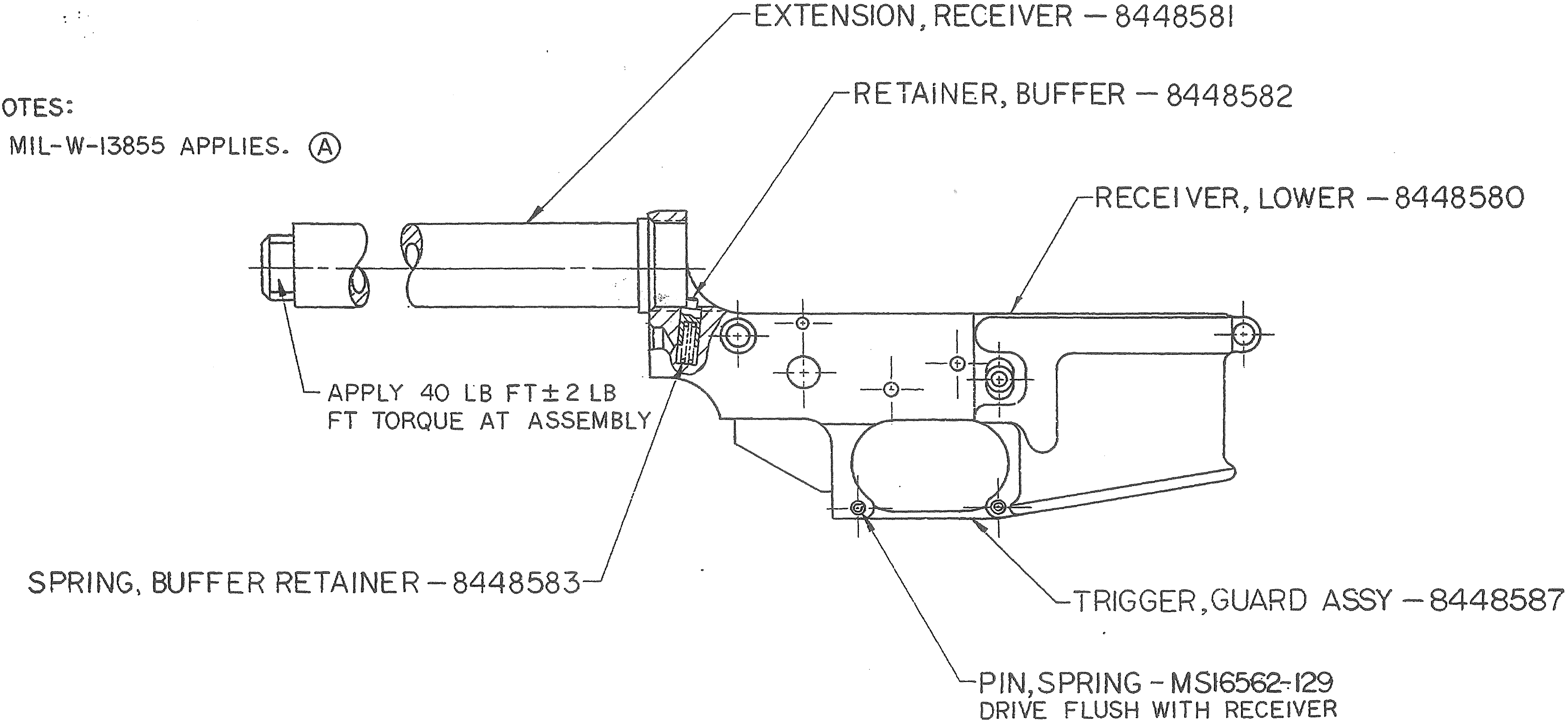
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62273 REV A	27 APR 70	
		A	SEE ERR HQR 20778	6 OCT 72	R.E.
		B	NORW2S0020 82-06-09	83 02 03	LAH
		C	NOR W2S 0026 82-05-21	83-09-22	

NOTES:

1. MIL-W-13855 APPLIES. Ⓐ



EXTENSION, RECEIVER — 8448581
RETAINER, BUFFER — 8448582
RECEIVER, LOWER — 8448580
APPLY 40 LB FT ± 2 LB FT TORQUE AT ASSEMBLY
SPRING, BUFFER RETAINER — 8448583
TRIGGER, GUARD ASSY — 8448587
PIN, SPRING — MS16562-129
DRIVE FLUSH WITH RECEIVER

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL-8448579

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		F8448578	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO:

DATE 27 APR 1970

PREPARED	R.A.R.	S.A.
CHECKED	D.A.H.	
ENGINEER	S. Smart	B. Billiet
SUBMITTED	F.P. Gilhooly	
APPROVED	R.S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

LOWER RECEIVER AND RECEIVER EXTENSION ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448579

SCALE 1/1 SHEET 1 OF 1

CDI

C 8448579

AMSWE Form 403C, 29 Jul 69

October 13, 2004 3:19 PM

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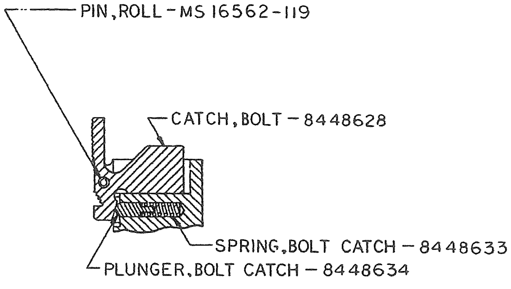
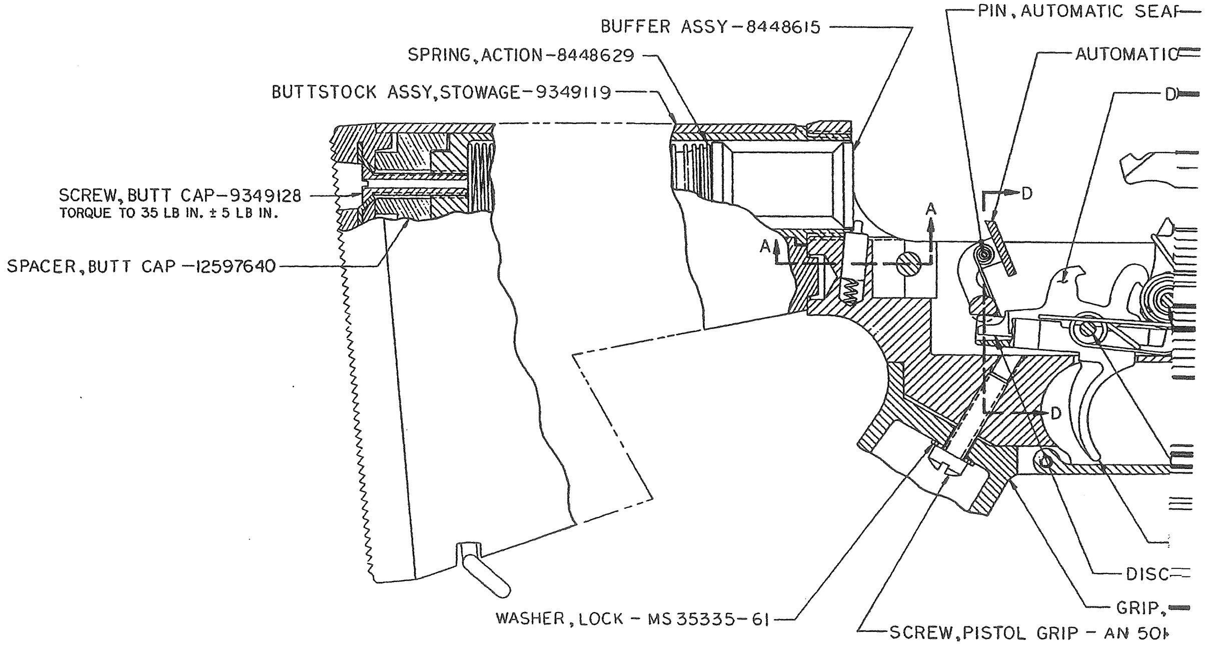
NOTES:-

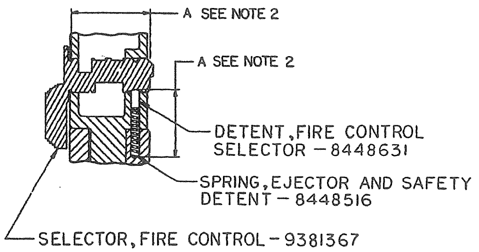
1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 - APPLY MIL-L-46000 (LSA) OR MIL-L-63460 (CLP) AT ASSEMBLY OVER A.

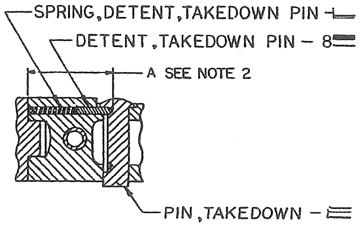

PIN, ROLL - MS 16562-119
CATCH, BOLT - 8448628
SPRING, BOLT CATCH - 8448633
PLUNGER, BOLT CATCH - 8448634

SECTION C-C


BUFFER ASSY - 8448615
SPRING, ACTION - 8448629
BUTTSTOCK ASSY, STOWAGE - 9349119
SCREW, BUTT CAP - 9349128
TORQUE TO 35 LB IN. ± 5 LB IN.
SPACER, BUTT CAP - 12597640
PIN, AUTOMATIC SEAF
AUTOMATIC
D
D
D
A
A
WASHER, LOCK - MS 35335-61
SCREW, PISTOL GRIP - AN 50
DISC
GRIP,


A SEE NOTE 2
A SEE NOTE 2
DETENT, FIRE CONTROL SELECTOR - 8448631
SPRING, EJECTOR AND SAFETY DETENT - 8448516
SELECTOR, FIRE CONTROL - 9381367

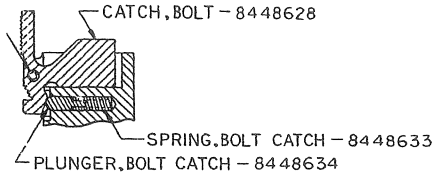
SECTION D-D


SPRING, DETENT, TAKEDOWN PIN -
DETENT, TAKEDOWN PIN - 8
A SEE NOTE 2
PIN, TAKEDOWN -

SECTION A-A

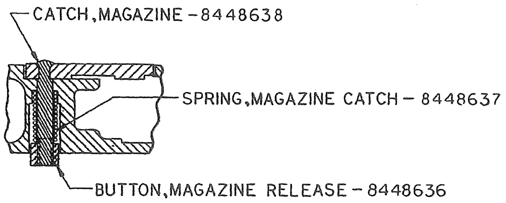
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S0020 82-06-09	83 02 03	
B	NORW3S3148/83-11-14	84-01-27	ESB
C	NORW4S0030/84-11-15	850402	
D	NOR G7S9452 870722	880119	
E	NOR W5S8004/860204	890215	
F	NOR G3S3058/930701	930831	
G	NOR G6S3117 / 960719	961204	FET

PIN,ROLL-MS 16562-119



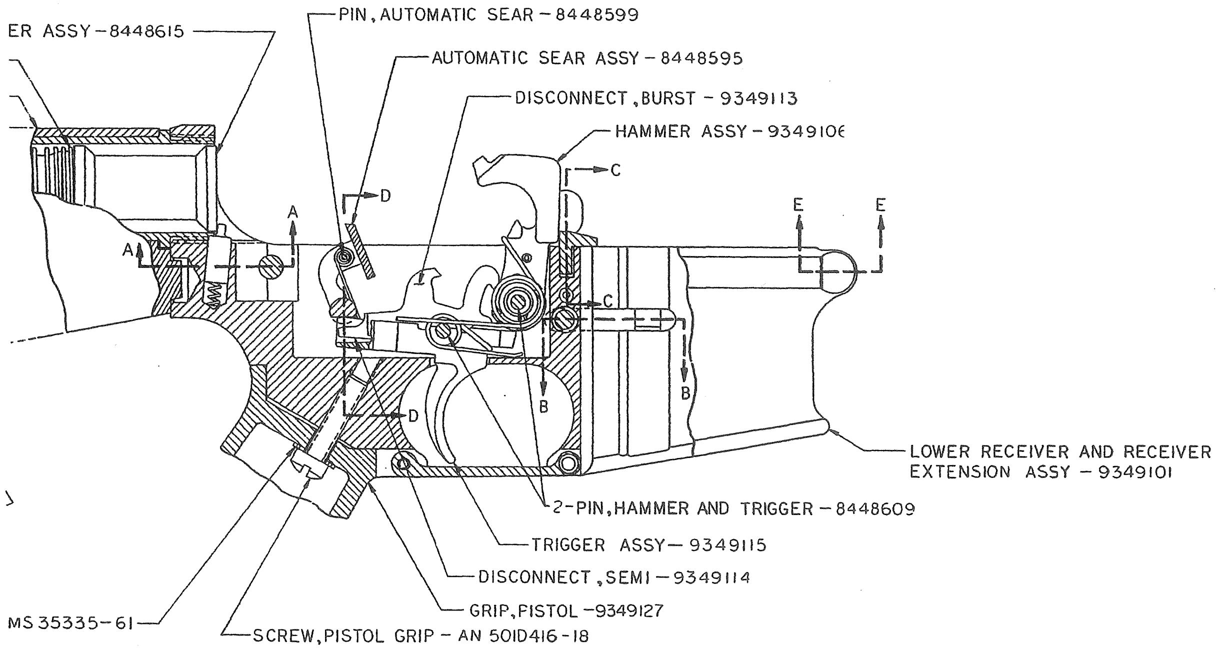
CATCH,BOLT-8448628
SPRING,BOLT CATCH-8448633
PLUNGER,BOLT CATCH-8448634

SECTION C-C

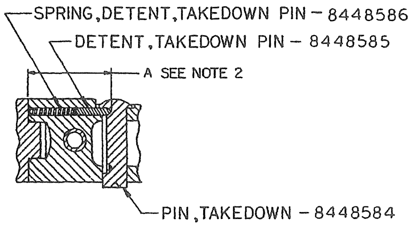


CATCH,MAGAZINE-8448638
SPRING,MAGAZINE CATCH-8448637
BUTTON,MAGAZINE RELEASE-8448636

SECTION B-B



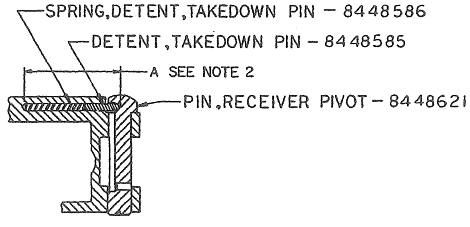
PIN,AUTOMATIC SEAR-8448599
ER ASSY-8448615
AUTOMATIC SEAR ASSY-8448595
DISCONNECT,BURST-9349113
HAMMER ASSY-9349106
C
D
A
A
E
E
C
B
B
D
LOWER RECEIVER AND RECEIVER EXTENSION ASSY-9349101
2-PIN,HAMMER AND TRIGGER-8448609
TRIGGER ASSY-9349115
DISCONNECT,SEMI-9349114
GRIP,PISTOL-9349127
MS 35335-61
SCREW,PISTOL GRIP-AN 501D416-18



SPRING,DETENT,TAKEDOWN PIN-8448586
DETENT,TAKEDOWN PIN-8448585
A SEE NOTE 2
PIN,TAKEDOWN-8448584

AFETY

SECTION A-A



SPRING,DETENT,TAKEDOWN PIN-8448586
DETENT,TAKEDOWN PIN-8448585
A SEE NOTE 2
PIN,RECEIVER PIVOT-8448621

SECTION E-E

FOR ENGINEERING PARTS LIST SEE PL9349100

PART NO. 9349100

9349000	M16A2	MECHANICAL PROPERTIES	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS · FRACTIONS · ANGLES ·
NEXT ASSY	USED ON	YP TS EL RA BH BH	
APPLICATION			

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN EJZ
CHECKER NEW
ENGR
ENGR
ENGR
ENGR

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

LOWER RECEIVER AND BUTTSTOCK ASSY

SIZE J FSCM NO. 19200 9349100
SCALE 2/1 UNIT WT SHEET 1 OF 1

9349100

J9349100 REV G F-2/2

DRAWING SIZE D
(ARRADCOMR 70-12)

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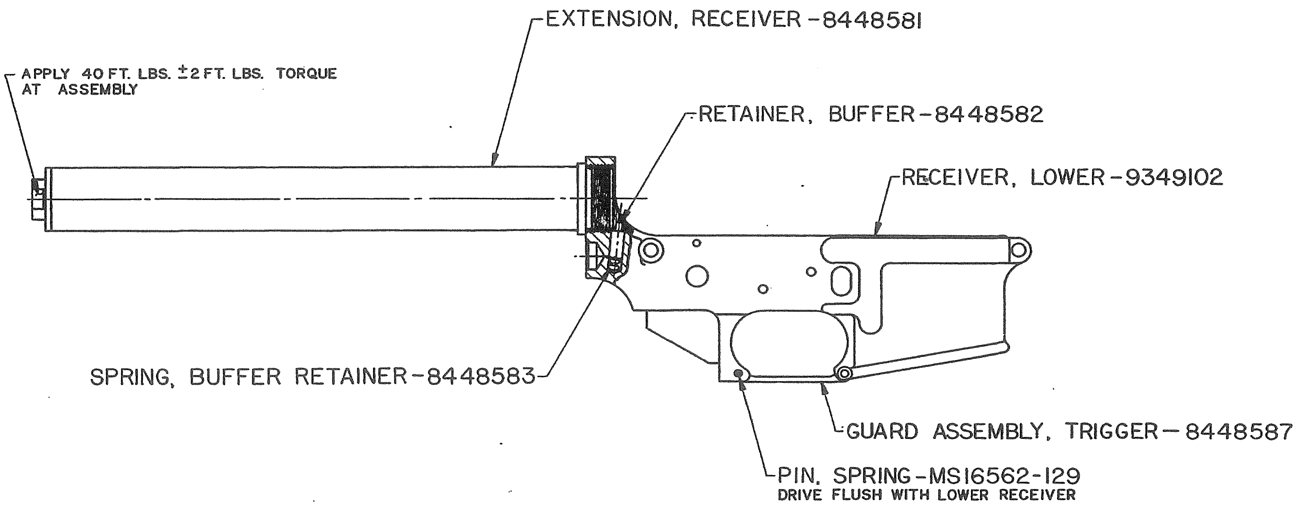
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S0030/84-11-15	850402	

NOTES:—

1— SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.



EXTENSION, RECEIVER-8448581
APPLY 40 FT. LBS. ±2 FT. LBS. TORQUE AT ASSEMBLY
RETAINER, BUFFER-8448582
RECEIVER, LOWER-9349102
SPRING, BUFFER RETAINER-8448583
GUARD ASSEMBLY, TRIGGER-8448587
PIN, SPRING-MS16562-129
DRIVE FLUSH WITH LOWER RECEIVER

FOR ENGINEERING PARTS LIST SEE PL9349101

PART NO. 9349101

9349100	M16A1E1
NEXT ASSY	USED ON
APPLICATION	

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN MM
CHECKER JWH
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

LOWER RECEIVER AND RECEIVER
EXTENSION ASSEMBLY

SIZE D
FSCM NO 19200
9349101
SCALE 1/1
UNIT WT.
SHEET 1 OF 1

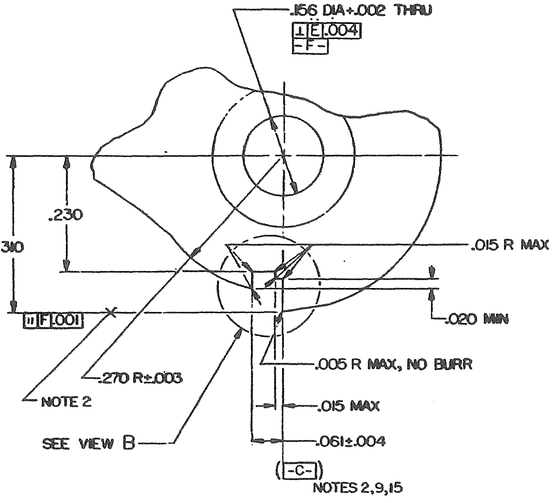
ARRADCOM FORM 60 AUG 77 REPLACES ARPA FORM 1041 NOV 72 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 7:09 AM

NOTICE RESTRICTED AS TO USE AND DISCLOSURE

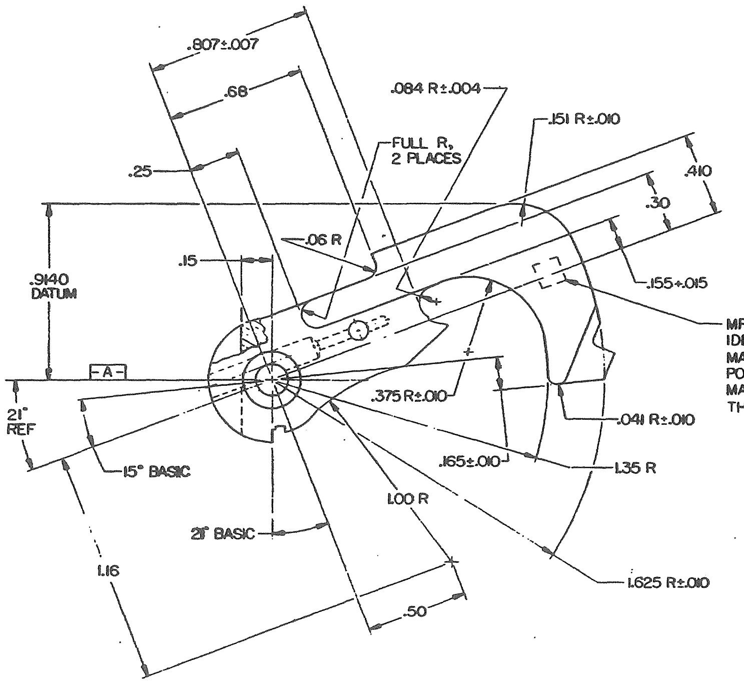
[illegible]

			REVISIONS		
	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV(A) W/CHANGE SEE EO HQR-10651	20 FEB 71	
		C	(4) SEE ERR HQR 20778	6 OCT 72	R.L
		D	NOR W2S 0026 / 82-05-21	83-02-03	
		G	NOR G2S3033/ 92-04-08	92-05-19	CF
		H	NOR G2S3102 / 92 1110	930128	GHS
		J	NOR G3S3009 930303	930401	



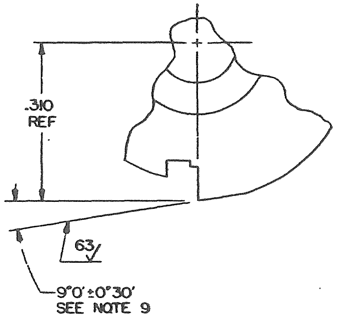
.156 DIA+.002 THRU
⊥ E .004
-F-
.230
.310
.015 R MAX
.020 MIN
⫽ F .001
.270 R±.003
NOTE 2
.005 R MAX, NO BURR
.015 MAX
SEE VIEW B
.061±.004
(-C-)
NOTES 2,9,15

VIEW A-A
SCALE 10/1



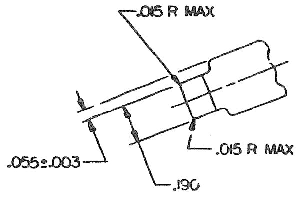
.807±.007
.68
.084 R±.004
FULL R, 2 PLACES
.151 R±.010
.410
.25
.30
.06 R
.9140 DATUM
.15
.155±.015
MFG. IDENT SYMBOL AND CAVITY IDENT MARK .125±.015 HIGH, .005 MAX NEGATIVE ONLY IN APPROX POSITION SHOWN, EITHER SIDE. MARKS TO BE APPROVED BY THE GOVT.
Ⓒ
-A-
21° REF
.375 R±.010
.041 R±.010
15° BASIC
.165±.010
1.35 R
1.00 R
21° BASIC
1.16
1.625 R±.010
.50

VIEW D-D



.310 REF
63
9°0'±0°30'
SEE NOTE 9

VIEW B
SCALE 10/1



.015 R MAX
.055±.003
.015 R MAX
.190

VIEW C-C

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; DATE OF DETERMINATION: 92-03-18.

CURRENT DESIGN ACTIVITY FSCM NO.19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES
YS MIN
YS MAX
EL 2
RA
BHN
BHN

NEXT ASSY
USED ON
APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO

DATE 27 APR 70
PREPARED T A Wilson
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HAMMER

SIZE F
CODE IDENT NO 19204
DRAWING NO 8448613
SCALE 4/1
SHEET 2 OF 2

F 8448613

October 18, 2004 7:15 AM

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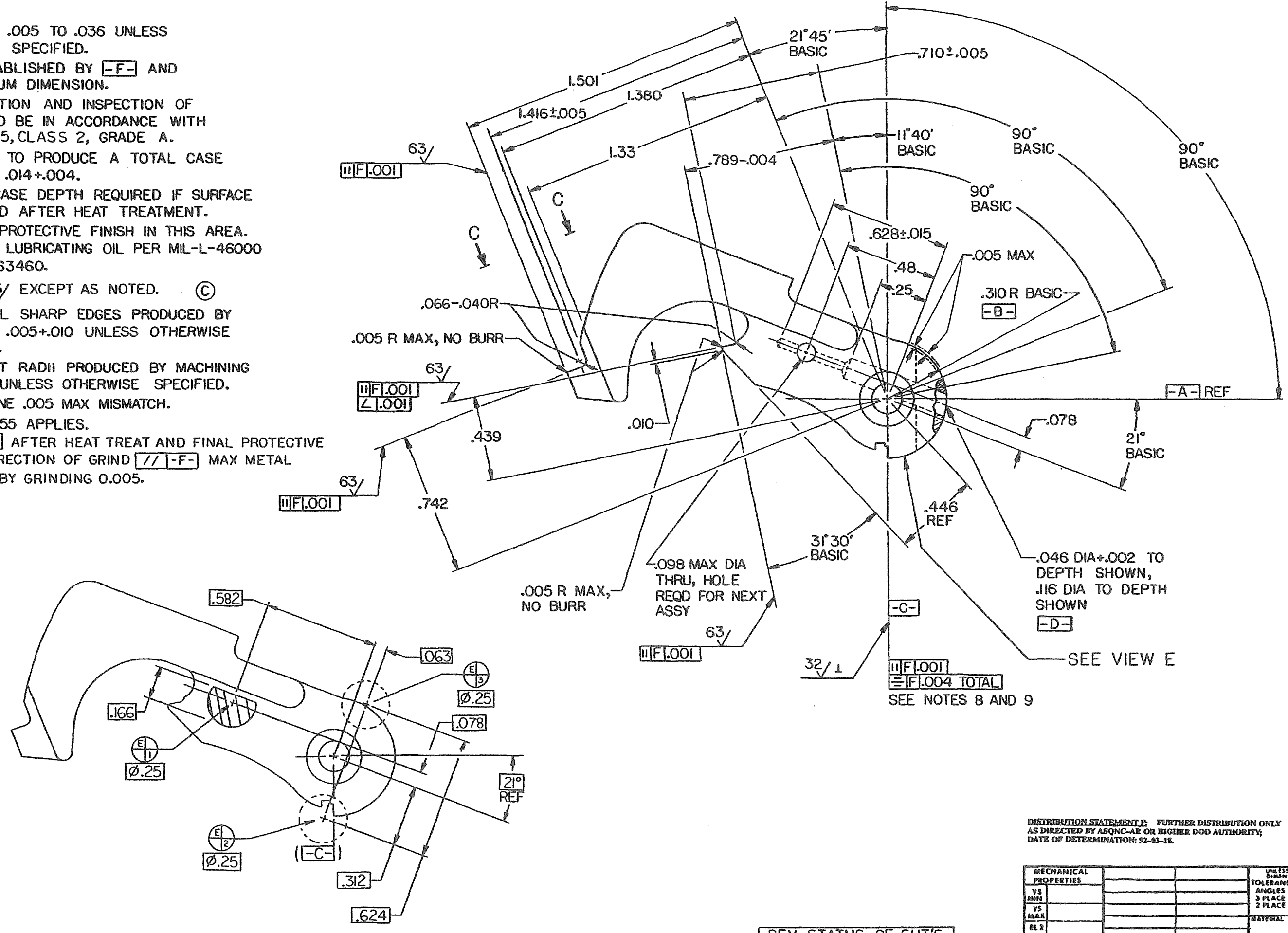
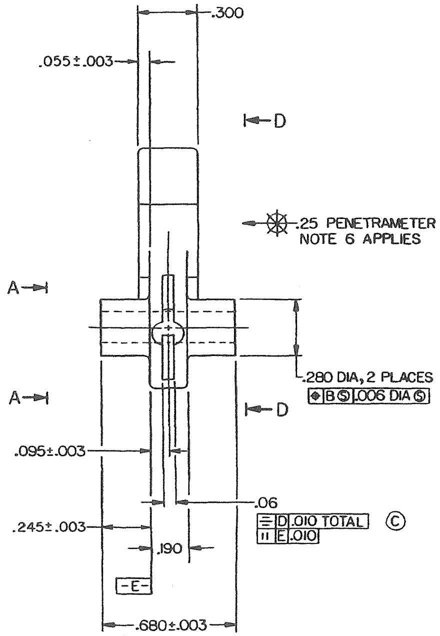
REVISIONS					
MP	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV(A) W/CHANGE SEE EO HQR-10651	20 FEB 71	
		C	(4) SEE ERF HQR 20778	6 OCT 72	RC
		D	NOR W2S0026 / 82-05-21	83-02-03	
		E	NOR W5S2099/ 85-11-21	860708	
		F	ERR Z9Z1251 AD (ECP W6S3044/860812)	900309	
		G	NOR G2S3033/92-04-08	92-05-19	CF AL
		H	NOR G2S3102/921110	930128	GHS
		J	NOR G3S3009 930303	930401	
		K	NOR G6S3117 / 960719	961204	FET

NOTES:

1. STEEL, INVESTMENT CASTING, CMPSN IC 4620 OR IC 8620, SPEC MIL-S-22141, EXCEPT THAT MANGANESE CONTENT SHALL BE .70 TO 1.20%. Ⓒ
2. ALL DIMENSIONS ARE BEFORE FINAL PROTECTIVE FINISH EXCEPT THOSE DEFINING -C-.
3. FILLET RADII .026+.010 UNLESS OTHERWISE SPECIFIED.
4. EDGE RADII .005 TO .036 UNLESS OTHERWISE SPECIFIED.
5. -A- ESTABLISHED BY -F- AND .9140 DATUM DIMENSION.
6. CLASSIFICATION AND INSPECTION OF CASTING TO BE IN ACCORDANCE WITH MIL-STD-2175, CLASS 2, GRADE A.
7. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014+.004.
8. .009 MIN CASE DEPTH REQUIRED IF SURFACE IS MACHINED AFTER HEAT TREATMENT.
9. NO FINAL PROTECTIVE FINISH IN THIS AREA. COAT WITH LUBRICATING OIL PER MIL-L-46000 OR MIL-L-63460.
10. FINISH 125/ EXCEPT AS NOTED. Ⓒ
11. BREAK ALL SHARP EDGES PRODUCED BY MACHINING .005+.010 UNLESS OTHERWISE SPECIFIED.
12. ALL FILLET RADII PRODUCED BY MACHINING .003+.012 UNLESS OTHERWISE SPECIFIED.
13. PARTING LINE .005 MAX MISMATCH.
14. MIL-W-13855 APPLIES.
15. GRIND -C- AFTER HEAT TREAT AND FINAL PROTECTIVE FINISH. DIRECTION OF GRIND // -F- MAX METAL REMOVED BY GRINDING 0.005.


21°45' BASIC
.710±.005
1.501
1.416±.005
1.380
1.33
.789-.004
11°40' BASIC
90° BASIC
90° BASIC
90° BASIC
63/
II F .001
C
C
.628±.015
.48
.25
.005 MAX
.310 R BASIC
-B-
.066-.040R
.005 R MAX, NO BURR
63/
II F .001
∠ .001
.010
.439
-A- REF
.078
21° BASIC
63/
II F .001
.742
.446 REF
31°30' BASIC
.098 MAX DIA THRU, HOLE REQD FOR NEXT ASSY
.005 R MAX, NO BURR
63/
II F .001
.046 DIA+.002 TO DEPTH SHOWN, .116 DIA TO DEPTH SHOWN
-D-
-C-
32/⊥
II F .001
≡ F .004 TOTAL
SEE NOTES 8 AND 9
SEE VIEW E
.582
.063
E 3
Ø.25
.078
.166
E 1
Ø.25
21° REF
E 2
Ø.25
(-C-)
.312
.624

VIEW E
DATUM TARGET LOCATION


.300
.055±.003
D
.25 PENETRAMETER NOTE 6 APPLIES
A
A
.280 DIA, 2 PLACES
⌖ B Ⓢ .006 DIA Ⓢ
D
.095±.003
.06
≡ D .010 TOTAL Ⓒ
II E .010
.245±.003
.190
-E-
.680±.003

REV STATUS OF SHT'S	
SH 1	SH 2
K	J

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; DATE OF DETERMINATION: 92-03-18.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA				
BH			M16,	
		C8448612	M16A1	
RH	15N 89-91	NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171

CONTRACT NO

DATE 27 APR 70

PREPARED		T A Wilkinson
CHECKED	E L Fossey	
ENGINEER		
SUBMITTED	F P Gillooly	
APPROVED	D. A. Cole	

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HAMMER

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448613

SCALE 4/1 SHEET 1 OF 2

Ⓒ

F8448613

5 4 3 2 1

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778	6 OCT 72	LB
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)	83-11-04	
		F	ERR ~~Z9~~Z1251W (ECP G9S2036/890721)	900403	ORFL-CHT
		G	NOR G1S2018 91-07-08	91-10-11	RR SL

B8448516

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC ASTM-A228. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ± 25° FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003+.012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0240 ± .0003
COIL DIAMETER (O.D)	.103 ± .003
FREE LENGTH AFTER SETTING	.926 REF
TOTAL COILS	27 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .850	2.94 LB ± .30 LB
LOAD AT COMPRESSED LENGTH OF .784	5.50 LB ± .25 LB
SPRING RATE	
SOLID LENGTH	.650 MAX
TYPE OF ENDS	SQUARED, GROUND

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

CURRENT

FSCM NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448516

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		8448509	M4
YS MAX		F9327230	M 231
EL 2			M16
RA		C8448509	M16A1
BH		F8448604	M16
RH		F8448578	M16A1
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1.

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 27 APR 70

PREP	P.V.	L.P.
CHK	G.D.	D.K.
ENGR	R.E.	L.B.

SUBMITTED
A.A. COLE

APPROVED
R.S. HENRY

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

SPRING, EJECTOR AND SAFETY DETENT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448516

SCALE NONE SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

SCANNED DUPLICATE ORIGINAL

October 18, 2004 10:55 AM

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D	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL SR

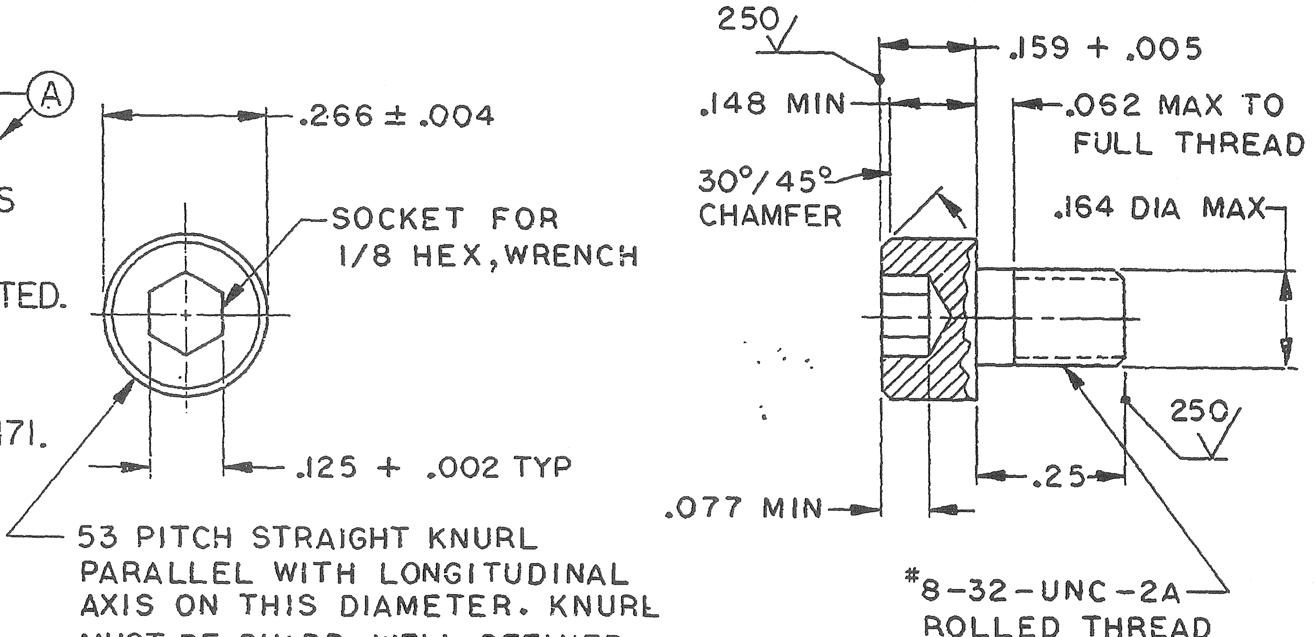
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C92201 REVISION A	27 APR 70	
		A	(4) SEE ERR HQR 20778	6 OCT 72	R.E.
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G1S2018 91-07-03	91-10-11	

B8448508

NOTES:

1. STEEL, CMPSN 4037, SPEC ASTM A322. Ⓐ
2. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
3. FINISH 125√ EXCEPT AS NOTED.
4. BREAK ALL SHARP EDGES .005+.005.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES. Ⓐ



53 PITCH STRAIGHT KNURL PARALLEL WITH LONGITUDINAL AXIS ON THIS DIAMETER. KNURL MUST BE SHARP, WELL DEFINED AND TO FULL DEPTH

Ⓐ

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

CURRENT
CODE IDENT NO.
19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		8448505	M4
EL 2			M16
RA		C8448505	M16A1
BH		NEXT ASSY	USED ON
RH	15N 78.5-83	APPLICATION	

Ⓐ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SCREW, CAP,
HEX SOCKET HEAD

SIZE	CODE IDENT NO	DRAWING NO.
B	19204	8448508

SCALE 5/1 SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

October 18, 2004 10:53 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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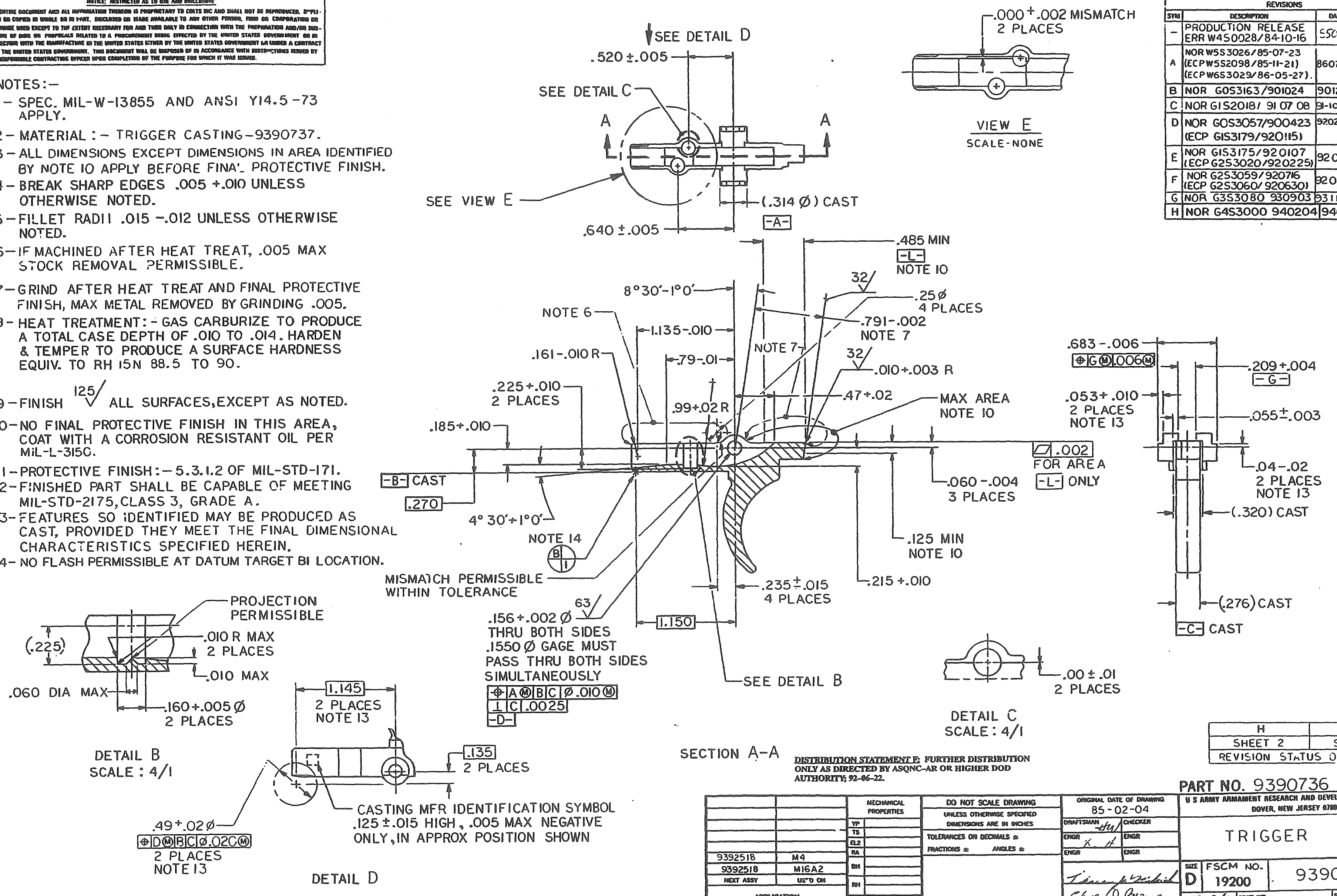
NOTES:–

1– SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2– MATERIAL:– TRIGGER CASTING–9390737.
3– ALL DIMENSIONS EXCEPT DIMENSIONS IN AREA IDENTIFIED BY NOTE 10 APPLY BEFORE FINAL PROTECTIVE FINISH.
4– BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE NOTED.
5– FILLET RADII .015 –.012 UNLESS OTHERWISE NOTED.
6– IF MACHINED AFTER HEAT TREAT, .005 MAX STOCK REMOVAL PERMISSIBLE.
7– GRIND AFTER HEAT TREAT AND FINAL PROTECTIVE FINISH, MAX METAL REMOVED BY GRINDING .005.
8– HEAT TREATMENT:– GAS CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .010 TO .014. HARDEN & TEMPER TO PRODUCE A SURFACE HARDNESS EQUIV. TO RH 15N 88.5 TO 90.
9– FINISH $\sqrt{125}$ ALL SURFACES, EXCEPT AS NOTED.
10– NO FINAL PROTECTIVE FINISH IN THIS AREA, COAT WITH A CORROSION RESISTANT OIL PER MIL-L-3150.
11– PROTECTIVE FINISH:– 5.3.1.2 OF MIL-STD-171.
12– FINISHED PART SHALL BE CAPABLE OF MEETING MIL-STD-2175, CLASS 3, GRADE A.
13– FEATURES SO IDENTIFIED MAY BE PRODUCED AS CAST, PROVIDED THEY MEET THE FINAL DIMENSIONAL CHARACTERISTICS SPECIFIED HEREIN.
14– NO FLASH PERMISSIBLE AT DATUM TARGET B1 LOCATION.


8
7
6
5
4
3
2
1
T
D
C
B
A
SEE DETAIL D
.520 ±.005
SEE DETAIL C
A
A
SEE VIEW E
(.314 Ø) CAST
-A-
.640 ±.005
.000 +.002 MISMATCH
2 PLACES
VIEW E
SCALE-NONE
.485 MIN
-L-
NOTE 10
32
.25 Ø
4 PLACES
8°30′-1°0′
NOTE 6
.791-.002
NOTE 7
1.135-.010
NOTE 7
.161-.010 R
.79-.01
32
.010+.003 R
.225+.010
2 PLACES
.99+.02 R
.47+.02
MAX AREA
NOTE 10
.185+.010
.002
FOR AREA
-L- ONLY
-B- CAST
.270
.060-.004
3 PLACES
4° 30′+1°0′
NOTE 14
B
1
.125 MIN
NOTE 10
MISMATCH PERMISSIBLE
WITHIN TOLERANCE
.235 ±.015
4 PLACES
.215 +.010
63
.156 +.002 Ø
THRU BOTH SIDES
.1550 Ø GAGE MUST
PASS THRU BOTH SIDES
SIMULTANEOUSLY
⌖ A Ⓜ B C Ø.010 Ⓜ
⊥ C .0025
-D-
1.150
SEE DETAIL B
SECTION A-A
.683-.006
⌖ G Ⓜ .006 Ⓜ
.209+.004
-G-
.053+.010
2 PLACES
NOTE 13
.055±.003
.04-.02
2 PLACES
NOTE 13
(.320) CAST
(.276) CAST
-C- CAST
.00 ± .01
2 PLACES
DETAIL C
SCALE: 4/1
PROJECTION
PERMISSIBLE
(.225)
.010 R MAX
2 PLACES
.010 MAX
.060 DIA MAX
.160+.005 Ø
2 PLACES
DETAIL B
SCALE: 4/1
1.145
2 PLACES
NOTE 13
.135
2 PLACES
CASTING MFR IDENTIFICATION SYMBOL
.125 ±.015 HIGH, .005 MAX NEGATIVE
ONLY, IN APPROX POSITION SHOWN
.49+.02 Ø
⌖ D Ⓜ B C Ø.02 C Ⓜ
2 PLACES
NOTE 13
DETAIL D

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERR W4S0028/84-10-16	850204	———
A	NOR W5S3026/85-07-23 (ECP W5S2098/85-11-21) (ECP W6S3029/86-05-27).	860724	
B	NOR G0S3163/901024	901217	GK
C	NOR G1S2018/ 91 07 08	91-10-11	RR
D	NOR G0S3057/900423 (ECP G1S3179/920115)	920227	RV
E	NOR G1S3175/920107 (ECP G2S3020/920225)	920331	AJL SR
F	NOR G2S3059/920716 (ECP G2S3060/920630)	920811	AJL SR
G	NOR G3S3080 930903	931101	
H	NOR G4S3000 940204	940523	

H	H
SHEET 2	SHEET 1

REVISION STATUS OF SHEETS

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

PART NO. 9390736

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING 85-02-04	U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801
		YP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAFTSMAN	CHECKER
		TS		TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±	ENGR	ENGR
		EL2			ENGR	ENGR
9392518	M4	RA				TRIGGER
9392518	M16A2	BH				SIZE D · FSCM NO. 19200 · 9390736
NEXT ASSY	USED ON	RH				SCALE 2/1 · UNIT WT. ——— · SHEET 1 OF 2
APPLICATION						

ARRADCOM FORM 60 AUG 77 REPLACES DARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:05 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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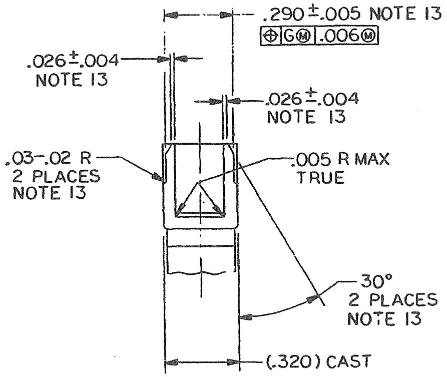
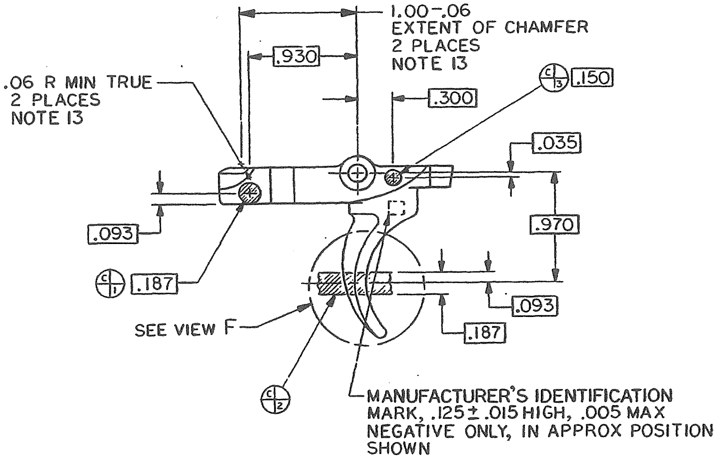
REVISIONS

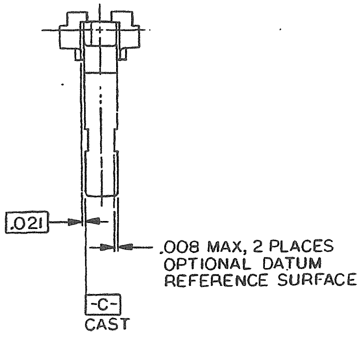
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERRW4S0028/84-10-16	850204	———
A	NOR W5S3026/ 85-07-23 (ECP W6S3029/ 86-05-27)	860724	
F	NOR G2S3059/920716 (ECP G2S3060/920630)	920811	AJL
G	NOR G3S3080 930903	931101	
H	NOR G4S3000 940204	940523	


.290 ± .005 NOTE 13
⊕ G Ⓜ .006 Ⓜ
.026 ± .004
NOTE 13
.026 ± .004
NOTE 13
.03-.02 R
2 PLACES
NOTE 13
.005 R MAX
TRUE
30°
2 PLACES
NOTE 13
(.320) CAST

VIEW E

SCALE 4/1


1.00-.06
EXTENT OF CHAMFER
2 PLACES
NOTE 13
.930
.06 R MIN TRUE
2 PLACES
NOTE 13
.300
C 3
.150
.035
.970
.093
C 1
.187
.093
SEE VIEW F
.187
C 2
MANUFACTURER'S IDENTIFICATION
MARK, .125 ± .015 HIGH, .005 MAX
NEGATIVE ONLY, IN APPROX POSITION
SHOWN


.021
.008 MAX, 2 PLACES
OPTIONAL DATUM
REFERENCE SURFACE
-C-
CAST

VIEW F

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION
ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD
AUTHORITY; 92-06-22.

PART NO. 9390736

9392518	M16A2	MECHANICAL PROPERTIES YP TS EL2 RA BH RH	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±
NEXT ASSY	USED ON		
APPLICATION			

ORIGINAL DATE OF DRAWING 85-02-04
DRAFTSMAN HW
CHECKER
ENGR
ENGR
ENGR
ENGR
Edward J Brennan

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

TRIGGER

SIZE D
FSCM NO. 19200
9390736
SCALE 2/1
UNIT WT
SHEET 2 OF 2

ARRADCOM FORM 60 AUG 77 REPLACES SARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:05 AM

DRAWING SIZE C
(ARRADCOMR 70-12)

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S0011/82-04-13 (ECP W3S3120/83-07-07	83-11-04	HW
B	NOR-W2S3258/82-12-30	840904	HW
C	NOR W4S 0030/84-11-15	850402	HW
D	NOR W5S 2030/85-05-25	850731	HW
E	NOR G0S3152/901002	910322	PF SE
F	NOR G1S2018 91 07 08	91-10-11	RG SL
G	NOR G1S3138/911001	920205	GHS SL

NOTES :—

1— SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2— MATERIAL:
WIRE, STAINLESS STEEL, TYPE 631 (17-7PH), COLD DRAWN, ASTM-A313.

3— WIRE DIAMETER :— .0200 ± .0005.

4— DIRECTION OF HELIX :- OPTIONAL.

5— TOTAL NO. OF COILS :— (7.5)

6— LOAD AT COMPRESSED LENGTH OF .263 :— 2.1 LBS ± .21 LBS.

7— MAX. SOLID HEIGHT :— .154.

8— BREAK SHARP EDGES .003 + .012.

9— FINISH $\sqrt{125}$ ALL SURFACES.

10— MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572, EXCEPT PARAGRAPH 4.4.4.1 SHALL NOT APPLY.

11— PRECIPITATION HEAT TREAT AFTER FORMING. HOLD AT 900°F ± 10°F FOR ONE HOUR, AIR COOL.

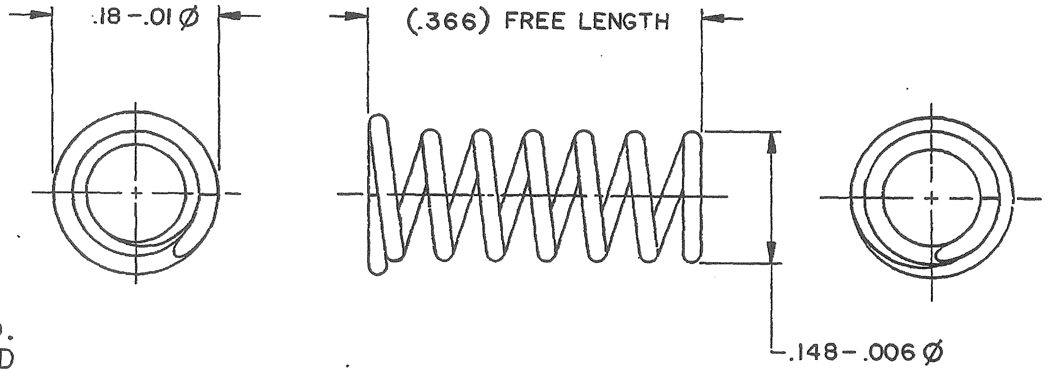
12— HARDNESS EQUIV TO ROCKWELL C48 MIN.

13— TYPE OF ENDS :— ONE CLOSED AND GROUND.
ONE CLOSED, FLARED AND GROUND.

14— PROTECTIVE FINISH :— 5.4.1 OF MIL-STD-171.

15— SPRING REQUIREMENTS APPLY AFTER COMPRESSING TO SOLID LENGTH.

16— FOR ASSEMBLY OF DISCONNECT SPRINGS TO TRIGGER USE OPTIONAL KEY AND SPRING INSERT TOOL DRAWING NO. (D12011964) OR SIMILAR DEVICE.



PART NO. 9349116

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
		RA	
9392518	M4	BH	
9349115	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ±
ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN M M	CHECKER DEW
ENGR R Van Bisiem	ENGR
ENGR	ENGR

Robert J McHugh

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SPRING, DISCONNECT

SIZE	FSCM NO.	
C	CURRENT 19200	9349116
SCALE 10/1	UNIT WT.	SHEET 1 OF 1

ARRADCOM FORM 67 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED

DRAWING SIZE D
(ARRADCOMR 70-12)

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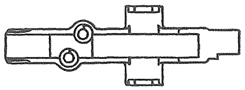
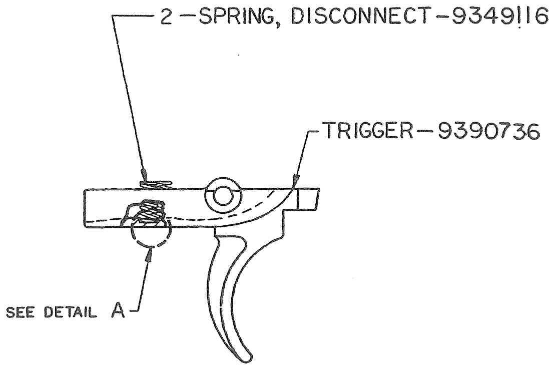
NOTES:—

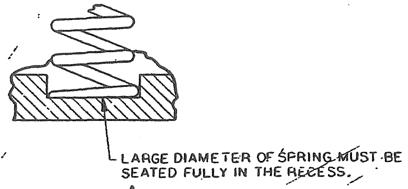
1 - SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 FOR ASSEMBLY OF DISCONNECT SPRINGS TO TRIGGER USE OPTIONAL KEY AND SPRING INSERT TOOL DRAWING NO.(D-12011964) OR SIMILAR DEVICE.

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW4S0028/ 84-10-16 (ECPW4S2099/ 84-12-21)	850204	—
A	NOR G0S3143/900913	901108	GHS
B	NOR G0S3152/901002	910322	PF
C	NOR G1S3138/911001	920206	GHS






LARGE DIAMETER OF SPRING MUST BE SEATED FULLY IN THE RECESS.

DETAIL A
2 PLACES
SCALE-10/1

FOR ENGINEERING PARTS LIST SEE PL 9392518

PART NO. 9392518

9349115	M16A2	MECHANICAL PROPERTIES	DO NOT SCALE DRAWING
NEXT ASSY	USED ON	YP TS EL2 RA BH RH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±
APPLICATION			

ORIGINAL DATE OF DRAWING 85-02-04
DRAFTSMAN HW
CHECKER
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

TRIGGER SUBASSEMBLY

SIZE D
FSCM NO. 19200
9392518
SCALE 2/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES SARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:04 AM

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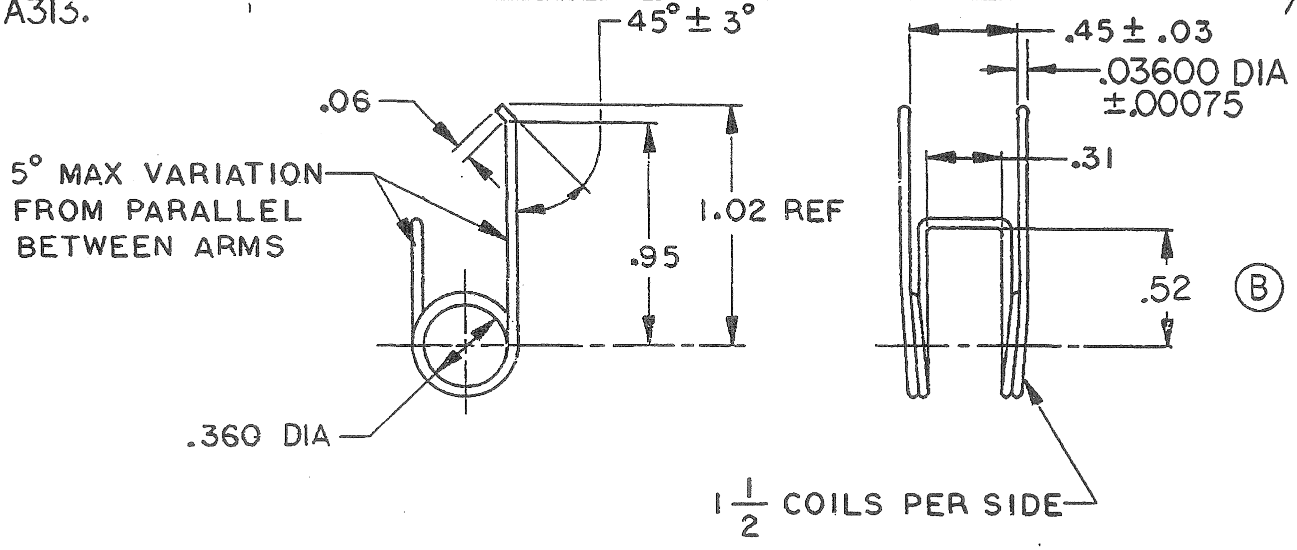
REVISIONS

ME	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		G	NOR GIS2018 910708	91-10-11	RR SN
			REDRAWN FROM COLT'S DRAWING B61657 REVISION B	27APR70	
		A	(1) SEE EO HRD 02197-3	15JULY70	
		B	(3) SEE EO HQR 10639	20 FEB 71	
		C	(2) SEE ERR HQR 20778	6 OCT 72	
		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W2S0011 / 82-04-13 (ECP W2S0034 / 82-07-15)	83-11-04	HW
		F	NOR GOS3100/90-06-28	900815	

B8448593

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH-900. HOLD AT 900°F ±10° FOR 1 HOUR. AIR COOL.
3. TORQUE REQUIREMENT: 1.5±.27 LB IN. TORQUE AT 45° DEFLECTION
4. FINISH 5.4.1 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.



CURRENT

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

FSCM NO.
19200

MECHANICAL PROPERTIES			
YS MIN		9390011	M4
YS MAX		9349115	M16A2
EL 2		F 9327230	M231
RA			M16
BH		B8448591	M16A1
RH	15N 84.5 MIN	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

~~CONTRACT NO:~~
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, TRIGGER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448593

SCALE 2/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CD1

October 18, 2004 11:04 AM

DRAWING SIZE D
(ARRADCOMR 78-12)

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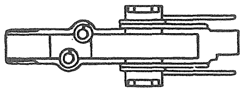
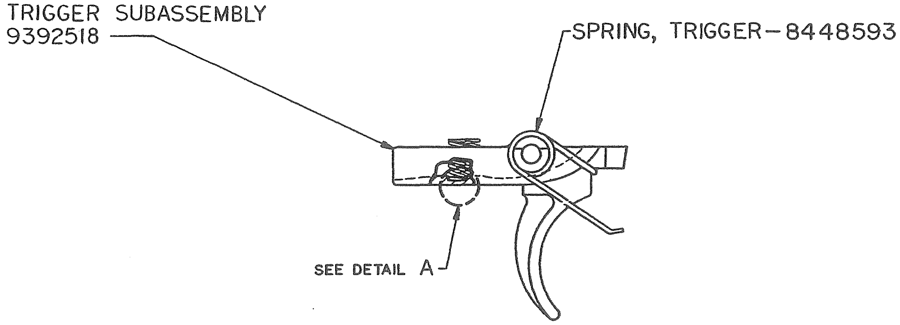
REVISIONS

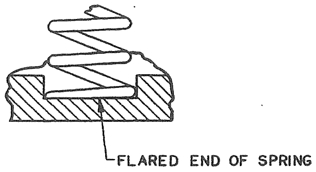
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S0028/84-10-16 (ECP W4S2099/84-12-21)	850204	

NOTES:—

1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.







DETAIL A
2 PLACES
SCALE: 10/1

FOR ENGINEERING PARTS LIST SEE PL 9349115

PART NO. 9349115

9349100	M16A1E1	MECHANICAL PROPERTIES YP TS EL2 RA BH RH	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±
NEXT ASSY	USED ON		
APPLICATION			

ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN M M	CHECKER DEW
ENGR	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

TRIGGER ASSEMBLY

SIZE	FSCM NO.	
D	19200	9349115
SCALE 2/1	UNIT WT.	SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES DARPA FORM 1040 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

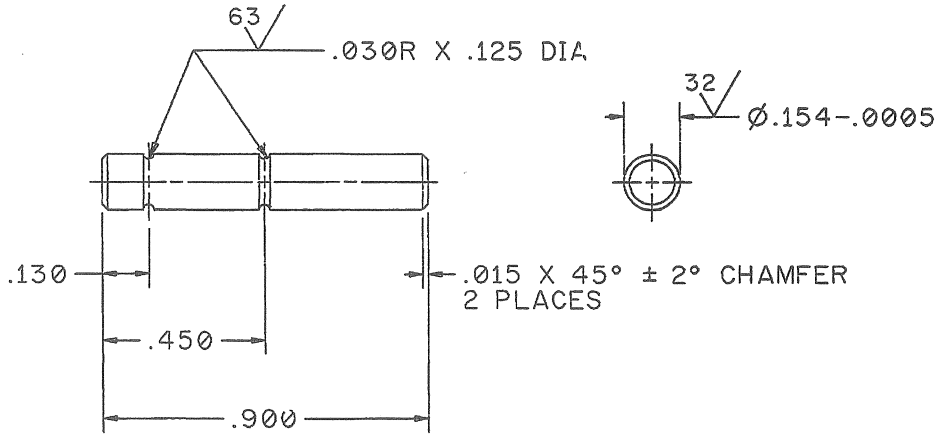
October 18, 2004 11:00 AM

DRAWING SIZE C 4 3 2 1

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	H	NOR G3S2032/930817 (ECP G3S3093/930910)	931108	RJC

NOTE:

1. FINISHED $^{125}\surd$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES.
6. MATERIAL: COLD FINISHED ALLOY STEEL BAR, GRADE 4130 OR 4140, ASTM A331, COLD HEADING QUALITY.



THIS DRAWING HAS BEEN GENERATED ON A CAD SYSTEM LOCATED AT ARDEC. BLDG. 6. PICATINNY ARSENAL. N.J. CHANGES MUST BE INCORPORATED VI\ THIS SYSTEM.

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CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448609

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASONC-AR OR HIGHER DOD AUTHORITY: 92-06-22.

PMIC		
MECHANICAL PROPERTIES		
YP		
TS	9390011	M4
EL2	F8448604	M16
RA	F8448578	M16A1
BH	NEXT ASSY	USED ON
RH 15N 72.5-76	APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ±.005
THIRD ANGLE PROJECTION
MATL ENGR
CADDS REV A 634

CONTRACT NUMBER
CONTRACTOR
DRAWN BY PEM
DATE(YR-MO-DA) 700427
CHECKER DHW
ENGINEER D. SMART
DRAWING APPROVAL F. P. GILHOOLY
DESIGN APPROVAL R. S. HENRY

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND ILLINOIS, 61201

PIN, HAMMER & TRIGGER

SIZE C
CAGE CODE 19204
8448609
SCALE 4/1
UNIT WT.
SHEET

SMCAR FORM 67, 1 DEC 87(TEMP), REPLACES SMCAR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:00 AM

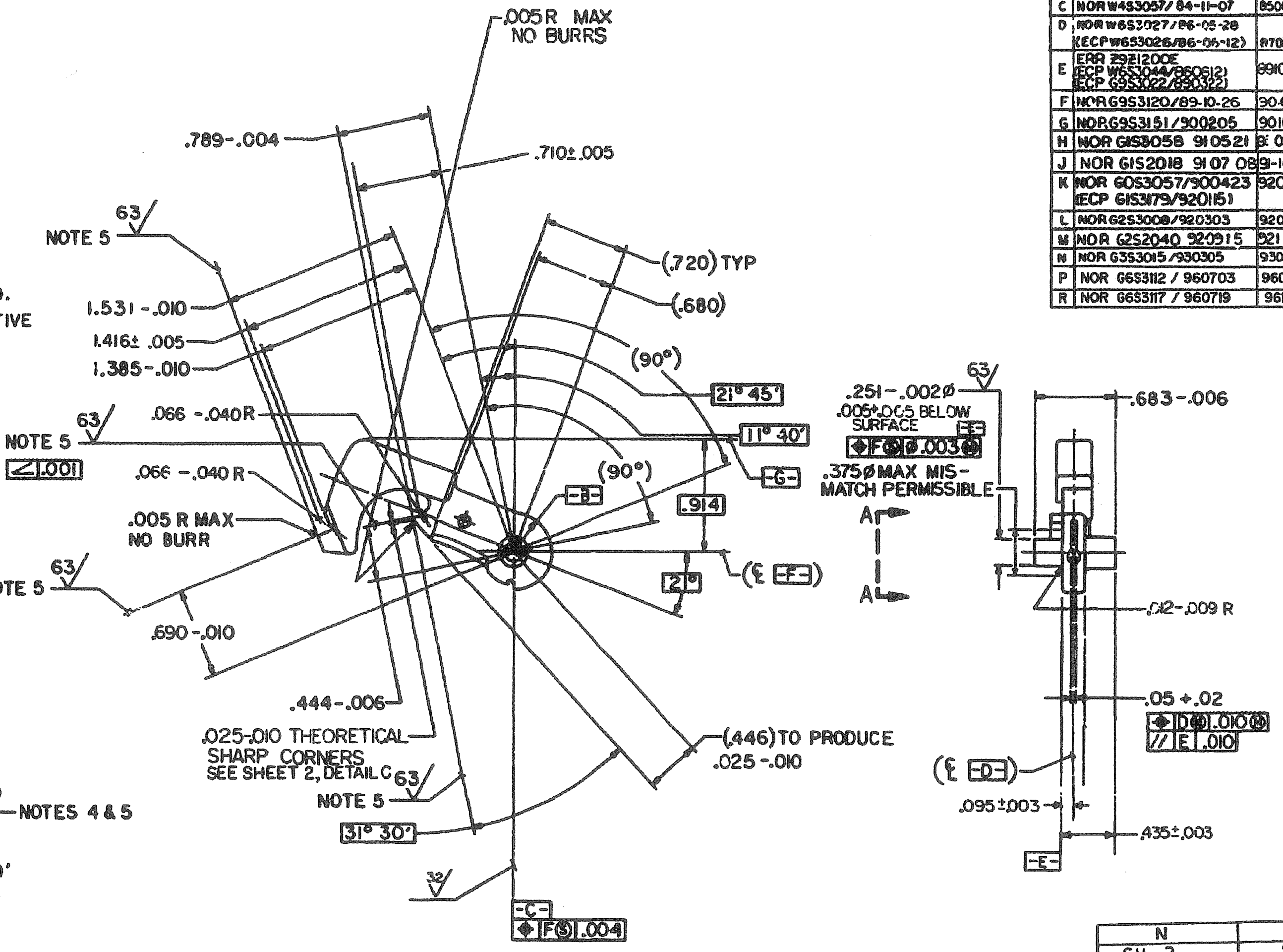
DRAWING SIZE D

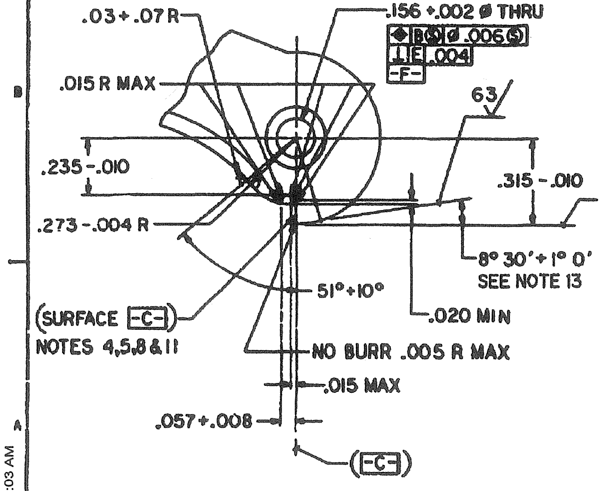
[illegible]

NOTES :-

1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 - MATERIAL :- HAMMER CASTING - 9349112.
3 - ALL DIMENSIONS APPLY WHEN LOCATED ON -F- AND -G- .
4 - ALL DIM. EXCEPT THOSE DEFINING -C- ARE BEFORE FINAL PROTECTIVE FINISH.
5 - SURFACES SO NOTED // F .001 .
6 - BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE NOTED.
7 - FILLET RADII .015 -.012 UNLESS OTHERWISE NOTED.
8 - GRIND -C- AFTER HEAT TREAT AND FINAL PROTECTIVE FINISH, DIRECTION OF GRIND // F . MAX METAL REMOVED BY GRINDING .005.
9 - HEAT TREATMENT :- CARBURIZE, CASE DEPTH .014 TO .018 TOTAL, CASE HARDNESS EQUIV. TO RH 30N 75 TO 79.
10 - FINISH 125√ ALL SURFACES EXCEPT AS NOTED.
11 - COAT GROUND SURFACE -C- WITH CRROSION RESISTING OIL PER MIL-L-46000 OR MIL-L-63460.
12 - PROTECTIVE FINISH :- 5.3.1.2 OF MIL-STD-171.
13 - NO FINAL FINISH REQUIRED IN THIS AREA. COAT WITH CORROSION RESISTING OIL PER MIL-L-46000, OR MIL-L-63460.

REV	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S3160/83-12-22	840618	
B	NORW4S0030/84-11-15	850402	
C	NORW4S3057/84-11-07	850626	
D	NOR W6S3027/86-05-28 (ECP W6S3026/86-05-12)	870218	
E	ERR 2921200E (ECP W6S3044/860612) (ECP G9S3022/890322)	891016	
F	NOR G9S3120/89-10-26	90-03-30	
G	NOR G9S3151/900205	901011	
H	NOR G1S3058 910521	9 07 23	ET
J	NOR G1S2018 91 07 08	91-10-11	
K	NOR G0S3057/900423 (ECP G1S3179/920151)	920227	RV SC
L	NOR G2S3008/920303	920331	GHS
M	NOR G2S2040 920915	921106	
N	NOR G3S3015/930305	930406	GHS
P	NOR G6S3112 / 960703	960820	FET
R	NOR G6S3117 / 960719	961204	FET


.005R MAX
NO BURRS
.789-.004
.710±.005
63
NOTE 5
(.720) TYP
(.680)
1.531-.010
1.416±.005
1.385-.010
(90°)
21° 45'
11° 40'
-G-
63
NOTE 5
⦣ .001
.066-.040R
.066-.040 R
(90°)
-B-
.914
.005 R MAX
NO BURR
2°
(℄ -F-)
63
NOTE 5
.690-.010
.444-.006
.025-.010 THEORETICAL
SHARP CORNERS
SEE SHEET 2, DETAIL C
63
NOTE 5
(.446) TO PRODUCE
.025-.010
31° 30'
32
-C-
⌖ F Ⓢ .004
63
.251-.002Ø
.005+.005 BELOW
SURFACE
-E-
⌖ F Ⓜ Ø.003 Ⓜ
.375Ø MAX MIS-
MATCH PERMISSIBLE
A
A
.683-.006
.012-.009 R
.05+.02
⌖ D Ⓜ .010 Ⓜ
// E .010
(℄ -D-)
.095±.003
.435±.003
-E-


.03+.07R
.156+.002 Ø THRU
⌖ B Ⓢ Ø .006 Ⓢ
⊥ E .004
-F-
.015 R MAX
63
.235-.010
.315-.010
NOTES 4 & 5
.273-.004 R
8° 30' + 1° 0'
SEE NOTE 13
51° + 10°
.020 MIN
(SURFACE -C-)
NOTES 4,5,8 & 11
NO BURR .005 R MAX
.015 MAX
.057+.008
(-C-)

DETAIL A
SCALE: 4/1

DISTRIBUTION STATEMENT F FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL, ASQNC-AR; 911025.

N	R
SH 2	SH 1

REVISION STATUS OF SHEETS

PART NO. 9349111

9349110	M4	
9349110	M16A2	
NEXT ASSY	USED ON	APPLICATION

DO NOT SCALE DRAWING

ORIGINAL DATE OF DRAWING 82-02-26

DRAFTSMAN EJZ — CHECKER JWH

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HAMMER

SIZE	FSCM NO.	
D	19200	9349111

SCALE 2/1 — UNIT WT. — SHEET 1 OF 2

October 18, 2004 11:03 AM

DRAWING SIZE C
(ARRADCOMR 70-12)

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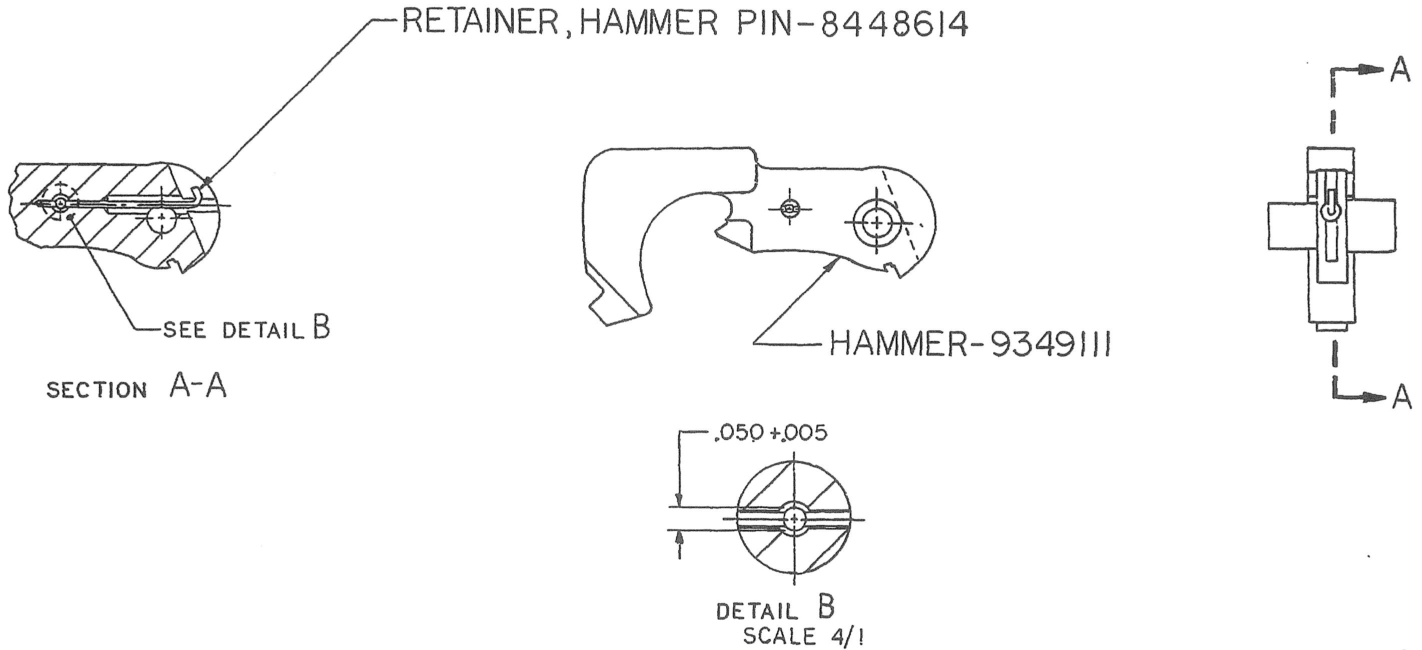
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW4S0030/84-11-15	850402	
B	NOR GIS2018 91 07 08	91-10-11	RR

NOTES:-

1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2- COIN BOTH SIDES OF RETAINER (8448614). AFTER COINING RETAINER IS TO HAVE .010 MIN LONGITUDINAL MOVEMENT.



FOR ENGINEERING PARTS LIST SEE PL 9349110

PART NO. 9349110

9390032	M4	MECHANICAL PROPERTIES	
9349106	M16A1E1	YP	
NEXT ASSY	USED ON	TS	
APPLICATION		EL2	
		RA	
		BH	
		RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN DHB	CHECKER JWH
ENGR	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HAMMER & HAMMER PIN RETAINER ASSEMBLY

SIZE	FSCM NO	
C	19200	9349110
SCALE 2/1	UNIT WT.	SHEET 1 OF 1

ARRADCOM FORM 87 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED

DRAWING SIZE D
(ARRADCOMR 70-12)

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S3258/82-12-30 (ECP W3S3151 / 83-11-19	84-09-04	
B	NOR W4S0030/84-11-15	850402	
C	NOR G1S3034/910327	910422	PF
D	NOR G4S3130 941110 (ECP G5S3002 950206) (ECP G5S3089 950823)	960118	RLV
E	NOR L9S3028/991123	000103	HJS

NOTES:—

1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2—MATERIAL:— AISI 1050

3—.000 TO .005 MISMATCH PERMISSIBLE ON THIS SURFACE.

4—TRANSITION TO BE FREE OF STEPS.

5—

6—MISMATCH BETWEEN (.210) DIMENSION AND (.420) Ø OR FLAT ON (.420) Ø PERMISSIBLE WITHIN DIMENSIONAL TOLERANCES.

7—BREAK SHARP EDGES .005+.010 EXCEPT AS NOTED.

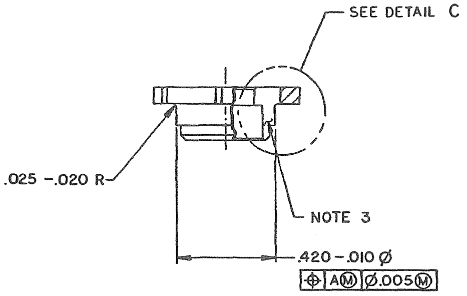
8—FILLET RADII .015 - .012.

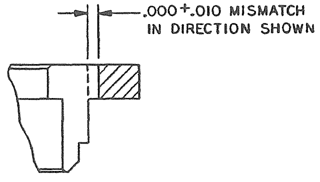
9—HARDEN TO ROCKWELL C 48 TO 52.

10—FINISH 63√ ALL OVER.

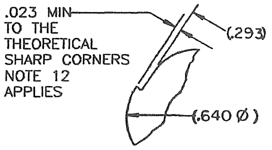
11—CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT OMIT ABRASIVE BLAST.

12—.023 MIN. TOOTH HEIGHT REQUIREMENT LIMITS USE OF FULL TOLERANCE BAND ON THE .640 Ø AND THE .293 DIM AT OPPOSITE TOLERANCE EXTREMES.

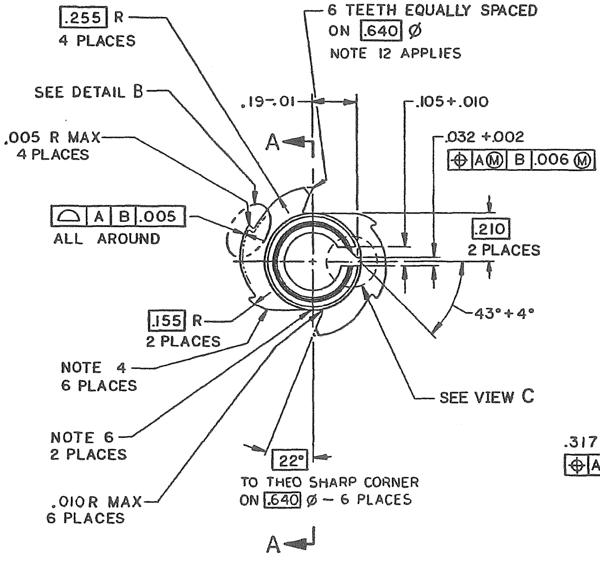

SEE DETAIL C
.025 -.020 R
NOTE 3
.420 -.010 Ø
⊕ A(M) Ø.005(M)

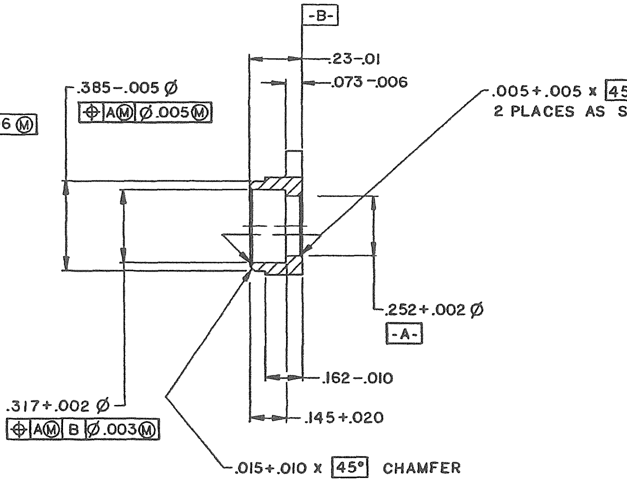

.000+.010 MISMATCH IN DIRECTION SHOWN

DETAIL C
SCALE - 8/1

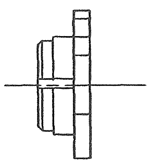

.023 MIN TO THE THEORETICAL SHARP CORNERS NOTE 12 APPLIES
(.293)
(.640 Ø)

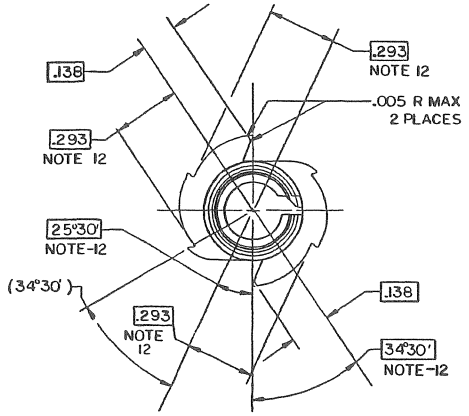
DETAIL-B

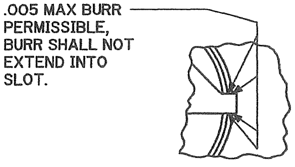

.255 R
4 PLACES
6 TEETH EQUALLY SPACED ON .640 Ø
NOTE 12 APPLIES
SEE DETAIL B
.19-.01
.105+.010
.005 R MAX
4 PLACES
.032 +.002
⊕ A(M) B .006(M)
A
⌓ A B .005
ALL AROUND
.210
2 PLACES
.155 R
2 PLACES
43°+4°
NOTE 4
6 PLACES
SEE VIEW C
NOTE 6
2 PLACES
22°
TO THEO SHARP CORNER ON .640 Ø - 6 PLACES
.010R MAX
6 PLACES
A


-B-
.23-.01
.073-.006
.385-.005 Ø
⊕ A(M) Ø.005(M)
.005+.005 x 45° CHAMFER
2 PLACES AS SHOWN
.252+.002 Ø
-A-
.162-.010
.317+.002 Ø
⊕ A(M) B Ø.003(M)
.145+.020
.015+.010 x 45° CHAMFER

SECTION A-A




.138
.293
NOTE 12
.005 R MAX
2 PLACES
.293
NOTE 12
25°30'
NOTE-12
(34°30')
.293
NOTE
12
.138
34°30'
NOTE-12


.005 MAX BURR PERMISSIBLE, BURR SHALL NOT EXTEND INTO SLOT.

VIEW C
SCALE 10:1

PART NO. 9349108

9349106	M16A2	MECHANICAL PROPERTIES	
NEXT ASSY	USED ON	YP	
APPLICATION		TS	
		EL2	
		RA	
		BH	
		RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN MM
CHECKER JWH
ENGR
ENGR
ENGR
ENGR
Robert J. McD

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CAM, BURST
(3 SHOT)

SIZE D
FSCM NO. 19200
9349108
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES SARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:02 AM

(ARRADCOMR 70-12)

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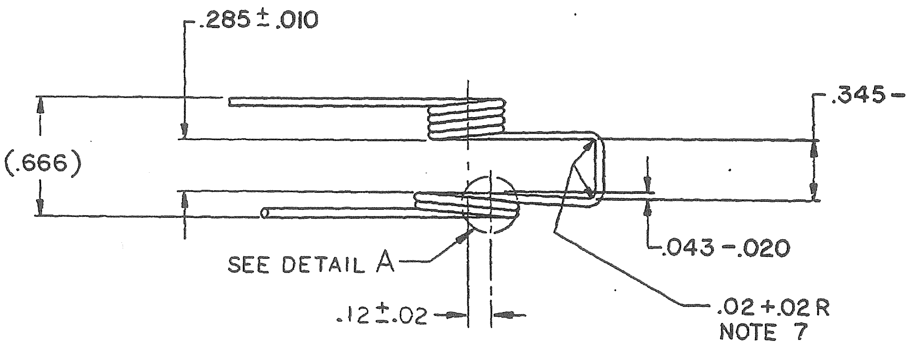
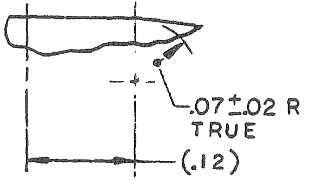
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W2S2013	820614	
A	NOR W2S3258/82-12-30 (ECP W3S3151 / 83-11-14 (ECP W4S3010/ 84-05-07)	840904	
B	NOR W4S 0030 / 84-11-15	85-04-02	
C	NOR G8S2005/880310	880927	
D	NOR G0S3095/900618	901107	
E	NOR G1S2018 91 07 08	91-10-11	RR

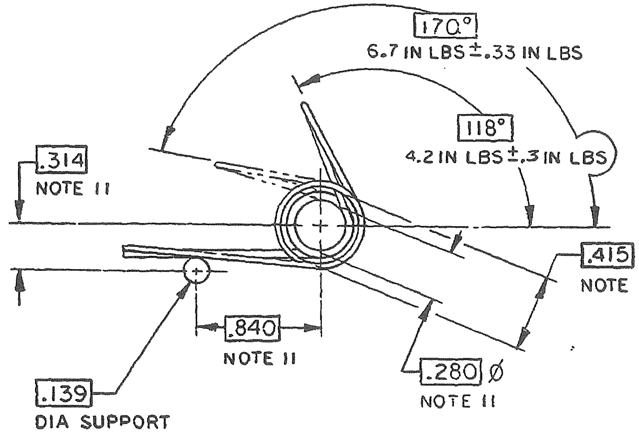
NOTES :—

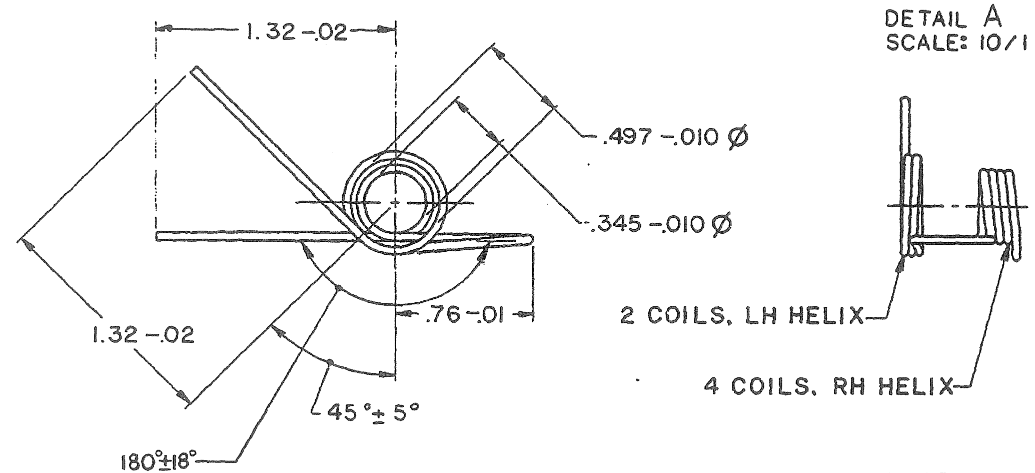
1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL :- MUSIC WIRE PER ASTM-A228
3- WIRE DIAMETER - .047 - .002 .
4- DIRECTION OF HELIX - AS SHOWN.
5- TOTAL COILS - AS SHOWN.
6- PITCH - CLOSE WOUND.
7- NO TOOL MARKS PERMITTED.
8- BREAK SHARP EDGES .005 + .010.
9- FINISH $\sqrt{}^{63}$ ALL SURFACES.
10- STRESS RELIEVE AT 525°± 25°F FOR 30 MINUTES AFTER FORMING.
11- SPECIFIED LOADS APPLY WHEN INSPECTED UPON SPECIFIED DIA'S AND AT DIM'S SHOWN.
12- FINISH: OIL-CLP PER MIL-L-63460.


.285 ± .010
.345 -.015
(.666)
.043 -.020
SEE DETAIL A
.12 ± .02
.02 +.02 R
NOTE 7


.07 ± .02 R
TRUE
(.12)

DETAIL A
SCALE: 10/1


170°
6.7 IN LBS ± .33 IN LBS
118°
4.2 IN LBS ± .3 IN LBS
.314
NOTE 11
.415 Ø
NOTE 11
.840
NOTE 11
.280 Ø
NOTE 11
.139
DIA SUPPORT


1.32 -.02
.497 -.010 Ø
.345 -.010 Ø
1.32 -.02
.76 -.01
45° ± 5°
180° ± 18°
2 COILS, LH HELIX
4 COILS, RH HELIX

PART NO. 9349107

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
		RA	
9390032	M4	BH	
9349106	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN M M
CHECKER DEW
ENGR
ENGR
ENGR
ENGR
Robert J. McHugh

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SPRING, HAMMER

SIZE C
FSCM NO. 19200
9349107
SCALE 2/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 67 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:02 AM

DRAWING SIZE C
(ARRADCOMR 70-12)

4 3 2 1

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REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W2S2013	820614	R. Van Barlego
A	NOR W2S0011/82-04-13 (ECP W3S3120/83-07-07	83-11-04	HW
B	NORW2S3258/82-12-30 (ECP W3S3151/ 83-11-14)	840904	HW
C	NOR W4S0030/84-11-15	850402	HW
D	NOR G1S2018 91 07 08	91-10-11	PP

NOTES:—

1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2—MATERIAL:-WIRE, STAINLESS STEEL, TYPE 631 (17-7PH), COLD DRAWN, ASTM A313.

3—WIRE DIAMETER — .032—.001 .

4—DIRECTION OF HELIX - RIGHT HAND.

5—TOTAL COILS — 3.5 REF.

6—PITCH— CLOSE WOUND.

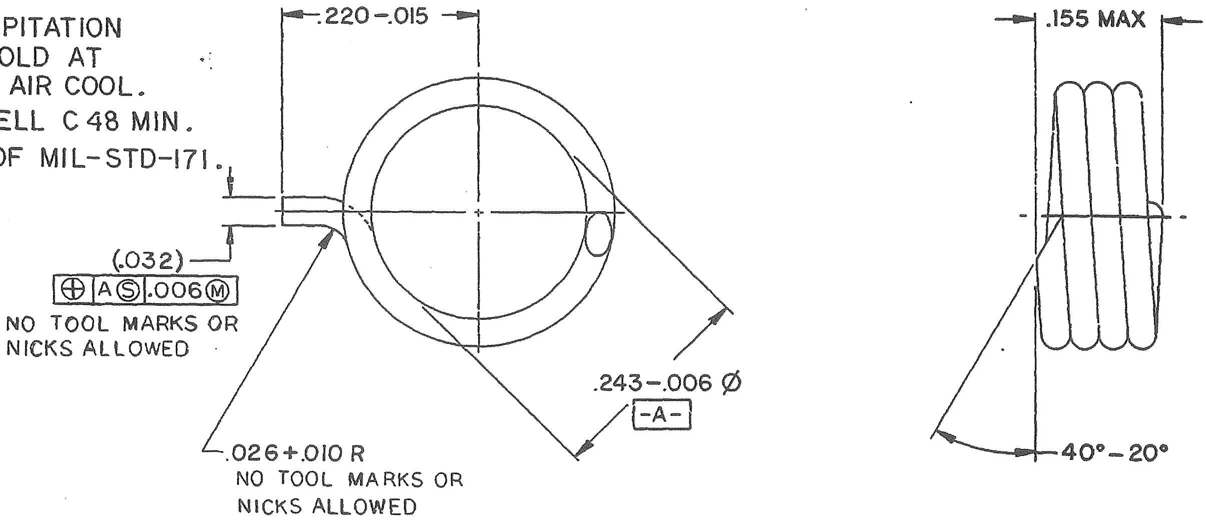
7—BREAK SHARP EDGES .003+.012 .

8—FINISH 63√ ALL SURFACES.

9—STRESS RELIEVE AND PRECIPITATION HARDEN AFTER FORMING. HOLD AT 900°F ± 10°F FOR ONE HOUR, AIR COOL.

10—HARDNESS EQUIV TO ROCKWELL C 48 MIN.

11—PROTECTIVE FINISH:-5.4.1 OF MIL-STD-171.



PART NO. 9349109

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
		RA	
9390032	M4	BH	
9349106	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN M M	CHECKER DEW
ENGR R. Van Barlego	ENGR
ENGR	ENGR

Robert J McHugh

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SPRING, CLUTCH

SIZE	FSCM NO.	
C	19200	9349109
SCALE 10/1	UNIT WT.	SHEET 1 OF 1

ARRADCOM FORM 97 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:01 AM

DRAWING SIZE D
(ARRADCOMR 78-12)

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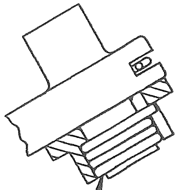
REVISIONS

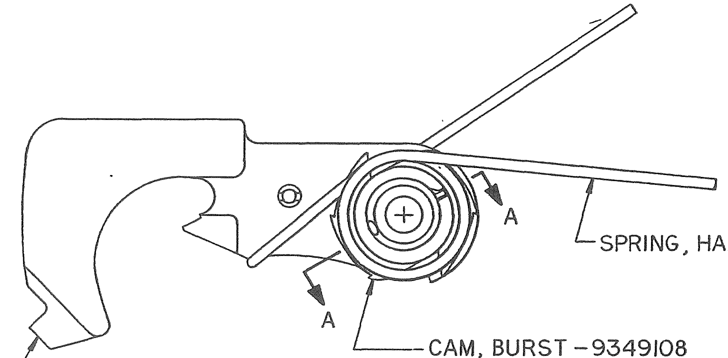
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW252013	820614	
A	NOR W4S0030/84-11-15	850402	JW EB

NOTES:—

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.



SECTION A-A
WITH(SPRING, HAMMER-9349107)REMOVED



FOR ENGINEERING PARTS LIST SEE PL 9349106

PART NO. 9349106

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
		RA	
9349100	M16A1E1	BH	
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN DHB	CHECKER JWH
ENGR	ENGR
ENGR	ENGR

Robert J Mc

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HAMMER ASSEMBLY

SIZE	FSCM NO	
D	19200	9349106

SCALE 4/1 UNIT WT. SHEET 1 OF 1

(ARRADCOM 70-12)

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NOTES:-

1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2—MATERIAL:-STEEL, CARBON, AISI 1065. PER SPEC. QQ-S-700.

3—ALL DIMENSIONS APPLY WHEN PART IS LOCATED ON HOLE -A- AND DATUM -D-.

4—BREAK SHARP EDGES .005+.005 UNLESS OTHERWISE NOTED.

5—AREAS SO NOTED ⊥ B .001, BREAK EDGES .005 MAX.

6—HEAT TREAT:-AUSTEMPER TO HARDNESS EQUIV. TO ROCKWELL C 49-53.

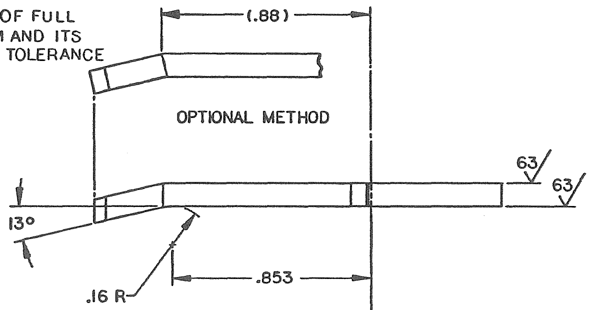
7—FINISH 125√ ALL SURFACES EXCEPT AS NOTED.

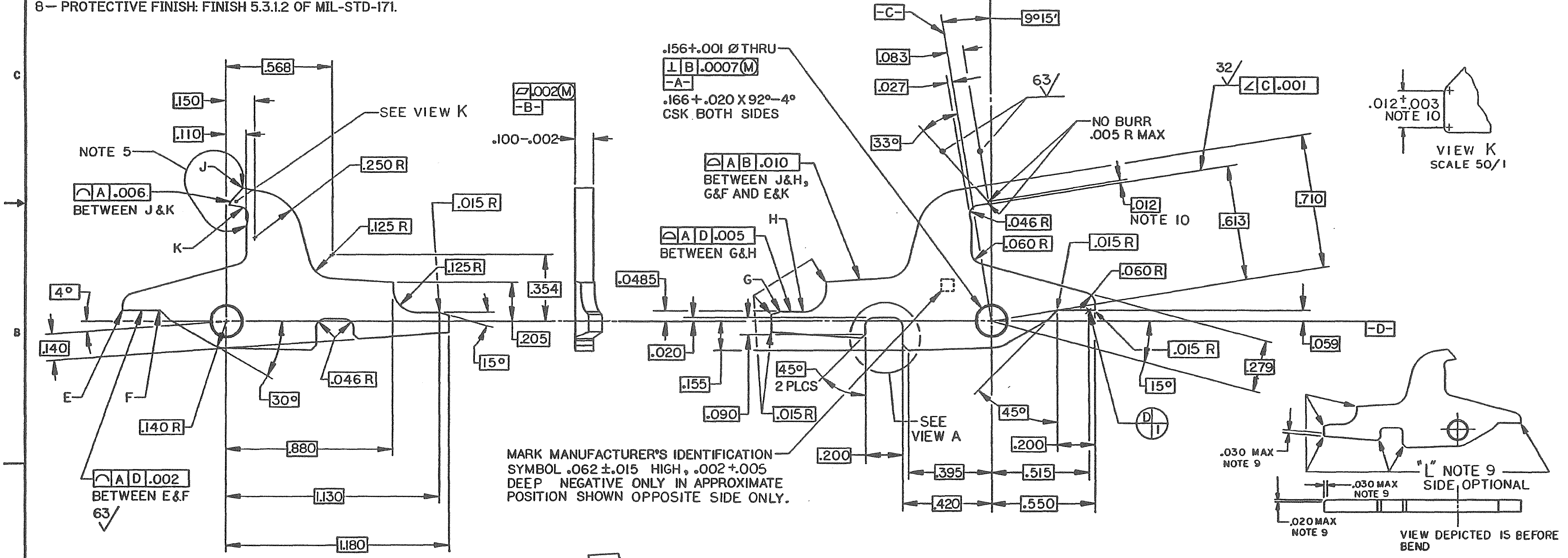
8—PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.

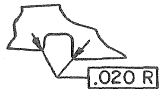
9-DIE ROLL PERMISSIBLE WITHIN DIMENSIONS SHOWN IN AREAS MARKED "L".

10-.012 ± .003 FLAT REQUIREMENTS USE OF FULL TOLERANCE BAND ON THE .012 DIM AND ITS RELATED DIMENSIONS AT OPPOSITE TOLERANCE EXTREMES.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S3258/82-12-30 (ECP W3S3151/83-11-14) (ECP W4S9001/84 06 29)	840904	HW
B	NOR W4S0030/84-11-15	850402	HW EB
C	ERR Z9Z1200G (ECP G8S3126/890105)	891012	
D	NOR G0S3096/900702	901107	RS
E	NOR G1S2018 / 910708	91-10-11	RK
F	NOR G1S3136 911001	920205	SL
G	NOR G2S3001 920219	920327	AJL SE
H	NOR G2S3121 930108	930324	SE
J	NOR G5S3099 951002	960117	RLV


(.88)
OPTIONAL METHOD
63
63
13°
.16 R
.853


.568
.150
.110
SEE VIEW K
NOTE 5
J
K
.250 R
◠ A .006
BETWEEN J&K
.125 R
.015 R
.125 R
.354
4°
.140
.205
15°
.046 R
30°
E
F
.140 R
.880
1.130
1.180
◠ A D .002
BETWEEN E&F
63
▱ .002 (M)
-B-
.100-.002
.156+.001 Ø THRU
⊥ B .0007 (M)
-A-
.166+.020 X 92°-4°
CSK BOTH SIDES
◠ A B .010
BETWEEN J&H, G&F AND E&K
◠ A D .005
BETWEEN G&H
H
G
.0485
.020
.155
.090
45°
2 PLCS
.015 R
SEE VIEW A
MARK MANUFACTURER'S IDENTIFICATION SYMBOL .062 ± .015 HIGH, .002 + .005 DEEP NEGATIVE ONLY IN APPROXIMATE POSITION SHOWN OPPOSITE SIDE ONLY.
.200
.395
.420
-C-
.083
.027
33°
9°15'
63
NO BURR
.005 R MAX
.046 R
.060 R
.015 R
.060 R
.012
NOTE 10
32
∠ C .001
.710
.613
-D-
.059
.279
.015 R
15°
45°
.200
.515
.550
D
1
.012 ± .003
NOTE 10
VIEW K
SCALE 50/1
.030 MAX
NOTE 9
"L" NOTE 9
.030 MAX
NOTE 9
SIDE OPTIONAL
.020 MAX
NOTE 9
VIEW DEPICTED IS BEFORE BEND



VIEW A
OPTIONAL METHOD

DISTRIBUTION STATEMENT F:
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR, ROCK ISLAND, IL, OR HIGHER DoD AUTHORITY, 920107.

PART NO. 9349114

		MECHANICAL PROPERTIES	DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING 82-06-09		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801
		YP	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAFTSMAN M M	CHECKER DEW	DISCONNECT-SEMI
		TS	TOLERANCES ON DECIMALS .00 ± .01 .000 ± .005	ENGR	ENGR	
		EL2	FRACTIONS ± ANGLES ± 1°	ENGR	ENGR	
9390011	M4	RA		John Schroeder		SIZE D
9349100	M16A2	BH		Robert J. McGough		FSCM NO. 19200
NEXT ASSY	USED ON	RH				9349114
APPLICATION						SCALE 4/1 UNIT WT. SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES DARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 11:00 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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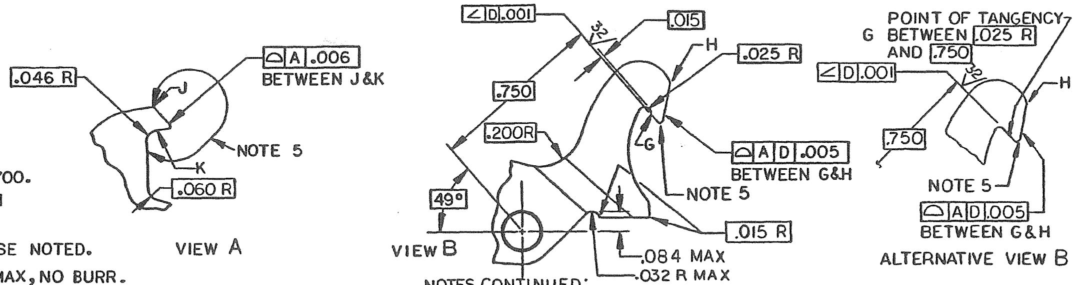
NOTES:-

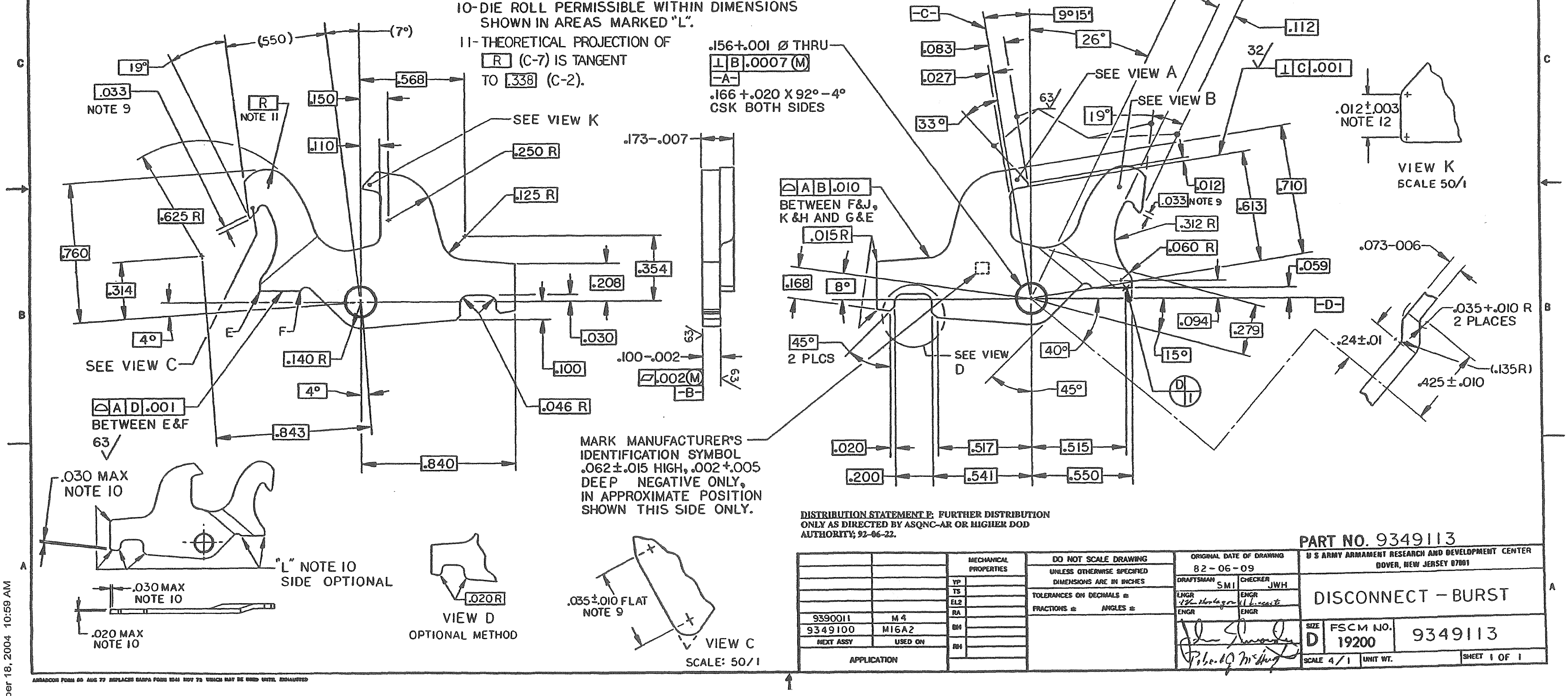
1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 — MATERIAL:-STEEL, CARBON, AISI 1065, PER SPEC. QQ-S-700.
3 — ALL DIMENSIONS APPLY WHEN PART IS LOCATED ON HOLE [-A-] AND DATUM [-D-].
4 — BREAK SHARP EDGES .005+.005 UNLESS OTHERWISE NOTED.
5 — AREAS SO NOTED [⊥|B|.001], BREAK EDGES .005 MAX, NO BURR.
6 — HEAT TREAT:-AUSTEMPER TO HARDNESS EQUIV. TO ROCKWELL C 49-53.
7 — FINISH 125√ ALL SURFACES EXCEPT AS NOTED.
8 — PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.
9 — .035±.010 FLAT REQUIREMENT LIMITS USE OF FULL TOLERANCE BAND ON THE [.033] DIM AND ITS' RELATED DIMENSIONS AT OPPOSITE TOLERANCE EXTREMES.
10 — DIE ROLL PERMISSIBLE WITHIN DIMENSIONS SHOWN IN AREAS MARKED "L".
11 — THEORETICAL PROJECTION OF [R] (C-7) IS TANGENT TO [.338] (C-2).

NOTES CONTINUED:

12 — .012±.003 FLAT REQUIREMENT LIMITS USE OF FULL TOLERANCE BAND ON THE [.012] DIM AND ITS RELATED DIMENSIONS AT OPPOSITE TOLERANCE EXTREMES.



.046 R
J
K
.060 R
NOTE 5
⌓|A|.006
BETWEEN J&K
VIEW A
∠|D|.001
32
.015
H
.025 R
.750
.200R
G
49°
⌓|A|D|.005
BETWEEN G&H
NOTE 5
.015 R
.084 MAX
.032 R MAX
VIEW B
POINT OF TANGENCY G BETWEEN .025 R AND .750
∠|D|.001
.750
NOTE 5
⌓|A|D|.005
BETWEEN G&H
ALTERNATIVE VIEW B



(550)
(7°)
19°
.033
NOTE 9
R
NOTE 11
.150
.568
SEE VIEW K
.110
.250 R
.125 R
.625 R
.760
.314
.354
.208
4°
E
F
.030
SEE VIEW C
.140 R
.100
4°
.046 R
⌓|A|D|.001
BETWEEN E&F
.843
.840
.173-.007
63
.100-.002
⏥|.002Ⓜ
-B-
.156+.001 Ø THRU
⊥|B|.0007Ⓜ
-A-
.166+.020 X 92°-4° CSK BOTH SIDES
-C-
9°15'
26°
.083
.027
33°
63
SEE VIEW A
SEE VIEW B
19°
.338
.112
32
⊥|C|.001
.012
.033 NOTE 9
.312 R
.060 R
.710
.613
.059
-D-
.094
.279
15°
⌓|A|B|.010
BETWEEN F&J, K&H AND G&E
.015R
.168
8°
45°
2 PLCS
SEE VIEW D
40°
45°
D
.020
.517
.515
.200
.541
.550
.012±.003
NOTE 12
VIEW K
SCALE 50/1
.073-.006
.035+.010 R
2 PLACES
.24±.01
(.135R)
.425±.010
63
.030 MAX
NOTE 10
"L" NOTE 10
SIDE OPTIONAL
.030 MAX
NOTE 10
.020 MAX
NOTE 10
.020R
VIEW D
OPTIONAL METHOD
.035±.010 FLAT
NOTE 9
VIEW C
SCALE: 50/1

MARK MANUFACTURER'S IDENTIFICATION SYMBOL .062±.015 HIGH, .002+.005 DEEP NEGATIVE ONLY, IN APPROXIMATE POSITION SHOWN THIS SIDE ONLY.

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S3258/82-12-30 (ECPW3S3151 /83-11-14) (ECPW4S9001/84-06-29)	840904	RJH
B	NOR W4S0030/84-11-15	850402	
C	NOR G7S2013 / 870313	880118	
D	ERR Z9Z1200H (ECP G9S3011/E90406)	891016	
E	NOR G0S3096 900702	901107	FS
F	NOR G1S3076 910626	910821	AJL SR
G	NOR G1S2018 91 07 08	91-10-11	
H	NOR G1S3136 911001	920205	
J	NOR G2S3059 920716 (ECP G2S3060 920630)	920811	AJL SR
K	NOR G2S3121 930108	930324	SR
L	NOR G5S3099 951002	960117	RLV

PART NO. 9349113

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
		RA	
9390011	M4	BH	
9349100	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN SMI
CHECKER JWH
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DISCONNECT - BURST

SIZE D
FSCM NO. 19200
9349113
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES SARPA FORM 1041 NOV 75 WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 10:59 AM

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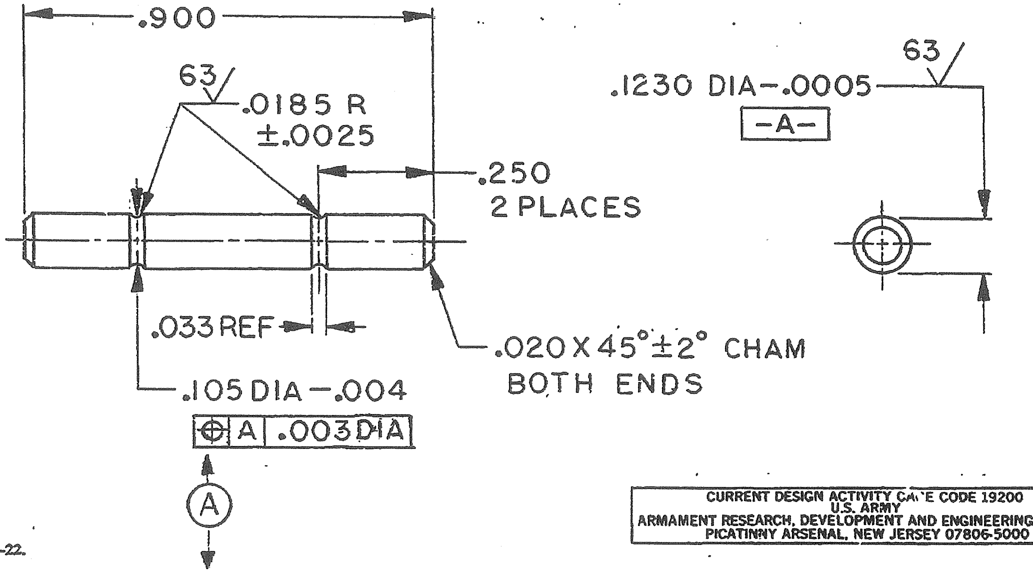
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B61615 REVISION B	27APR 70	
		A	(4) SEE ERR HQ R 20778	6OCT 72	R.C.
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G8S3003/880229	880926	
		D	NOR G1S2018/ 91 07 08	91-10-11	RP
		E	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL

B8448599

NOTES:

1. FINISH 125/√ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH Ⓐ AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES. Ⓐ



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390011	M4
EL 2		F8448604	M16
RA		F8448578	M16A1
BH		NEXT ASSY	USED ON
RH	15N 72.5-76	APPLICATION	

Ⓐ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± —
MATERIAL
WIRE, STEEL, CMPSN 4130, OR 4140, ASTM A331
FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO:
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED F.P. Gillrooly
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, AUTOMATIC SEAR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448599

SCALE 4/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CD1

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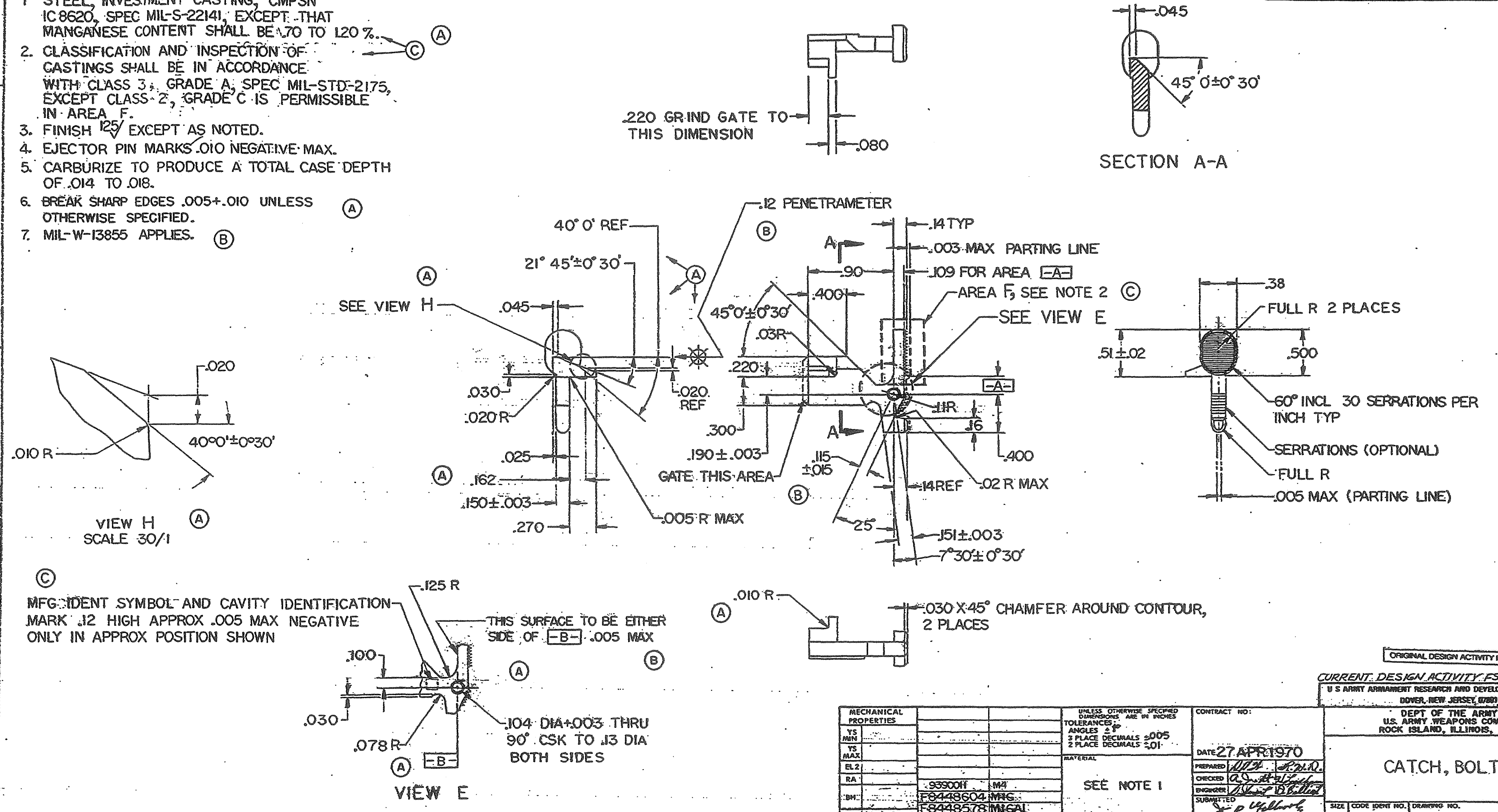
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62301 REV B	27 APR 70	
		A	(9) SEE EO HRD 02197-3	15 JUL 70	
		B	(4) SEE EO HQR 10642	20 FEB 71	
		C	(3) SEE ERR HQR 20778	6 OCT 72	R.E.
		D	~~NORW230026 82-05-21~~	85-02-03	
		E	NOR W5S2099 85-11-21	85 07 08	
		F	NOR GIS3015/910225	910405	PF SR
		G	NOR GIS2018/ 91 07 08	91-10-11	RR

NOTES:

1. STEEL, INVESTMENT CASTING, CMPSN IC 8620, SPEC MIL-S-22141, EXCEPT THAT MANGANESE CONTENT SHALL BE .70 TO 1.20 %. Ⓒ Ⓐ
2. CLASSIFICATION AND INSPECTION OF CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 3, GRADE A, SPEC MIL-STD-2175, EXCEPT CLASS 2, GRADE C IS PERMISSIBLE IN AREA F.
3. FINISH 125√ EXCEPT AS NOTED.
4. EJECTOR PIN MARKS .010 NEGATIVE MAX.
5. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014 TO .018.
6. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓐ
7. MIL-W-13855 APPLIES. Ⓑ



.220 GRIND GATE TO THIS DIMENSION
.080
.045
45° 0'±0° 30'
SECTION A-A
.12 PENETRAMETER
Ⓑ
40° 0' REF
21° 45'±0° 30'
Ⓐ
SEE VIEW H
.045
45° 0'±0° 30'
.03R
.400
.90
.220
.300
.190±.003
GATE THIS AREA
Ⓑ
.115 ±.015
.14 TYP
.003 MAX PARTING LINE
.109 FOR AREA -A-
AREA F, SEE NOTE 2 Ⓒ
SEE VIEW E
A
-A-
.11R
.16
.400
.14 REF
.02 R MAX
25°
.151±.003
7° 30'±0° 30'
.030
.020 R
.020 REF
.025
.162
.150±.003
.270
.005 R MAX
.38
FULL R 2 PLACES
.51±.02
.500
60° INCL 30 SERRATIONS PER INCH TYP
SERRATIONS (OPTIONAL)
FULL R
.005 MAX (PARTING LINE)
.020
.010 R
40° 0'±0° 30'
VIEW H
SCALE 30/1
Ⓐ
Ⓒ
MFG IDENT SYMBOL AND CAVITY IDENTIFICATION MARK .12 HIGH APPROX .005 MAX NEGATIVE ONLY IN APPROX POSITION SHOWN
.125 R
THIS SURFACE TO BE EITHER SIDE OF -B- .005 MAX
Ⓑ
.100
.030
.078 R
.104 DIA+.003 THRU 90° CSK TO .13 DIA BOTH SIDES
Ⓐ -B-
VIEW E
Ⓐ .010 R
.030 X 45° CHAMFER AROUND CONTOUR, 2 PLACES

ORIGINAL DESIGN ACTIVITY FSCM NO. 19204

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY, 07801

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA		93900H	M4	
BH		F8448604	M16	
		F8448578	M16A1	
RH	15N 89.5 ±91.0	NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.12 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970

PREPARED

CHECKED

ENGINEER

SUBMITTED

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

CATCH, BOLT

SIZE D | CODE IDENT NO. 19204 | DRAWING NO. 8448628

SCALE 2/1 | SHEET 1 OF 1

CDI

October 15, 2004 11:22 AM

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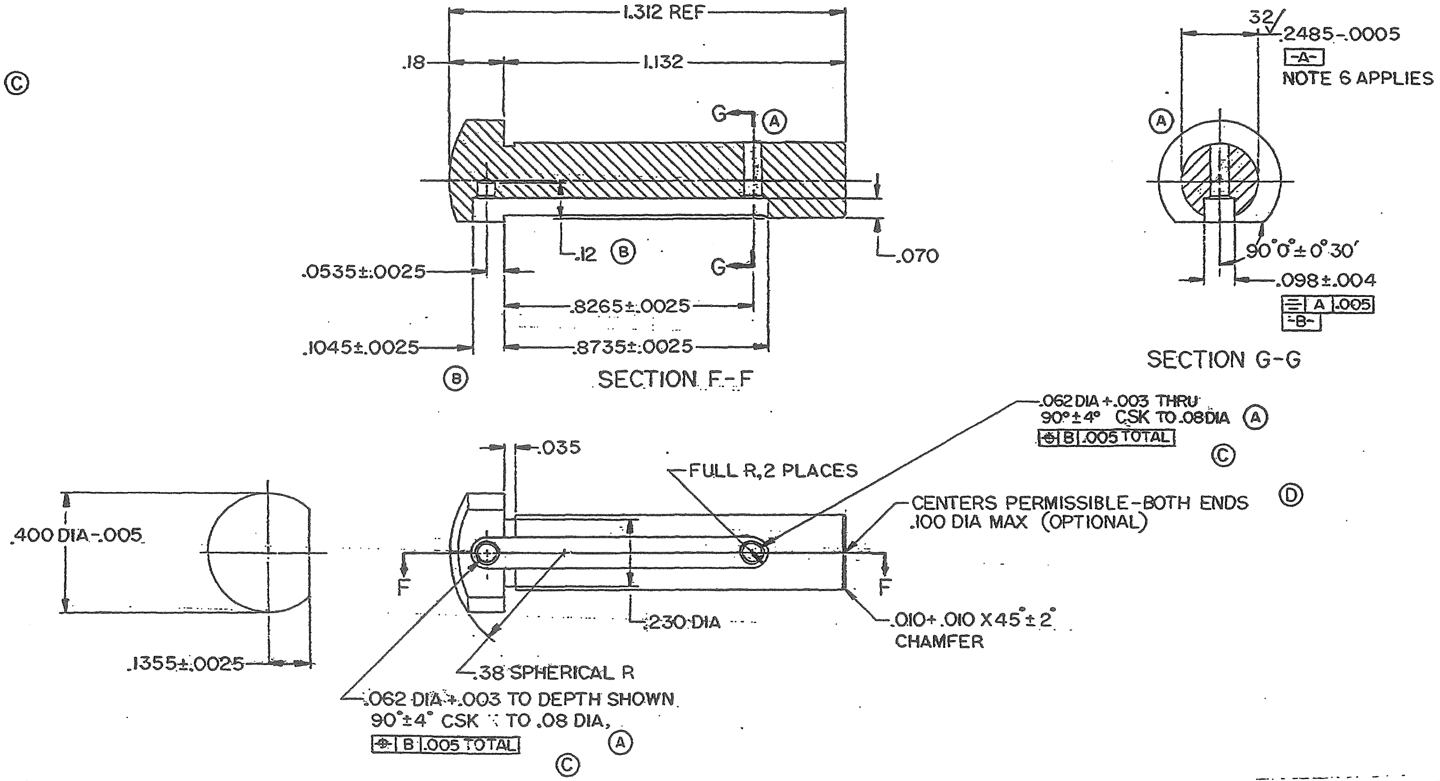
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62221 REV A	27 APR 70	
		A	(4), SEE EO. MRD: 02197-3	15 JULY 70	
		B	(3) SEE HQR 10699	26 APR 71	
		C	(4) SEE ERR HQR 20778	6 OCT 72	
		D	SEE ERR HQR 50646	16 MAY 75	
		E	NOR W9S2009 80-02-13	80-05-16	
		F	NOR G1S2018 91-07-08	91-10-11	
		G	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL

NOTE:

1. STEEL, ALLOY, CMPSN 8620 OR 86L20, ASTM A322. Ⓒ
2. FINISH 125/ EXCEPT AS NOTED.
3. FILLET RADII .010 MAX.
4. BREAK ALL SHARP EDGES .010 MAX.
5. HEAT TREATMENT: CARBURIZE TOTAL CASE DEPTH .010 +.005. Ⓒ
6. GRIND AFTER HEAT TREATMENT. MAX REDUCTION IN DIAMETER BY GRINDING .006.
7. MIL-W-13855 APPLIES. Ⓑ



1.312 REF
.18
1.132
G Ⓐ
.12 Ⓑ
G
.070
.0535±.0025
.8265±.0025
.1045±.0025
.8735±.0025
Ⓑ
SECTION F-F
32/
.2485-.0005
-A-
NOTE 6 APPLIES
Ⓐ
90°0'±0°30'
.098±.004
⌯ A .005
-B-
SECTION G-G
.062 DIA +.003 THRU
90°±4° CSK TO .08 DIA Ⓐ
⌖ B .005 TOTAL
Ⓒ
.035
FULL R, 2 PLACES
CENTERS PERMISSIBLE-BOTH ENDS
.100 DIA MAX (OPTIONAL)
Ⓓ
.400 DIA -.005
F
F
.230 DIA
.010+.010 X 45°±2°
CHAMFER
.1355±.0025
.38 SPHERICAL R
.062 DIA +.003 TO DEPTH SHOWN
90°±4° CSK TO .08 DIA, Ⓐ
⌖ B .005 TOTAL
Ⓒ

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT | CODE IDENT NO. 19200

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA		939001I	M4	
BH		F9327230	M 231	
		F8448604	M16	
RH	15N 89-91	F8448578	M16A1	
		NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.20F MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970

PREPARED

CHECKED

ENGINEER

SUBMITTED

APPROVED R. S. Henry

DEPT. OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, RECEIVER PIVOT

SIZE D | CODE IDENT NO. ~~19204~~ | DRAWING NO. 8448621

SCALE 5/1 | SHEET 1 OF 1

CD1

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

SWE Form 403D, 29 Jul 69

October 15, 2004 11:22 AM

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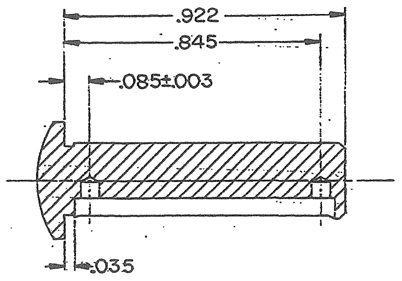
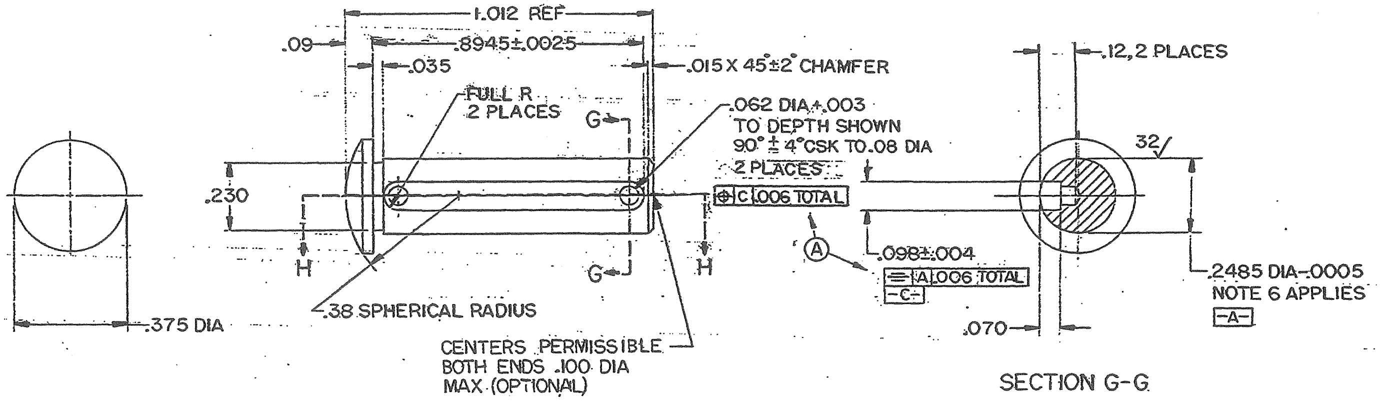
NOTES:

1. STEEL, ALLOY, CMPSN 8620 OR 86L20, Ⓐ ASTM A322.
2. FINISH 125√ EXCEPT AS NOTED.
3. BREAK ALL SHARP EDGES .010 MAX.
4. FILLET RADII .010 MAX.
5. HEAT TREATMENT, CARBURIZE, .010 + .005 TOTAL CASE DEPTH.
6. GRIND AFTER HEAT TREAT. MAX REDUCTION IN DIAMETER AFTER GRINDING .006.
7. MIL-W-13855 APPLIES. Ⓐ

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D61655 REV B	27 APR 70	
		A	(3) SEE ERR HQR 20778	6 OCT 72	RE
		B	SEE ERR HQR 50646	16 MAY 75	
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR G9S3143 900112	900402	
		E	NOR G1S2018 91 07 08	91-10-11	RR
		F	NOR G2S3059 920716 (ECP G2S3060 920630)	92 08 11	AJL


.922
.845
.085±.003
.035

SECTION H-H


1.012 REF
.09
.8945±.0025
.035
.015 X 45°±2° CHAMFER
FULL R
2 PLACES
G
G
.062 DIA ±.003
TO DEPTH SHOWN
90° ± 4° CSK TO .08 DIA
2 PLACES
⊕ C .006 TOTAL
.230
H
H
.375 DIA
.38 SPHERICAL RADIUS
CENTERS PERMISSIBLE
BOTH ENDS .100 DIA
MAX (OPTIONAL)
Ⓐ
.098±.004
≡ A .006 TOTAL
-C-
.070
.12, 2 PLACES
32√
.2485 DIA -.0005
NOTE 6 APPLIES
-A-

SECTION G-G

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		9390011	M4
		F9327230	XM 231
BH		F8448604	M16
		F8448578	M16A1
RH	15N 89-91	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED F.P. Gillooly
APPROVED R.S. Henry

DEPT. OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, TAKEDOWN

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448584

SCALE 5/1 SHEET 1 OF 1

CDI

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

October 15, 2004 11:20 AM

ISWE Form 403D, 29 Jul 69

DRAWING SIZE D
(ARRADCOMR 70-1?)

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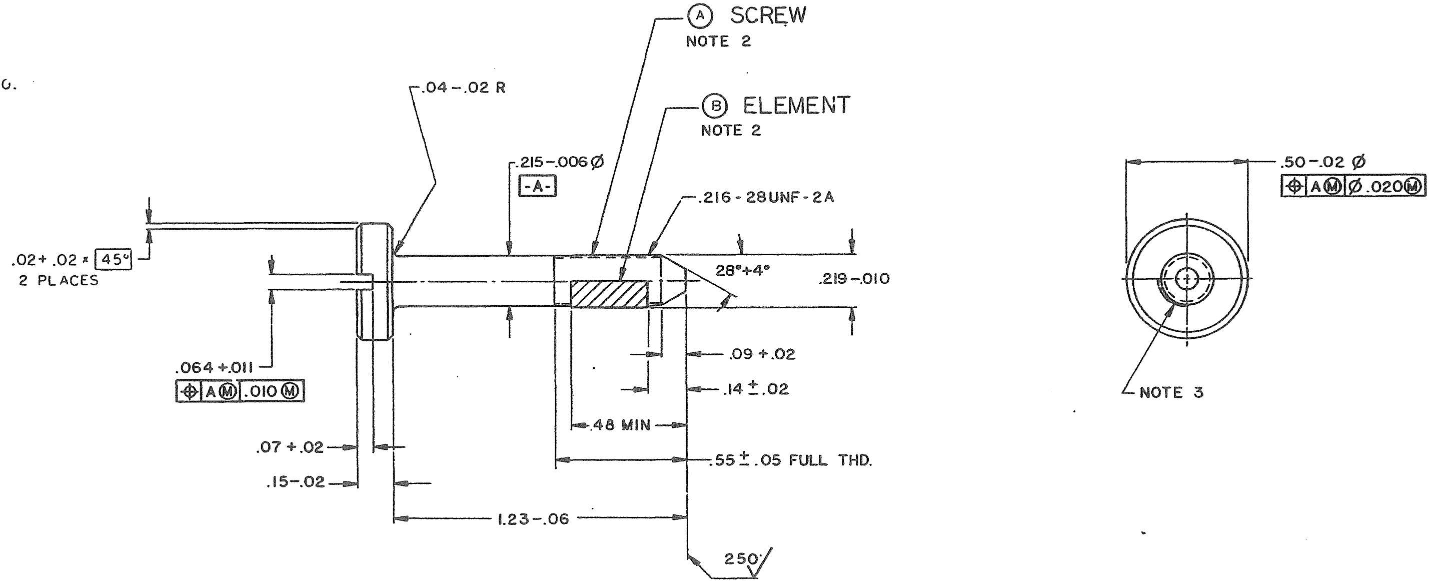
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S3G11 / 84-05-20	840720	
B	NOR W4S0030/84-11-15	850402	
C	NOR W5S8004/860204	890215	89-FEB

NOTES :—

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 — MATERIAL :—
  A. SCREW-STEEL, AISI 1030-1040.
  B. ELEMENT—MUST MEET THE PERFORMANCE REQUIREMENTS OF MIL-F-18240 CONFIGURATION B PATCH.
3 — COVERAGE OF ELEMENT TO BE 90° MIN OF THREADED DIA. RANDOM RADIAL LOCATION OF ELEMENT.
4 — BREAK SHARP EDGES .005 +.010.
5 — FILLET RADII .015 -.012.
6 — FINISH $\sqrt{}^{125}$ ALL OVER EXCEPT AS NOTED.
7 — PROTECTIVE FINISH - 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
8 — HEAT TREATMENT- HARDEN AND TEMPER TO RC 30-40.



PART NO. 9349120

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING 82-02-26		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801
		YP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAFTSMAN M M	CHECKER JWH	SCREW, SWIVEL
	M16	TS		TOLERANCES ON DECIMALS ±	ENGR	ENGR	
	M16A1	EL2		FRACTIONS ± ANGLES ±	ENGR	ENGR	
9349119	M16A2	RA					SIZE D · FSCM NO. 19200 · 9349120
NEXT ASSY	USED ON	BH					SCALE 4/1 · UNIT WT. · SHEET 1 OF 1
APPLICATION		RH			Robert J McHugh		

ARRADCOM FORM 60 AUG 77 REPLACES DARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:05 AM

			REVISIONS		
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	(2) SEE ERR HQR 10835	31 AUG 71	
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR W5S8004/860204	890215	

B8448655

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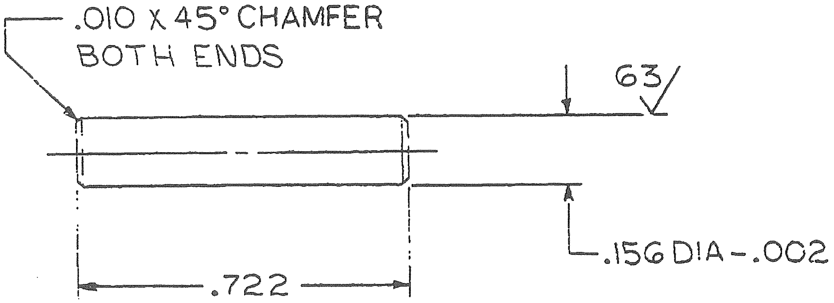
NOTES:

1. STEEL, CMPSN 1010 TO 1020, PER ASTM A576. Ⓐ
2. FINISH 125√ EXCEPT AS NOTED.
3. FINISH-5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 1°0 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO DATE 5 JUN 70
YS MIN				PREP T. A. Wilson
YS MAX			MATERIAL: SEE NOTE 1	CHK
EL 2	9349119	M16, M16A2 M16A1		ENGR D. Billet
RA				SUBMITTED
BH	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH SEE NOTE 3	APPROVED R. S. Henry
RH	APPLICATION			

Ⓐ

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

PIN

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448655

SCALE 4/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

DUPLICATE ORIGINAL

October 15, 2004 11:04 AM

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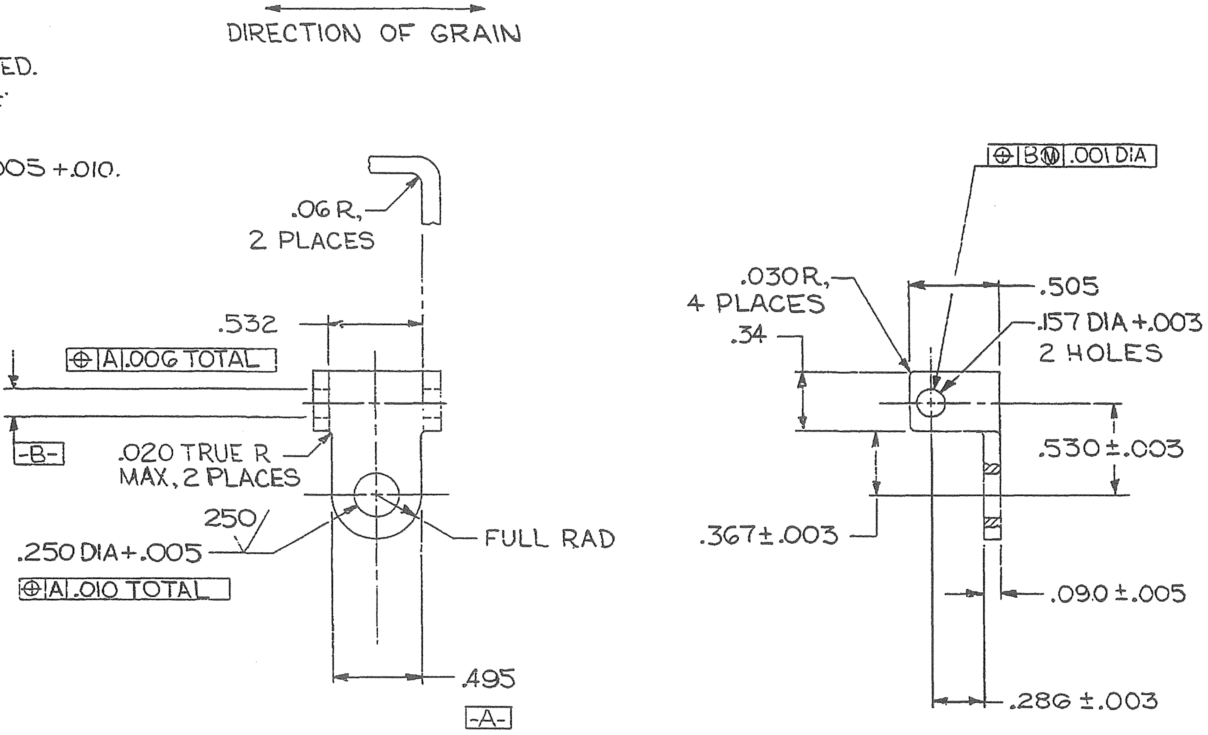
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	(2) SEE EO HRD-02231	25AUG70	
M		B	(4) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	SEE ERR HQF 30671	22 MAR 73	YB
		D	NOR W2S0029 82-07-15	83-02-08	
		E	NOR W2S 0026 82-05-21	83-09-22	
		F	NOR W5S8004 / 860204	890215	
		G	NOR G6S3149 961024	961215	JB

NOTES:
1. BLANK EDGES 250/
2. FINISH 125/ EXCEPT AS NOTED.
3. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
4. BREAK SHARP EDGES .005 + .010.
5. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			MIG, MIGA2
		D9349119	MIGAI
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
STEEL, CMPSN 1010 THRU 1020 SPEC ASTM A109

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO:
M

DATE 5 JUN 70

PREPARED	T. A. Wilson	R. Vassig
CHECKED		
ENGINEER	D. Billet	D. Krolak

SUBMITTED

APPROVED
R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS. 61201

HINGE

SIZE C
CODE IDENT NO 19204
DRAWING NO. 8448653
SCALE 2/1
SHEET 1 OF 1

C 8448653

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:05 AM

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REVISIONS

MT	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	(2) SEE EO HRD-02230	25AUG70	
		B	(9) SEE HQR 10716	6 MAY 71	
		C	SEE ERR HQR 10849	15 SEP 71	
M		D	SEE ERR HQR 20778	6 OCT 72	R.E.
M		E	SEE NOR 76E0003-0000	22JAN76	
		F	NOR W2S0029 82-07-15	83-02-03	
		G	NOR W6S0061 86-05-21	87-01-30	
		H	NOR G7S3082/870716	880222	
		J	NOR W5S8004/860204	890215	
		K	NOR L8S2015 980812	980901	TPT

NOTES:-

1-STEEL STRIP, TEMPER NO. 2, ASTM A 109 OR STEEL BAR, 1018 THRU 1020, ASTM A576, FORGED PER MIL-S-46172, GRADE C OR D.

2-FINISH 125/ EXCEPT AS NOTED.

3-MIL-W-13855 APPLIES

4-EDGE RADII .045±.015 UNLESS OTHERWISE SPECIFIED.

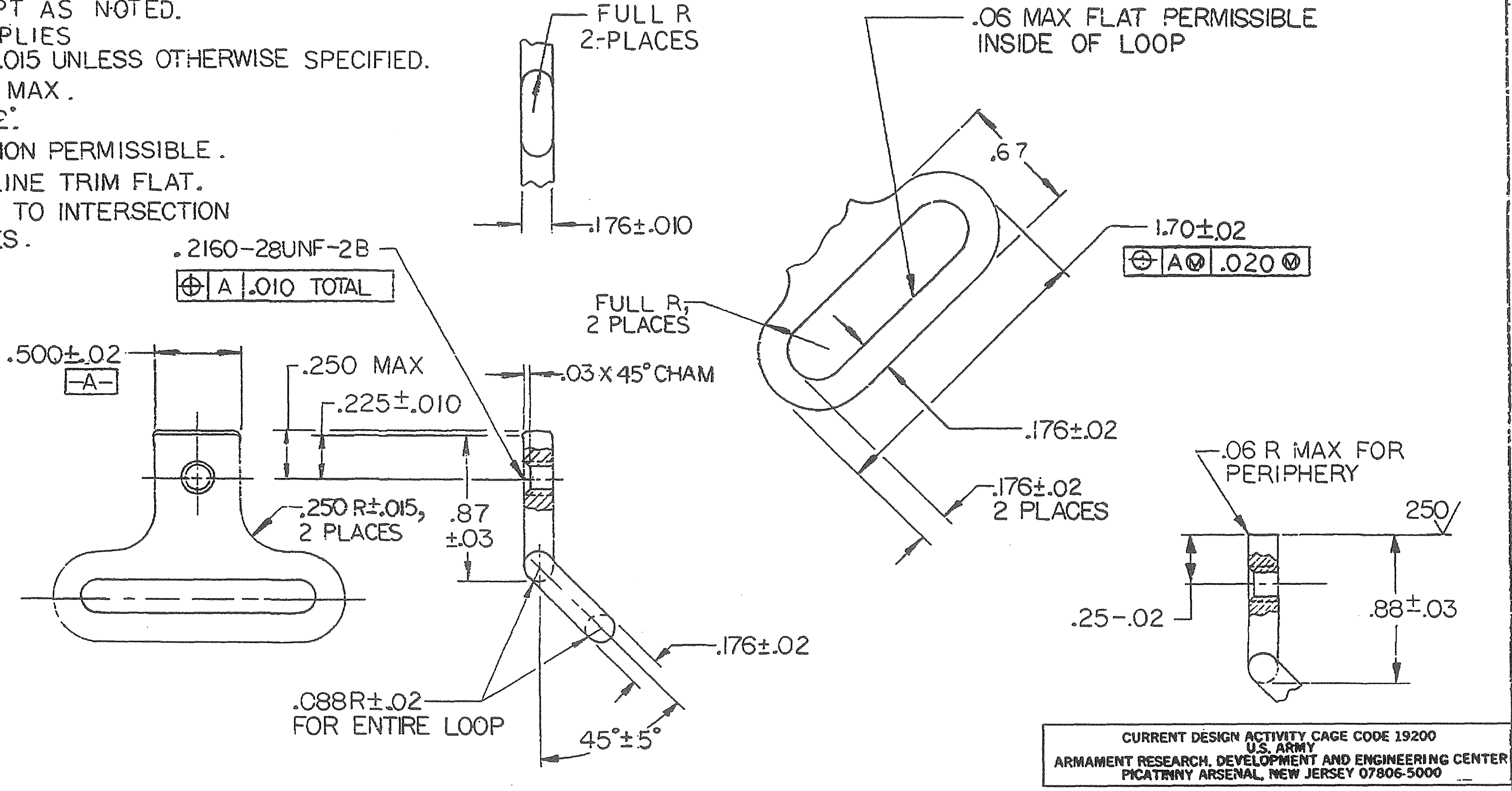
5-DIE MISMATCH .015 MAX.

6-DRAFT ANGLE 7°±2°.

7-NO FLASH EXTENSION PERMISSIBLE.

8-.08 MAX PARTING LINE TRIM FLAT.

9-DIMENSIONS APPLY TO INTERSECTION OF STRAIGHT LINES.


FULL R
2-PLACES
.176±.010
.06 MAX FLAT PERMISSIBLE
INSIDE OF LOOP
.67
1.70±.02
⊖ A Ⓜ .020 Ⓜ
FULL R,
2 PLACES
.176±.02
.176±.02
2 PLACES
.2160-28UNF-2B
⊕ A .010 TOTAL
.500±.02
-A-
.250 MAX
.225±.010
.03 X 45° CHAM
.250 R±.015,
2 PLACES
.87
±.03
.176±.02
.088R±.02
FOR ENTIRE LOOP
45°±5°
.06 R MAX FOR
PERIPHERY
250/
.25-.02
.88±.03

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		12012082	M4, M4A1
RH		D9349119	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°0'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OR 5.3.2.2 OF MIL-STD-171

CONTRACT NO

DATE 5 JUN 70
PREPARED J. Barclay K. Tassig
CHECKED
ENGINEER D. Billiet
SUBMITTED
APPROVED R. S. Kenny

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SWIVEL

SIZE	CODE IDENT NO	DRAWING NO
C	19204	8448652

SCALE 2/1 SHEET 1 OF 1

C8448652
B

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:05 AM

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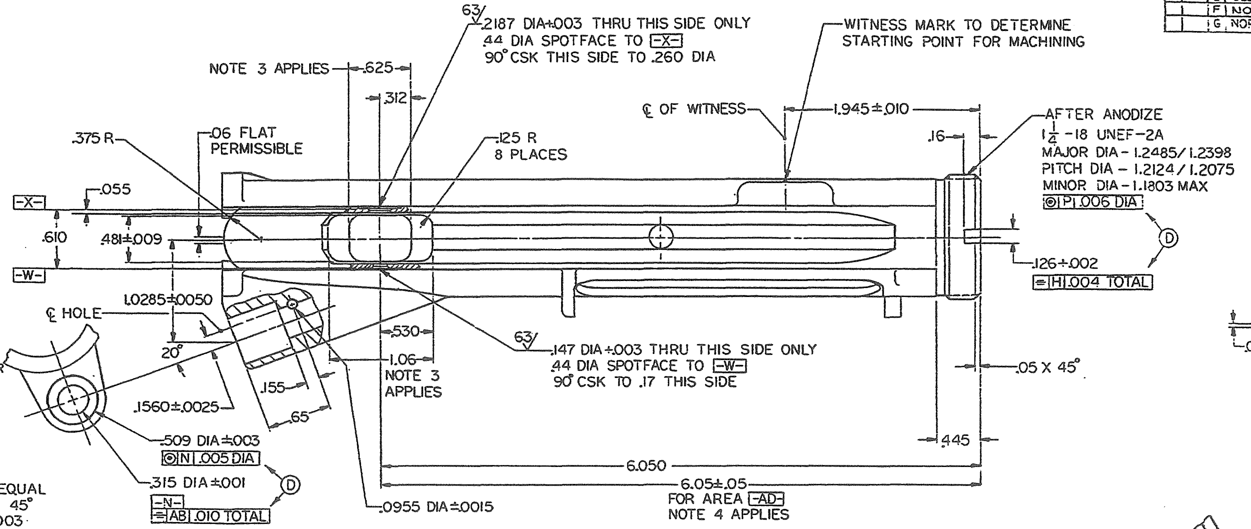
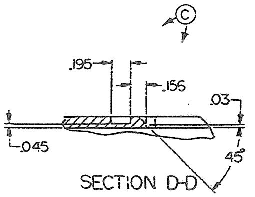
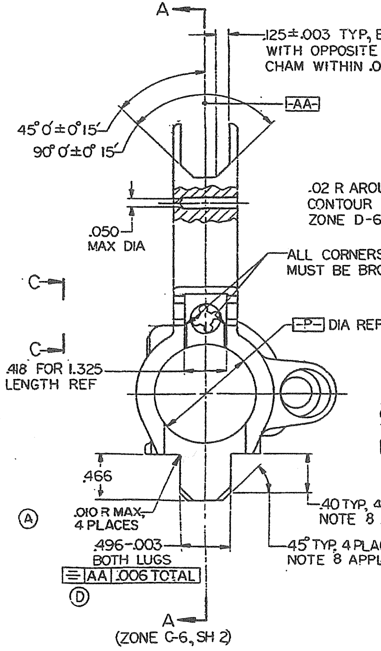
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62273 REV E	27 APR 70	
		A	(8) SEE EO HRD 02137-2	15 JUL 70	
		B	NO CHANGE	1 SEPT 70	
		C	(3) SEE EO HQR 10517	20 FEB 71	
		D	(7) SEE ERR HQR 20778	5 OCT 72	R.E.
		E	SEE ERR HQR 50615	27 FEB 75	
		F	NOR W2S0026 82-05-21	83-02-03	
		G	NORWSS001C 86-02-24	86-11-05	

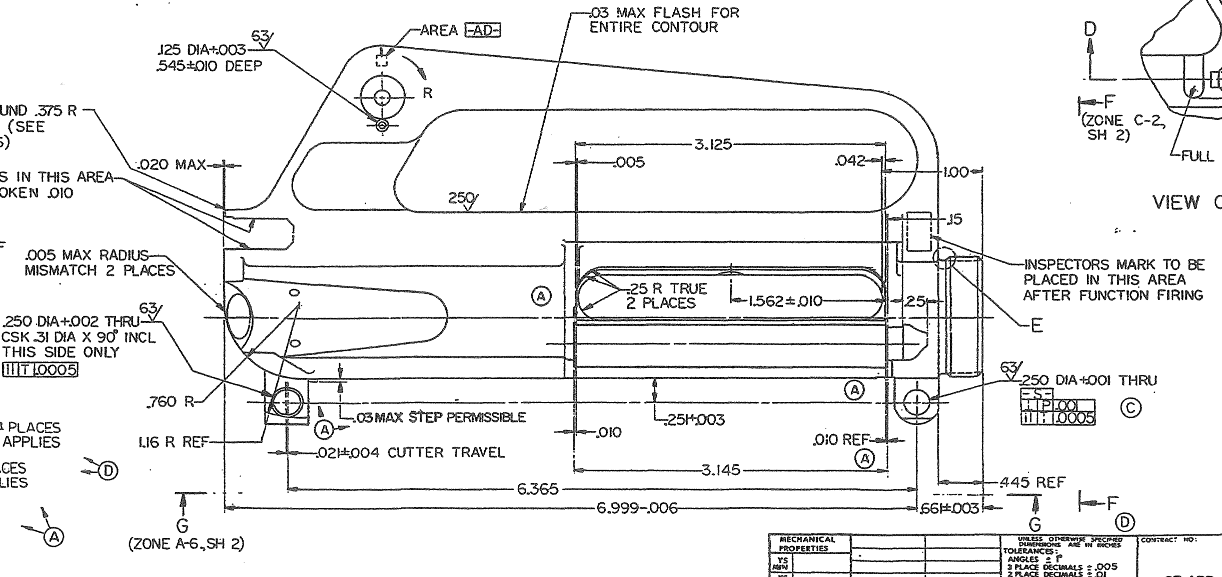
NOTE:

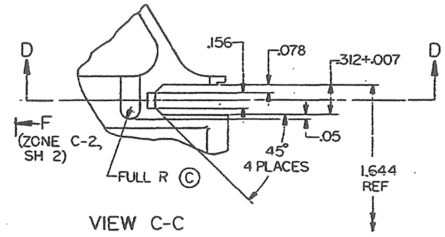
1. FINISH 125√ EXCEPT AS NOTED.
2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND 1.06 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT -U-.
4. CENTER LINES -AA- AND -AB- (ZONES D-3 AND D-1, SH 2) ARE ESTABLISHED WHEN LOCATING ON DIA -P- (IN 1.000 DIA ±.002 AREA) AND SLOT -U- AT AREA -AD-.
5. FINISH MIL-A-8625 TYPE 3, CLASS 2, FILM THICKNESS .0010±.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595. AND SEAL. GRIT BLAST BEFORE FINISH TO PROVIDE NON-REFLECTIVE MATTE SURFACE AFTER FINAL FINISH. Ⓓ Ⓔ
6. EVERLUBE 626, OR 626S CURED AT 275° ± 25°F FOR ONE HOUR OR MIL-L-46010, CURED AT 300° TO 325°F FOR TWO HOURS, TO BE APPLIED AFTER FINISH TO INTERIOR, EXCEPT FOR LENGTH -A-, (SEE SHEET 2, ZONE D-4). FILM THICKNESS TO BE .0002 TO .0003. Ⓐ
7. BREAK SHARP EDGES .005 ± .010 UNLESS OTHERWISE SPECIFIED. Ⓐ
8. OPTIONAL ON FRONT LUG. Ⓓ
9. MIL-W-13855 APPLIES.

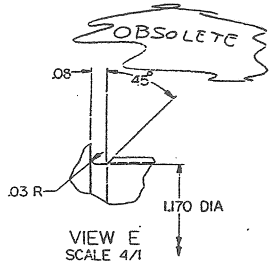

63√ .2187 DIA±.003 THRU THIS SIDE ONLY .44 DIA SPOTFACE TO -X- 90° CSK THIS SIDE TO .260 DIA
WITNESS MARK TO DETERMINE STARTING POINT FOR MACHINING
NOTE 3 APPLIES
.625
.312
℄ OF WITNESS
1.945±.010
.375 R
.06 FLAT PERMISSIBLE
.125 R 8 PLACES
.16
AFTER ANODIZE 1¼ -18 UNEF-2A MAJOR DIA - 1.2485/1.2398 PITCH DIA - 1.2124/1.2075 MINOR DIA - 1.1803 MAX ◎ P .006 DIA
-X-
.055
.610
.481±.009
-W-
Ⓓ
.126±.002
═ H .004 TOTAL
1.0285±.0050
℄ HOLE
20°
.530
1.06 NOTE 3 APPLIES
63√ .147 DIA±.003 THRU THIS SIDE ONLY .44 DIA SPOTFACE TO -W- 90° CSK TO .17 THIS SIDE
.05 X 45°
.155
.65
.1560±.0025
.509 DIA±.003 ◎ N .005 DIA
.445
.315 DIA±.001 -N- ═ AB .010 TOTAL
Ⓓ
.0955 DIA±.0015
6.050
6.05±.05 FOR AREA -AD- NOTE 4 APPLIES


Ⓒ
.195
.156
.03
.045
45°
SECTION D-D


A
.125±.003 TYP, EQUAL WITH OPPOSITE 45° CHAM WITHIN .003
-AA-
45°0'±0°15'
90°0'±0°15'
.050 MAX DIA
ALL CORNERS IN THIS AREA MUST BE BROKEN .010
C
C
-P- DIA REF
.418 FOR 1.325 LENGTH REF
.466
.010 R MAX, 4 PLACES
Ⓐ
.496-.003 BOTH LUGS
═ AA .006 TOTAL
Ⓓ
.40 TYP, 4 PLACES NOTE 8 APPLIES
.45° TYP, 4 PLACES NOTE 8 APPLIES
Ⓓ
A
(ZONE C-6, SH 2)


AREA -AD-
63√ .125 DIA±.003 .545±.010 DEEP
R
.03 MAX FLASH FOR ENTIRE CONTOUR
.02 R AROUND .375 R CONTOUR (SEE ZONE D-6)
.020 MAX
3.125
.005
.042
1.00
250√
.005 MAX RADIUS MISMATCH 2 PLACES
.15
INSPECTORS MARK TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
Ⓐ
.25 R TRUE 2 PLACES
1.562±.010
.25
E
63√ .250 DIA±.002 THRU CSK .31 DIA X 90° INCL THIS SIDE ONLY ⌭ T .0005
63√ .250 DIA±.001 THRU -S- ⊥ P .001 ⌭ T .0005
Ⓒ
Ⓐ
.760 R
.03 MAX STEP PERMISSIBLE
.25H.003
.010
.010 REF
Ⓐ
1.16 R REF
.021±.004 CUTTER TRAVEL
3.145
6.365
.445 REF
6.999-.006
.661±.003
Ⓐ
G
(ZONE A-6, SH 2)
G
F
Ⓓ


D
D
.156
.078
.312±.007
F (ZONE C-2, SH 2)
.05
45° 4 PLACES
FULL R Ⓒ
1.644 REF
VIEW C-C


OBSOLETE
.08
45°
.03 R
1.170 DIA
VIEW E SCALE 4/1

REV STATUS OF SHT'S	
SH 1	SH 2
F	F

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			
RH		D8448523	M16A1
		NEXT ASST	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
MAKE FROM FORGING, UPPER RECEIVER F8448642

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO:

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED R.S. Henry

CURRENT DESIGN ACTIVITY. FSCM. NO. 19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RECEIVER, UPPER

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448524

SCALE 2/1 SHEET 1 OF 2

E8448524

CDI

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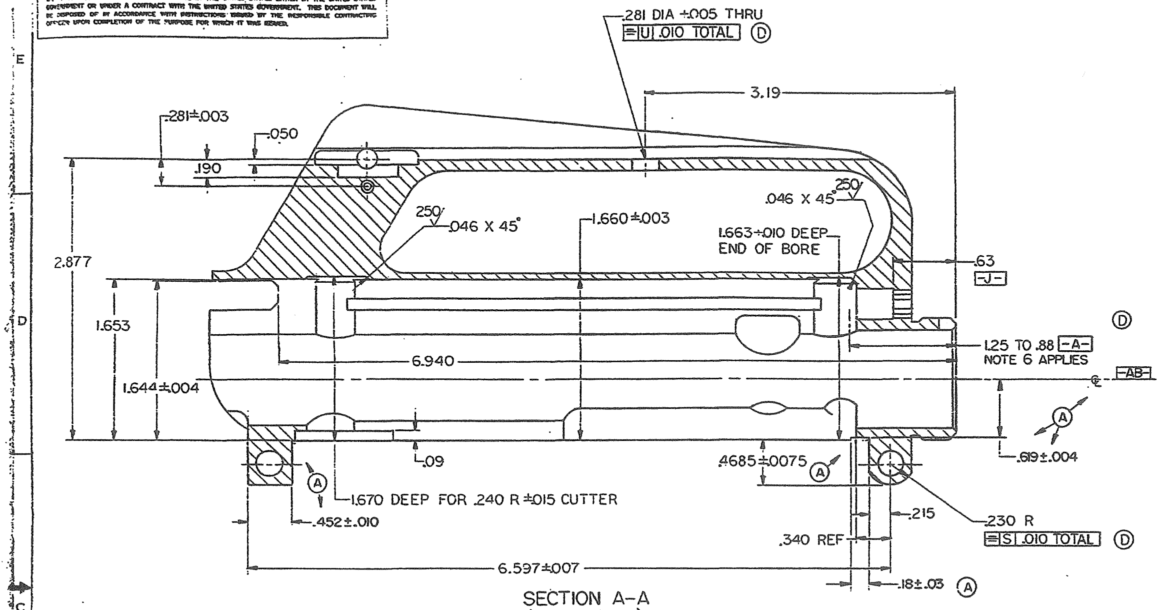
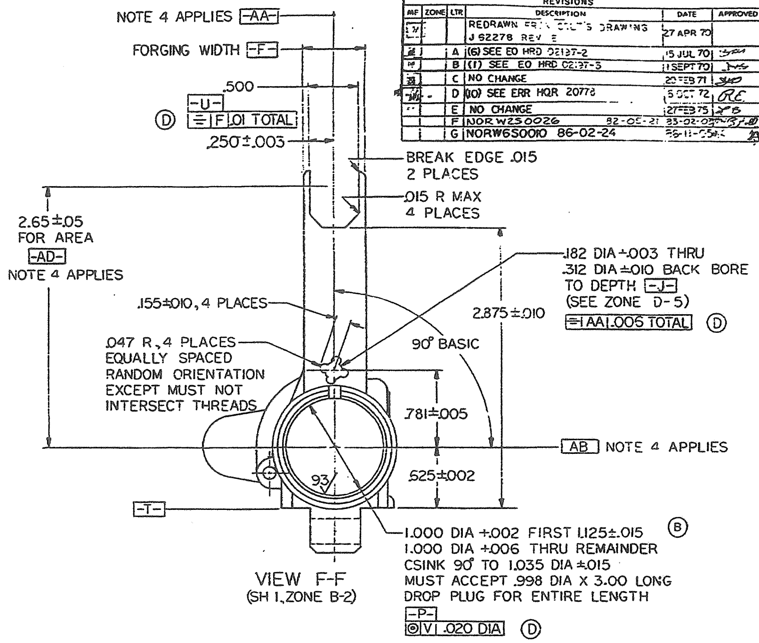
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J 62278 REV E	27 APR 70	
		A	(6) SEE EO HRD 02137-2	15 JUL 70	
		B	(1) SEE EO HRD 02137-5	1 SEPT 70	
		C	NO CHANGE	20 FEB 71	
		D	(10) SEE ERR HQR 20778	5 OCT 72	RE
		E	NO CHANGE	27 FEB 75	
		F	NORW2S0026 82-05-21	83-02-03	
		G	NORW6S0010 86-02-24	86-11-05	



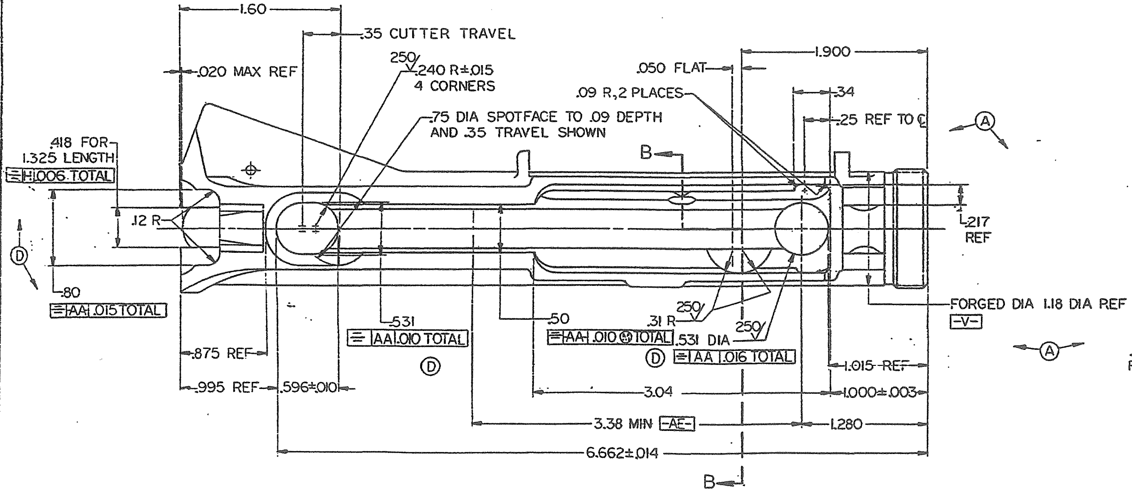
.281 DIA +.005 THRU
⌯ U .010 TOTAL Ⓓ
3.19
.281±.003
.050
.190
250
.046 X 45°
1.660±.003
.046 X 45°
250
1.663+.010 DEEP
END OF BORE
2.877
1.653
.63
-J-
1.25 TO .88 -A-
NOTE 6 APPLIES
Ⓓ
6.940
-AB-
1.644±.004
Ⓐ
.619±.004
.09
.4685±.0075 Ⓐ
Ⓐ
1.670 DEEP FOR .240 R ±.015 CUTTER
.452±.010
.215
.230 R
⌯ S .010 TOTAL Ⓓ
.340 REF
6.597±.007
.18±.03 Ⓐ

SECTION A-A
(SH 1, ZONE A-8)



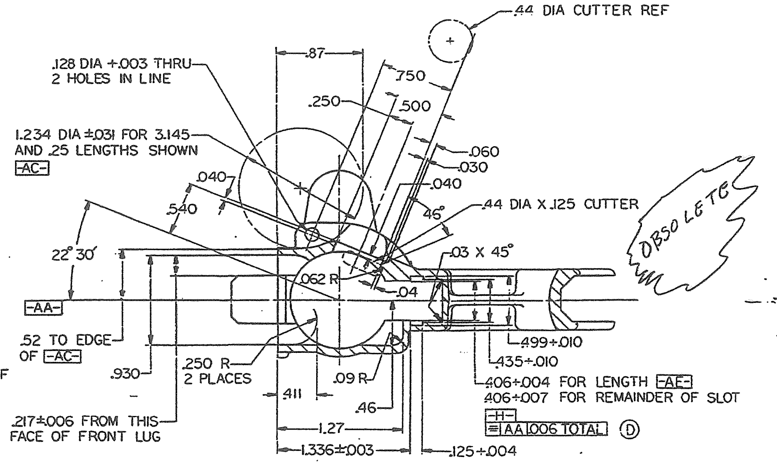
NOTE 4 APPLIES -AA-
FORGING WIDTH -F-
.500
-U-
Ⓓ ⌯ F .01 TOTAL
.250±.003
BREAK EDGE .015
2 PLACES
.015 R MAX
4 PLACES
2.65±.05
FOR AREA
-AD-
NOTE 4 APPLIES
.182 DIA +.003 THRU
.312 DIA ±.010 BACK BORE
TO DEPTH -J-
(SEE ZONE D-5)
⌯ AA .005 TOTAL Ⓓ
.155±.010, 4 PLACES
2.875±.010
90° BASIC
.047 R, 4 PLACES
EQUALLY SPACED
RANDOM ORIENTATION
EXCEPT MUST NOT
INTERSECT THREADS
.781±.005
AB NOTE 4 APPLIES
.625±.002
93
-T-
1.000 DIA +.002 FIRST 1.125±.015
1.000 DIA +.006 THRU REMAINDER
CSINK 90° TO 1.035 DIA ±.015
MUST ACCEPT .998 DIA X 3.00 LONG
DROP PLUG FOR ENTIRE LENGTH
Ⓑ
-P-
◎ V .020 DIA Ⓓ

VIEW F-F
(SH 1, ZONE B-2)



1.60
.35 CUTTER TRAVEL
.020 MAX REF
250
.240 R±.015
4 CORNERS
.050 FLAT
1.900
.09 R, 2 PLACES
.34
.75 DIA SPOTFACE TO .09 DEPTH
AND .35 TRAVEL SHOWN
.25 REF TO ℄
Ⓐ
.418 FOR
1.325 LENGTH
⌯ H .006 TOTAL
B
.12 R
.217
REF
Ⓓ
.80
⌯ AA .015 TOTAL
.531
⌯ AA .010 TOTAL
Ⓓ
.50
⌯ AA .010 Ⓜ TOTAL
.31 R
250
250
.531 DIA
Ⓓ ⌯ AA .016 TOTAL
FORGED DIA 1.18 DIA REF
-V-
Ⓐ
.875 REF
1.015 REF
.995 REF
.596±.010
3.04
1.000±.003
3.38 MIN -AE-
1.280
6.662±.014
B

VIEW G-G
(SH 1, ZONE A-6)



.44 DIA CUTTER REF
.87
.128 DIA +.003 THRU
2 HOLES IN LINE
.750
.250
.500
1.234 DIA ±.031 FOR 3.145
AND .25 LENGTHS SHOWN
-AC-
.060
.030
.040
.040
.540
46°
.44 DIA X .125 CUTTER
22°30'
.03 X 45°
.062 R
.04
-AA-
.52 TO EDGE
OF -AC-
.499+.010
.435+.010
.930
.250 R
2 PLACES
.09 R
.406+.004 FOR LENGTH -AE-
.406+.007 FOR REMAINDER OF SLOT
-H-
⌯ AA .006 TOTAL Ⓓ
.411
.46
.217±.006 FROM THIS
FACE OF FRONT LUG
1.27
1.336±.003
.125+.004
OBSOLETE

SECTION B-B

E8448524

CURRENT DESIGN ACTIVITY FSCM NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL2			
RA			
BH			
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED R.S. Henry

RECEIVER, UPPER

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448524

SCALE 2/1

SHEET 2 OF 2

CD!

AMSWE Form 403F, 29 Jul 69

October 15, 2004 11:00 AM

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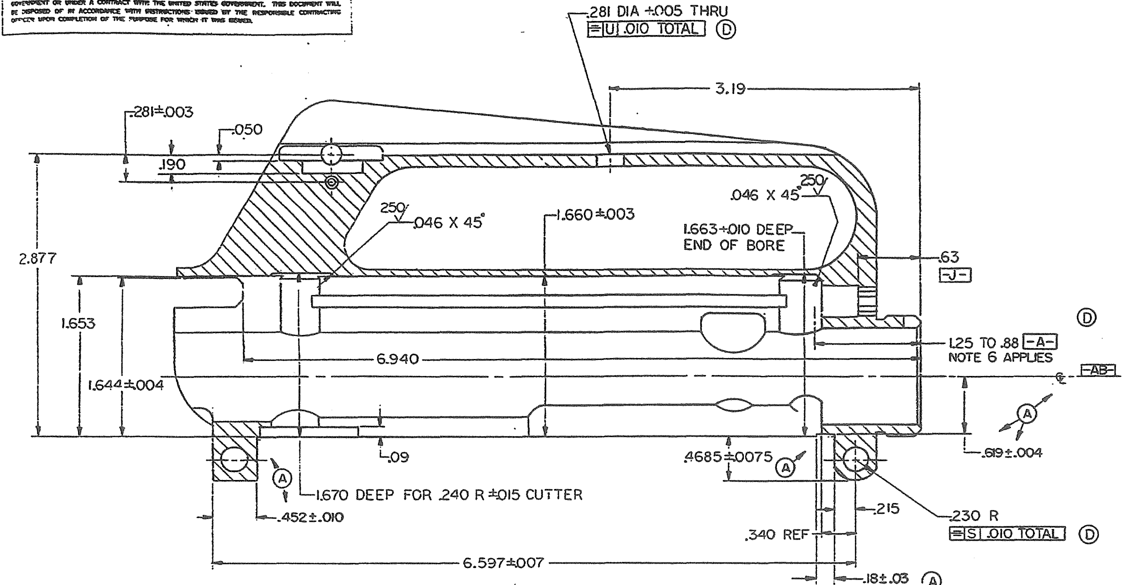
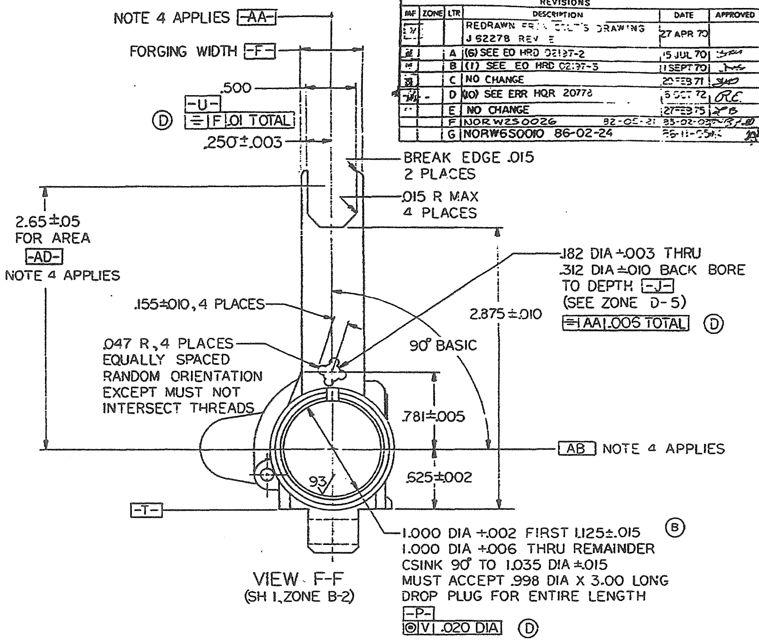
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J 62278 REV E	27 APR 70	
		A	(6) SEE EO HRD 02137-2	15 JUL 70	
		B	(1) SEE EO HRD 02137-5	11 SEPT 70	
		C	NO CHANGE	20 FEB 71	
		D	(10) SEE ERR HQR 20778	5 OCT 72	R.E.
		E	NO CHANGE	27 FEB 75	
		F	NORW2S0026 82-05-21	83-02-03	
		G	NORW6S0010 86-02-24	86-11-05	



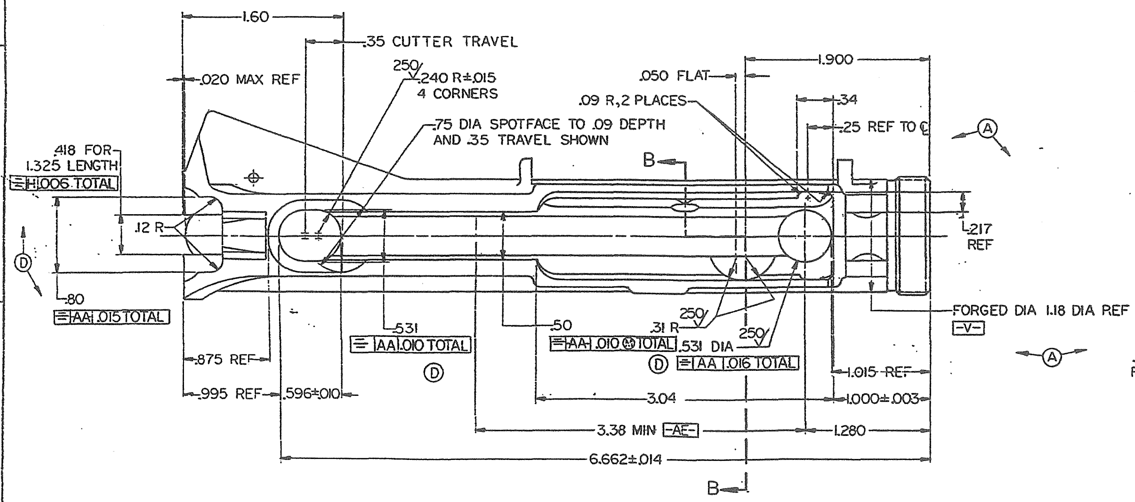
.281 DIA +.005 THRU
U .010 TOTAL (D)
3.19
.281±.003
.050
.190
.046 X 45°
250
1.660±.003
1.663+.010 DEEP END OF BORE
2.877
.63
-J-
1.653
(D)
6.940
1.25 TO .88 -A-
NOTE 6 APPLIES
-AB-
1.644±.004
(A)
.09
.4685±.0075
.619±.004
1.670 DEEP FOR .240 R ±.015 CUTTER
.452±.010
.215
.230 R
S .010 TOTAL (D)
.340 REF
6.597±.007
.18±.03 (A)

SECTION A-A
(SH 1, ZONE A-8)



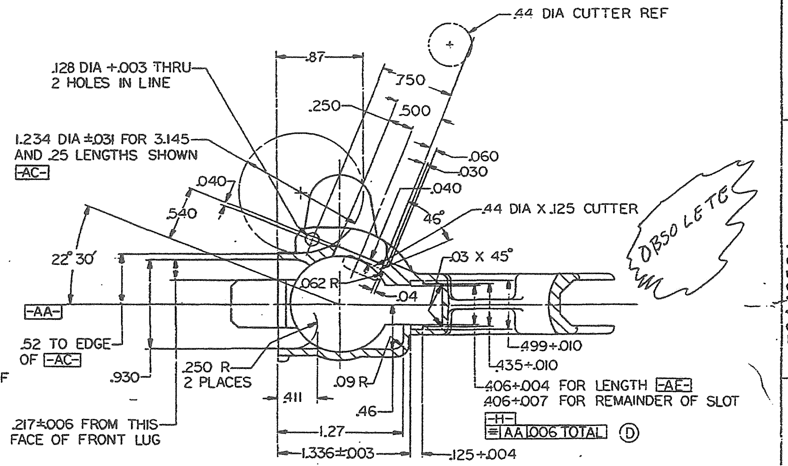
NOTE 4 APPLIES -AA-
FORGING WIDTH -F-
.500
-U-
(D) F .01 TOTAL
.250±.003
BREAK EDGE .015 2 PLACES
.015 R MAX 4 PLACES
2.65±.05 FOR AREA -AD-
NOTE 4 APPLIES
.182 DIA +.003 THRU
.312 DIA ±.010 BACK BORE TO DEPTH -J-
(SEE ZONE D-5)
AA .005 TOTAL (D)
.155±.010, 4 PLACES
2.875±.010
.047 R, 4 PLACES EQUALLY SPACED RANDOM ORIENTATION EXCEPT MUST NOT INTERSECT THREADS
90° BASIC
.781±.005
AB NOTE 4 APPLIES
.525±.002
93
-T-
1.000 DIA +.002 FIRST 1.125±.015 (B)
1.000 DIA +.006 THRU REMAINDER
CSINK 90° TO 1.035 DIA ±.015
MUST ACCEPT .998 DIA X 3.00 LONG DROP PLUG FOR ENTIRE LENGTH
-P-
V .020 DIA (D)

VIEW F-F
(SH 1, ZONE B-2)



1.60
.35 CUTTER TRAVEL
.020 MAX REF
250
.240 R±.015 4 CORNERS
.050 FLAT
1.900
.09 R, 2 PLACES
.34
.75 DIA SPOTFACE TO .09 DEPTH AND .35 TRAVEL SHOWN
.25 REF TO ℄
(A)
.418 FOR 1.325 LENGTH
H .006 TOTAL
B
.12 R
.217 REF
(D)
.80
AA .015 TOTAL
.531
AA .010 TOTAL
(D)
.50
AA .010 Ⓜ TOTAL
.31 R
250
250
.531 DIA
AA .016 TOTAL (D)
FORGED DIA 1.18 DIA REF
-V-
(A)
.875 REF
1.015 REF
.995 REF
.596±.010
3.04
1.000±.003
3.38 MIN -AE-
1.280
6.662±.014
B

VIEW G-G
(SH 1, ZONE A-6)



.44 DIA CUTTER REF
.87
.128 DIA +.003 THRU 2 HOLES IN LINE
.750
.250
.500
1.234 DIA ±.031 FOR 3.145 AND .25 LENGTHS SHOWN
-AC-
.060
.030
.040
.040
.540
.44 DIA X .125 CUTTER
46°
22° 30'
.03 X 45°
.062 R
.04
-AA-
.52 TO EDGE OF -AC-
.499+.010
.435+.010
.930
.250 R 2 PLACES
.09 R
.406+.004 FOR LENGTH -AE-
.406+.007 FOR REMAINDER OF SLOT
-H-
AA .006 TOTAL (D)
.411
.46
.217±.006 FROM THIS FACE OF FRONT LUG
1.27
1.336±.003
.125+.004

OBSOLETE

SECTION B-B

CURRENT DESIGN ACTIVITY FSCM NO. 19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL2	
RA	
BH	
RH	

NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RECEIVER, UPPER

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448524

SCALE 2/1 SHEET 2 OF 2

CD!

E8448524

AMSWE Form 403F, 29 Jul 69

October 15, 2004 11:00 AM

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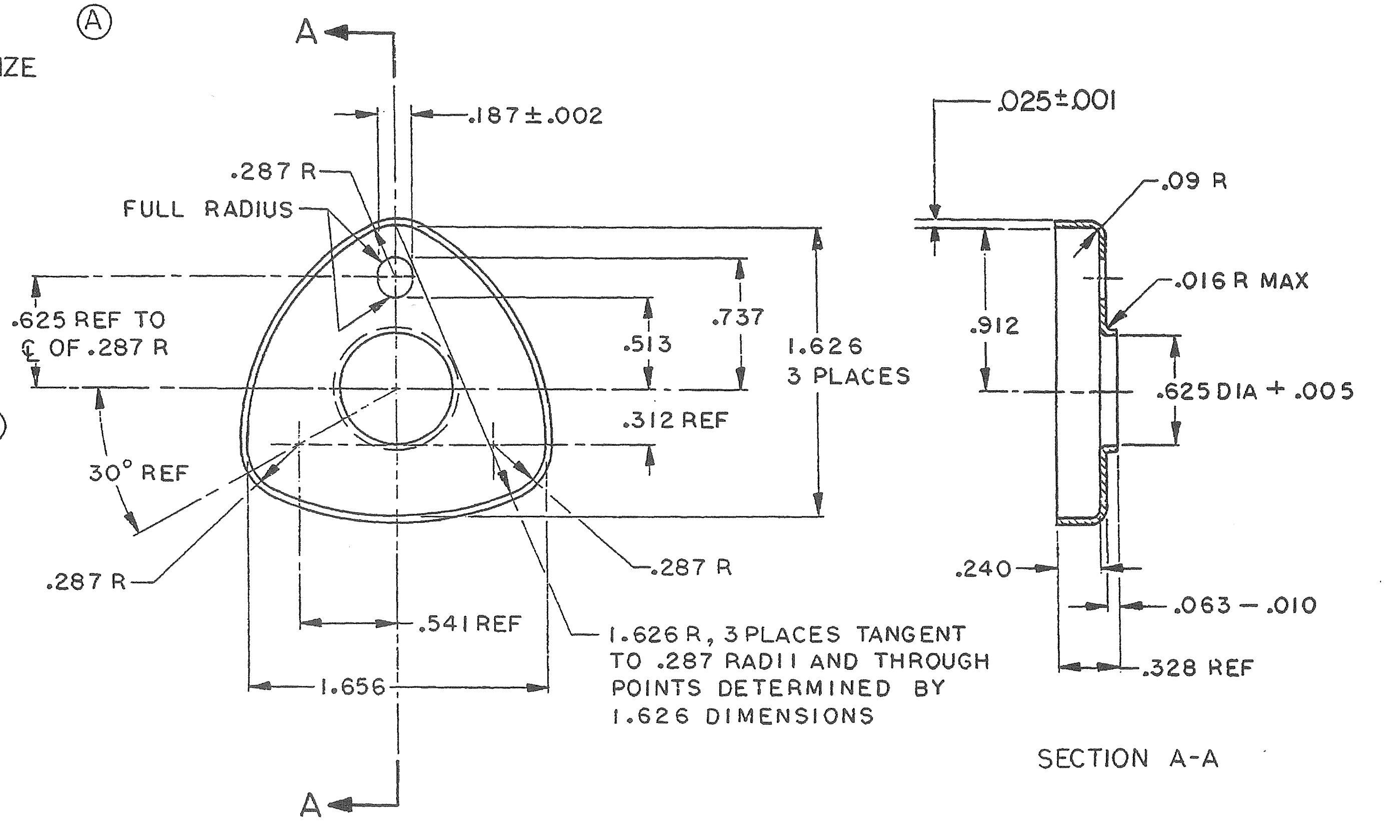
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62087 REVISION A	27APR 70	
		A	(3) SEE ERR HQR 20827	14 DEC 72	RC
		B	NORW12S0026 82-05-21	83-02-03	

NOTE:

1. STEEL, CMPSN 1045 THRU 1070, COLD ROLLED, SPHEROIDIZE ANNEALED, SPEC QQ-S-700.
2. FINISH 125/√.
3. BREAK SHARP EDGES .010R MAX.
4. FINISH 5.3.1.2 OF MIL-STD-171.
5. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓐ
6. MIL-W-13855 APPLIES.


Ⓐ
A
A
.187 ± .002
.287 R
FULL RADIUS
.625 REF TO ℄ OF .287 R
.513
.737
1.626 3 PLACES
.312 REF
30° REF
.287 R
.287 R
.541 REF
1.656
1.626 R, 3 PLACES TANGENT TO .287 RADII AND THROUGH POINTS DETERMINED BY 1.626 DIMENSIONS
.025 ± .001
.09 R
.016 R MAX
.912
.625 DIA + .005
.240
.063 − .010
.328 REF
SECTION A-A

C8448564

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

Ⓐ

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 79.5-81.5

NEXT ASSY	USED ON
F8448601	M16
F8448522	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO:

DATE 27 APR 1970

PREPARED		A.J.
CHECKED		H. Leedham
ENGINEER	D. Smart	D. Billet

SUBMITTED F. P. Gilhooly

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

CAP, HANDGUARD

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448564

SCALE 2/1 SHEET 1 OF 1

CD1

October 15, 2004 10:59 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
VI-		B	REPLACES REV A W/CHANGE SEE ERR HQR 20827	14 DEC 72	LB
		C	NOR W2S0011 / 82-04-13 (ECP W2S0034 / 82-07-15) (ECP W3S3120 / 83-07-07)	83-11-04	
		D	NOR G1S2018 91 07 08	91-10-11	RR

B8448574

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0180 ±.0005
COIL DIAMETER (O.D)	.115 ±.003
FREE LENGTH	.75 REF
TOTAL COILS	20 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .557 AFTER SET	1.78 LB ±.18 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	
SOLID LENGTH	.390 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631 (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900° F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012.

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448574

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390001	M4
EL 2		F8448601	M16
RA		F8448522	M16 A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 70

PREP	P. Vernon	L. Gutman
CHK	J. Dressel	D. Krolek
ENGR	R. Elbe	L. Brunton

SUBMITTED A. A. Cole

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, FRONT SIGHT DETENT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448574

SCALE — SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

October 15, 2004 10:58 AM

PARTS LIST PL-8448501
DOCUMENT/PART NUMBER D 8448501
BOLT CARRIER ASSEMBLY
CHANGE CONTROL NUMBER 76V0018 AUTHENTICATION-

ROCK ISLAND ARSENAL
ROCK ISLAND IL
CODE ID 19204

REV. DATE 16 APR 76
REVISION LETTER A
SHEET 1
ORIG. DATE 27 APR 70

FND NO.	QTY REQ	UNIT MEAS	CODE ID	PART OR IDENTIFYING NO	DRAWING/DOCUMENT SZE	NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP LST
	1			8448502	C	8448502	PIN, CAM	
	1			8448503	D	8448503	PIN, FIRING	
	1			8448504	B	8448504	PIN, RETAINING, FIRING PIN	
	1			8448505	C	8448505	KEY AND BOLT CARRIER ASSEMBLY	X
	1			8448509	C	8448509	BOLT ASSEMBLY	X

TOTAL NUMBER OF SHEETS 1

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

REVISIONS					
REF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		–	PRODUCT BASELINE ERR G5S3081	951211	HJS
		A	NOR L7S3059 971016 (ECP L8S3000 980126) (ECP L8S3007 980225)	980213	JB

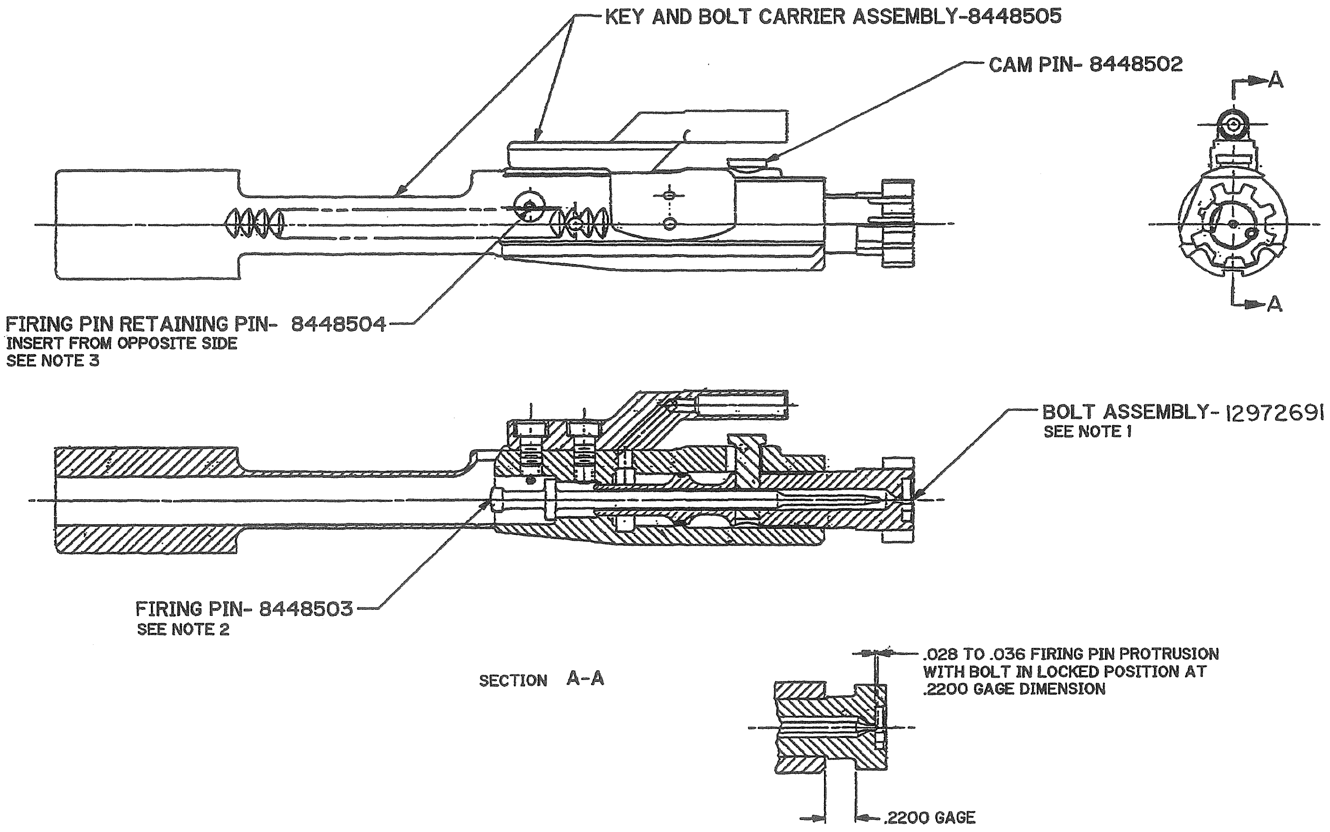
NOTES:-

1- BOLT ASSEMBLY- 12972691 MUST CAM FREELY IN KEY AND BOLT CARRIER ASSEMBLY- 8448505.

2- FIRING PIN- 8448503 MUST MOVE FREELY IN BOLT ASSEMBLY- 12972691.

3- FIRING PIN RETAINING PIN- 8448504 MUST BE SECURE AND MUST HOLD FIRING PIN SECURELY.

4- MIL-W-13855 APPLIES.


KEY AND BOLT CARRIER ASSEMBLY-8448505
CAM PIN- 8448502
A
A
FIRING PIN RETAINING PIN- 8448504
INSERT FROM OPPOSITE SIDE
SEE NOTE 3
BOLT ASSEMBLY- 12972691
SEE NOTE 1
FIRING PIN- 8448503
SEE NOTE 2
SECTION A-A
.028 TO .036 FIRING PIN PROTRUSION
WITH BOLT IN LOCKED POSITION AT
.2200 GAGE DIMENSION
.2200 GAGE

SEE PL- 8448501

PART NO. 12011849

DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

PMIC		
	8448600	M16
	8448500	M16A1
MECHANICAL PROPERTIES	9349000	M16A2
YP	12973001	M16A4
TS	12012000	M16A3
EL2	12972700	M4A1
RA	9390000	M4
BH	NEXT ASSY	USED ON
RH	APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ±
THIRD ANGLE PROJECTION
MATL ENGR

CONTRACT NUMBER
CONTRACTOR
DRAWN BY HJS
DATE(YR-MO-DA) 951211
CHECKER
ENGINEER
DRAWING APPROVAL
DESIGN APPROVAL

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

BOLT CARRIER ASSEMBLY

SIZE D
CAGE CODE 19200
12011849
SCALE 2/1
UNIT WT.
SHEET

AMSWE Form 403D, 29 Jul 69

October 15, 2004 10:58 AM

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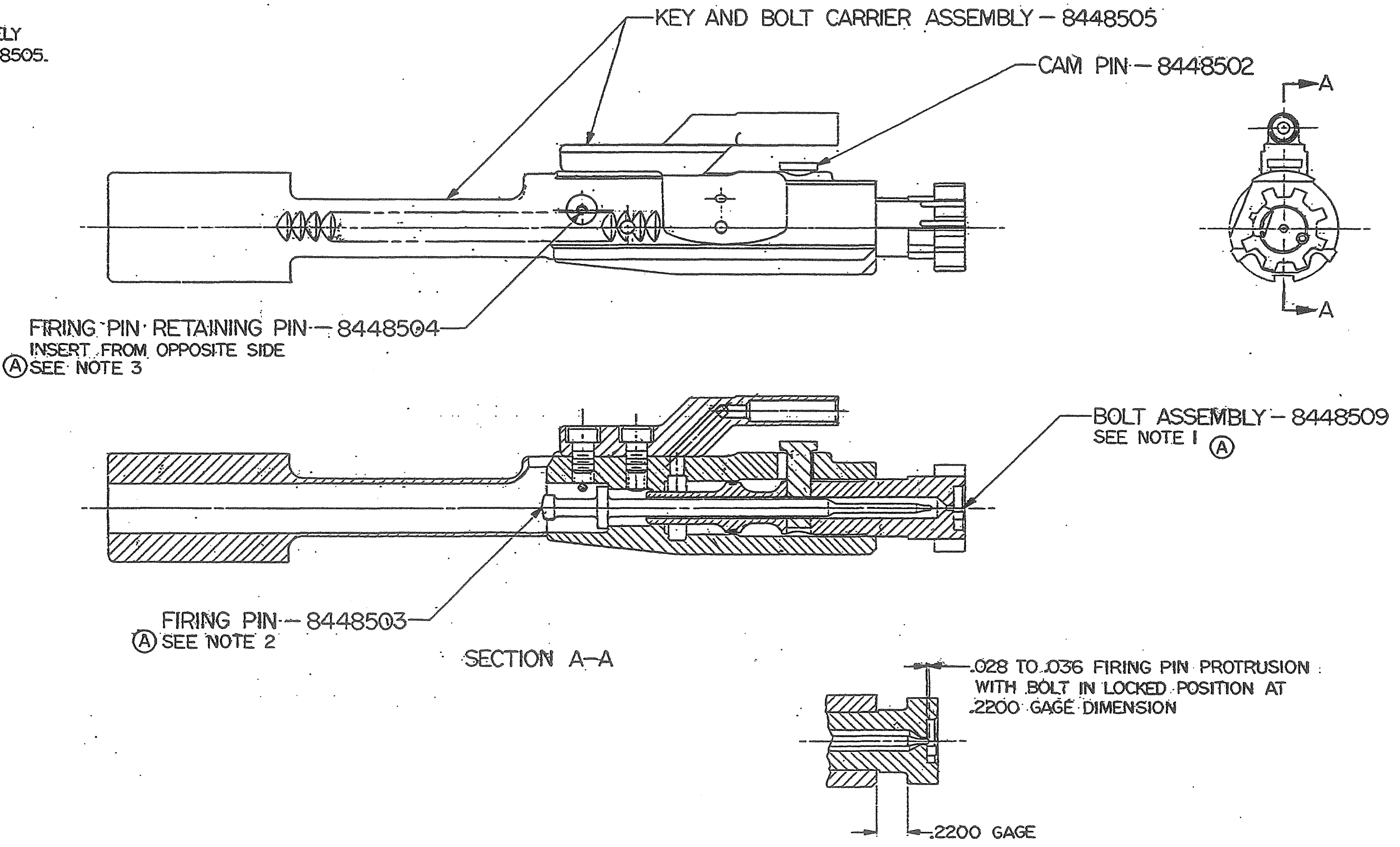
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING 062287 REV B	27 APR 70	
		A	(4)SEE ERR HQR 20778	6 OCT.72	R.E.
		B	NORW250026 82-05-21	83-02-03	
		C	NOR GIS2018 91 07 06	91-10-11	

NOTE
1. BOLT ASSEMBLY—8448509 MUST CAM FREELY IN KEY AND BOLT CARRIER ASSEMBLY—8448505.
2. FIRING PIN—8448503 MUST MOVE FREELY IN BOLT ASSEMBLY—8448509.
3. FIRING PIN RETAINING PIN—8448504 MUST BE SECURE AND MUST HOLD FIRING PIN SECURELY.
4. MIL-W-13855 APPLIES. Ⓐ


KEY AND BOLT CARRIER ASSEMBLY—8448505
CAM PIN—8448502
A
A
FIRING PIN RETAINING PIN—8448504
INSERT FROM OPPOSITE SIDE
Ⓐ SEE NOTE 3
BOLT ASSEMBLY—8448509
SEE NOTE 1 Ⓐ
FIRING PIN—8448503
Ⓐ SEE NOTE 2
SECTION A–A
.028 TO .036 FIRING PIN PROTRUSION
WITH BOLT IN LOCKED POSITION AT
.2200 GAGE DIMENSION
.2200 GAGE

SEE PL 8448501

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± — 3 PLACE DECIMALS ± — 2 PLACE DECIMALS ± —	CONTRACT NO:
YS MIN					
YS MAX					DATE 27 APR 1970
EL2				MATERIAL	PREPARED MSC
RA		9390000	M4		CHECKED
BH		F8448600	M16		ENGINEER
		F8448500	M16A1		SUBMITTED
RH		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED R.S. Henry
		APPLICATION			

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BOLT CARRIER ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448501

SCALE 2/1 SHEET OF

CDI

D8448501

ASWE Form 403D, 29 Jul 69

October 15, 2004 10:57 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	
		C	NORW2S0011 / 82-04-13 (ECPW2S0034 / 82-07-15)	83-11-04	
		D	ERR Z9Z1182AN (ECP G8S3111 881109)	890828	

8448538

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0220 ± .0005
COIL DIAMETER (O.D)	.118 ± .003
FREE LENGTH	.500 REF
TOTAL COILS	13 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .370	4.29 LB ± .43 LB
LOAD AT COMPRESSED LENGTH OF	———
SPRING RATE	———
SOLID LENGTH	.315 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, CORROSION RESISTING, TYPE 631, (17-7PH), ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448538

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 84.5 MIN

NEXT ASSY	USED ON
D8448602	M16
D8448523	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 70

PREP	P. Vernon	L. Gutman
CHK	G. Dresselhaus	D. Krolek
ENGR	R. Elbe	L. Brunton

SUBMITTED A. A. Cole

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, REAR SIGHT DETENT

SIZE	CCDE IDENT NO.	DRAWING NO.
B	19204	8448538

SCALE —— SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

DUPLICATE ORIGINAL

DRAWING SIZE C

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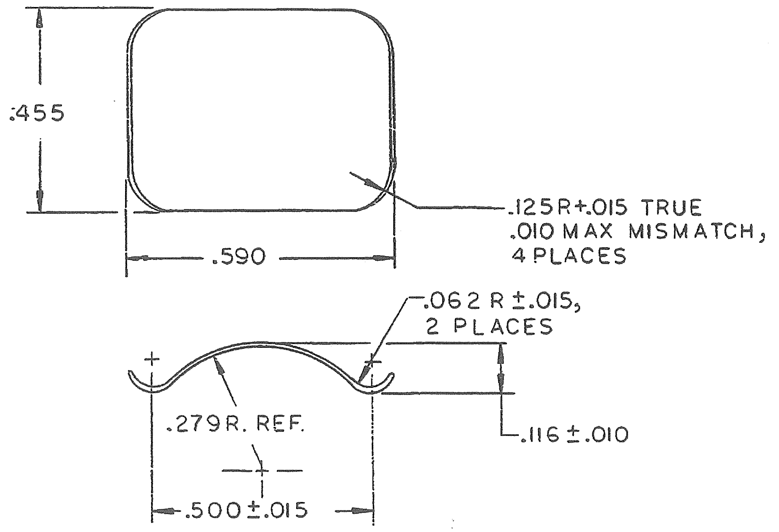
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	–	PRODUCT BASELINE ERR GIS3098	91-10-10	RR
	A	NOR G3S3028/930413	93-05-21	

NOTES:

1. STEEL, CARBON, UNTEMPERED SPRING QUALITY, ANEALED, CMPSN 1095, SPEC ASTM A684 OR AMS 5121, .010 ± .001 THICK.
2. FINISH 63√ EXCEPT SHEARED EDGES 250√.
3. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
4. MIL-W-13855 APPLIES.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2. OF MIL-STD-171.
6. HARDNESS: DPH484-528.



PART NO. 12011987

PMIC		
MECHANICAL PROPERTIES		
YP		
TS		
EL2	8448602	M16
RA	8448523	M16A1
BH	NEXT ASSY	USED ON
RH	APPLICATION	

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ± .005

THIRD ANGLE PROJECTION

MATL ENGR

CONTRACT NUMBER

CONTRACTOR

DRAWN BY	DATE (YR-MO-DA)
R.C.R.	91-10-10
CHECKER	ENGINEER

DRAWING APPROVAL

DESIGN APPROVAL

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SPRING REAR SIGHT

SIZE	CAGE CODE	
C	19200	12011987
SCALE NONE	UNIT WT.	SHEET

SMCAR FORM 67, 1 DEC 87(TEMP). REPLACES SMCAR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 10:55 AM

5 4 3 2 1

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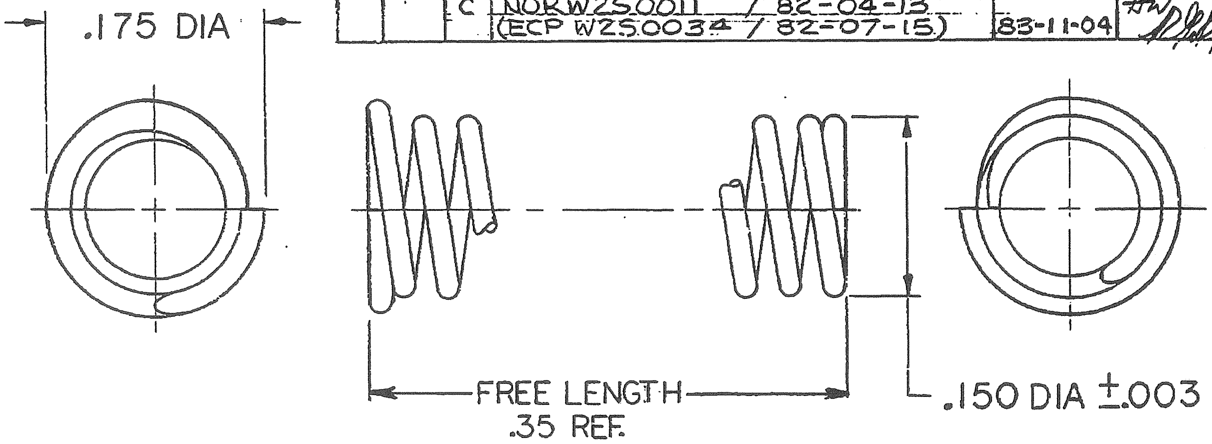
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61925 REVISION A	27 APR 70	
		A	(1) SEE EO HRD 02197-3	15 JULY 70	
		B	(4) SEE ERR HQR 20778	6 OCT 72	LB
		C	NORW25OO11 / 82-04-13 (ECP W25OO34 / 82-07-15)	83-11-04	HW

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900° F ± 10° FOR 1 HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.



SPRING DATA
TYPE OF ENDS – ONE CLOSED AND GROUND
– ONE CLOSED, FLARED AND GROUND
WIRE DIA .0200 ± .0005
DIRECTION OF HELIX – OPTIONAL
TOTAL COILS – 7 REF
LOAD AT COMPRESSED LENGTH OF .217 IN. = 2.79 LB ± .28 LB
MAX. SOLID LENGTH – .150

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572 Ⓑ

CURRENT DESIGN ACTIVITY FSCM NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			M16
RA		B8448591	M16A1
BH		NEXT ASSY	USED ON
RH	15N-84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970
PREP P.A.R. A.J.H.
CHK D.A.W. W. Ludham
ENGR D. Smart D. Gilliet
SUBMITTED F.P. McElhosky
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, DISCONNECT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448594
SCALE 10/1		SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CDI

B8448594

October 15, 2004 11:36 AM

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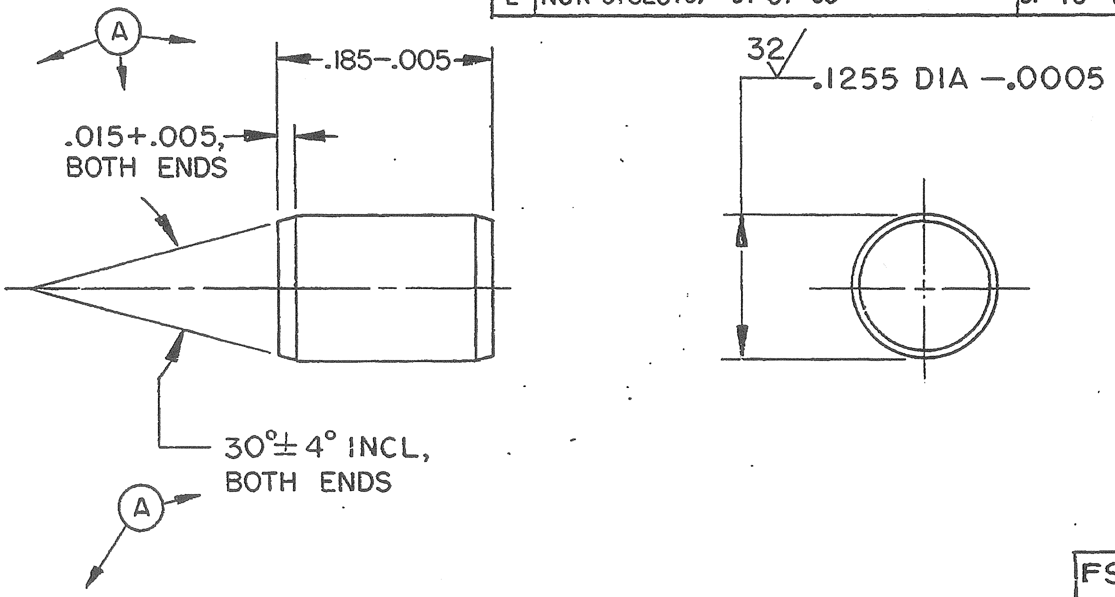
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61671 REVISION B	27 APR 70	
		A	(2) SEE ERR HQR 10906	15 DEC 71	
		B	(4) SEE ERR HQR 20827	14 DEC 72	
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W3S3133/83-08-25	83-11-04	
		E	NOR G1S2018/ 91-07-08	91-10-11	RR

NOTES:

1. FINISH 125√ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 MAX.
3. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓑ
4. STEEL, CARBON, CMPSN 1137, 11L37 OR 1141, 11L41, SPEC ASTM A108-81.
5. MIL-W-13855 APPLIES.



Ⓑ

CURRENT

FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61202

MECHANICAL PROPERTIES		
YS MIN		
YS MAX	9390009	M4
EL 2	F9327056	M231
RA		M16
BH	F8448548	M16A1
	NEXT ASSY	USED ON
RH 15N 78.5-80.5	APPLICATION	

Ⓑ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL: SEE NOTE 4

FINAL PROTECTIVE FINISH: —

CONTRACT NO:
DATE 27 APR 1970
PREP RGA
CHK
ENGR
SUBMITTED
APPROVED

PIN, BARREL INDEXING

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448551

SCALE 10/1 SHEET 1 OF 1

B8448551

AMSWE Form 403B, 29 Jul 69

CDI

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5 4 3 2 1

D C B A

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778	6 OCT 72	
		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)	83-11-04	
		F	ERR Z9Z1251W (ECP G9S2036/890721)	900403	ORFI-CHT
		G	NOR GIS2018 91-07-08	91-10-11	RR SL

B8448516

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC ASTM-A228. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ± 25° FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003+.012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0240 ± .0003
COIL DIAMETER (O.D.)	.103 ± .003
FREE LENGTH AFTER SETTING	.926 REF
TOTAL COILS	27 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .850	2.94 LB ± .30 LB
LOAD AT COMPRESSED LENGTH OF .784	5.50 LB ± .25 LB
SPRING RATE	
SOLID LENGTH	.650 MAX
TYPE OF ENDS	SQUARED, GROUND

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

CURRENT

FSCM NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448516

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		8448509	M4
YS MAX		F9327230	M231
EL 2			M16
RA		C8448509	M16A1
BH		F8448604	M16
RH		F8448578	M16A1
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 27 APR 70

PREP	P.V.	L.P.
CHK	G.D.	D.K.
ENGR	R.E.	L.B.

SUBMITTED
A.A. COLE

APPROVED
R.S. HENRY

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

SPRING, EJECTOR AND SAFETY DETENT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448516

SCALE NONE SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

SCANNED DUPLICATE ORIGINAL

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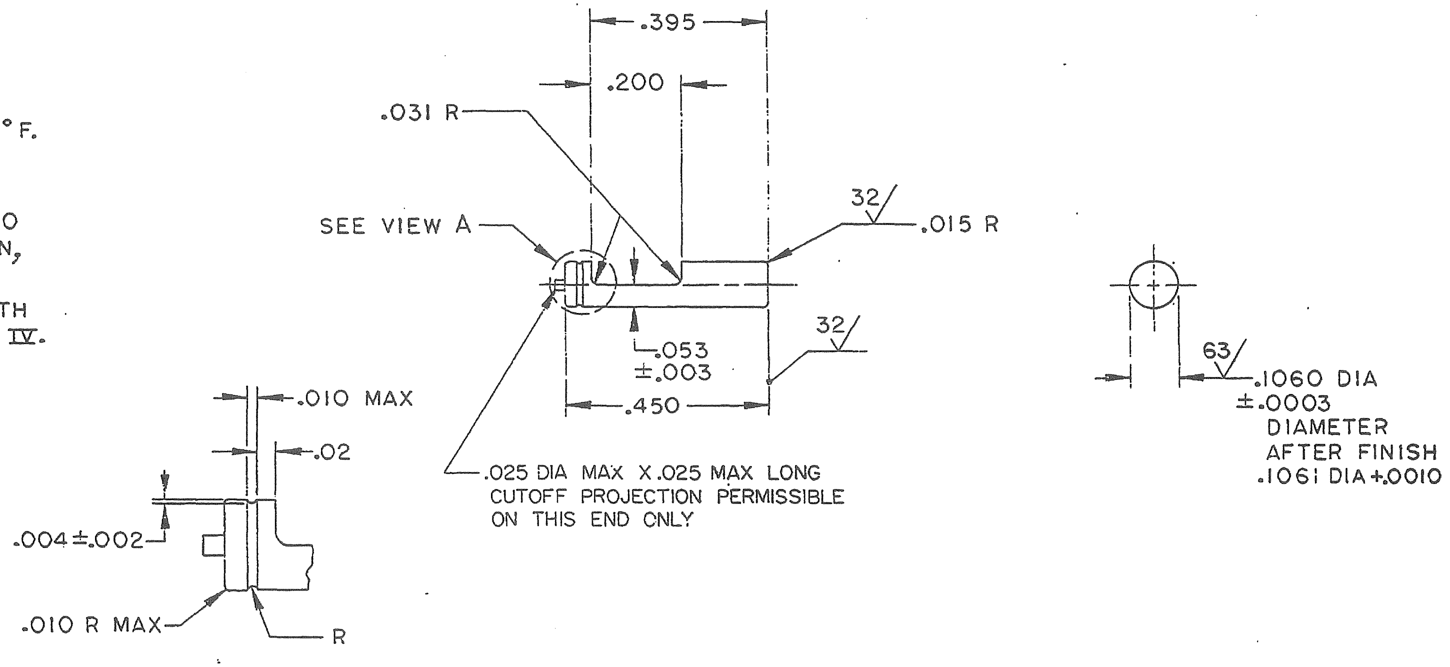
REVISIONS					
MF.	ZONE	LTR	DESCRIPTION	DATE	APPROVED
LM			REDRAWN FROM COLT'S DRAWING C61564 REVISION B	27 APR 70	
M		A	(3) SEE EO HRD 02255	15 OCT 70	F.P. Fillinoly
M		B	(2) SEE ERR HQR 20778	6 OCT 72	R.S.
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	ERR ~~Z9Z~~1251W (ECP G9S2036/890721)	900403	
		E	NOR G1S2018 91-07-08	91-10-11	RB
		F	NOR G2S3025 920330	920427	

NOTE:

1. FINISH $\overset{125}{\surd}$ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 R MAX.
3. OIL QUENCH FROM 1600° F. TEMPER AT 275° F TO 400° F.
4. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005-.007-A2 ALMEN, 150 % COVERAGE.
5. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



VIEW A
SCALE 10/1

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA			8448509	M4
			C9327073	M231
BH				M16
			C8448509	M16A1
RH	15N 88.5 -90.5		NEXT ASSY	USED ON
			APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ———
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
TOOL STEEL, TYPE S2, ASTM-A681

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO:

DATE 27 APR 1970

PREPARED	RGA	
CHECKED		H.L.
ENGINEER	D.S.	D.B.

SUBMITTED
F. P. FILLINOLY

APPROVED
R.S. HENRY

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

EJECTOR

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448515

SCALE 5/1 SHEET 1 OF 1

C8448515

DISTRIBUTION STATEMENT E
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL; OR HIGHER DoD AUTHORITY
ASQNC-AR: 920310.

AMSWE Form 403C, 29 Jul 69

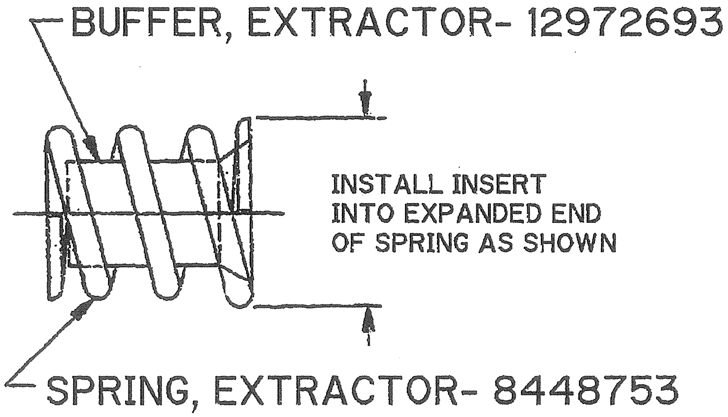
SCANNED DUPLICATE ORIGINAL CDI

October 15, 2004 11:26 AM

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	—	PRODUCT BASELINE ERR G5S3081	951211	HJS

NOTES:-

1- MIL-W-13855 APPLIES.



INSTALL INSERT
INTO EXPANDED END
OF SPRING AS SHOWN

DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

PART NO. 12972692

PMIC		
MECHANICAL PROPERTIES		
YP		
TS		
EL2		
RA		
BH	12972691	M4/M4A1
RH	NEXT ASSY	USED ON
	APPLICATION	

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON

DECIMAL	FRACTION
2 PL ±	±
3 PL ±	

THIRD ANGLE PROJECTION

MATL ENGR

CONTRACT NUMBER

CONTRACTOR

DRAWN BY HJS	DATE(YR-MO-DA) 951211
CHECKER	ENGINEER
DRAWING APPROVAL	
DESIGN APPROVAL	

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH. DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL. NEW JERSEY 07806-5000

SPRING ASSY, EXTRACTOR

SIZE	CAGE CODE	
B	19200	12972692
SCALE 10/1	UNIT WT.	SHEET

SMCAR FORM 66. 1 MAR 88(TEMP) REPLACES SMCAR FORM 66. 1 JUL 87(TEMP)
WHICH MAY BE USED UNTIL EXHAUSTED

October 15, 2004 11:26 AM

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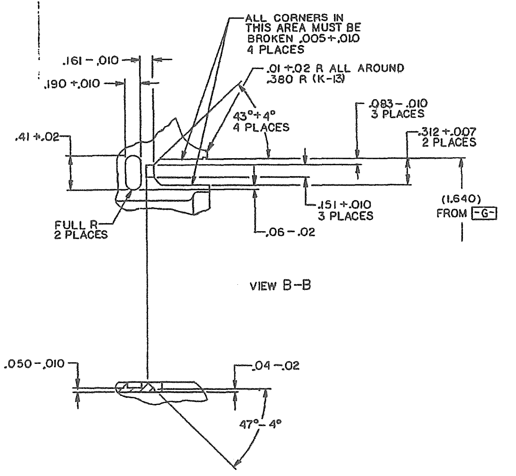
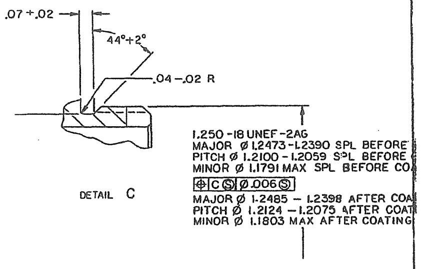
NOTES:-

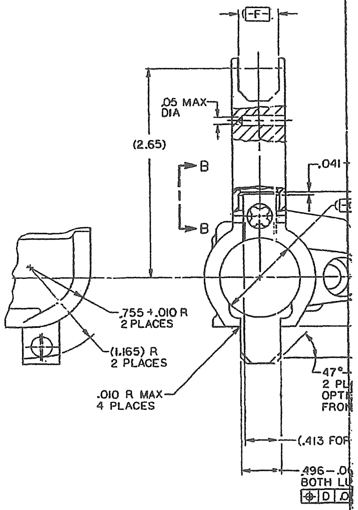
1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL:-MAKE FROM FORGING, UPPER RECEIVER-12576279.
3- CENTER LINE -D- (H-7) AND -J- (E-7) ARE ESTABLISHED WHEN LOCATING ON Ø -C-, AND SLOT -F- AT AREA -T- (G-12).
4- WITNESS MARK (K-11) TO DETERMINE STARTING POINT FOR MACHINING.
5- ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
6- BREAK SHARP EDGES .005 + .010 UNLESS OTHERWISE NOTED.
7- FILLET RADII .015 - .012 UNLESS OTHERWISE NOTED.
8- EVERLUBE 626 OR 626S CURED AT 275°F ± 25°F FOR 1 HOUR OR MIL-L-46010 CURED 300°F TO 325°F FOR 2 HOURS, TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .875 TO 1.25 LENGTH (B-19). FILM THICKNESS .0002 + .0001.
9- FINISH 125/ ALL MACHINED SURFACES, EXCEPT AS NOTED.
10- PROTECTIVE FINISH:- MIL-A-8625. TYPE III CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, BUT NOT LIGHTER THAN GRAY, NO. 36076, OF FED-STD-595, AND SEAL. GRIT BLAST PRIOR TO FINISH TO PROVIDE NON REFLECTIVE MATTE SURFACE AFTER FINISH.
11- LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND 1.06 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT -F-

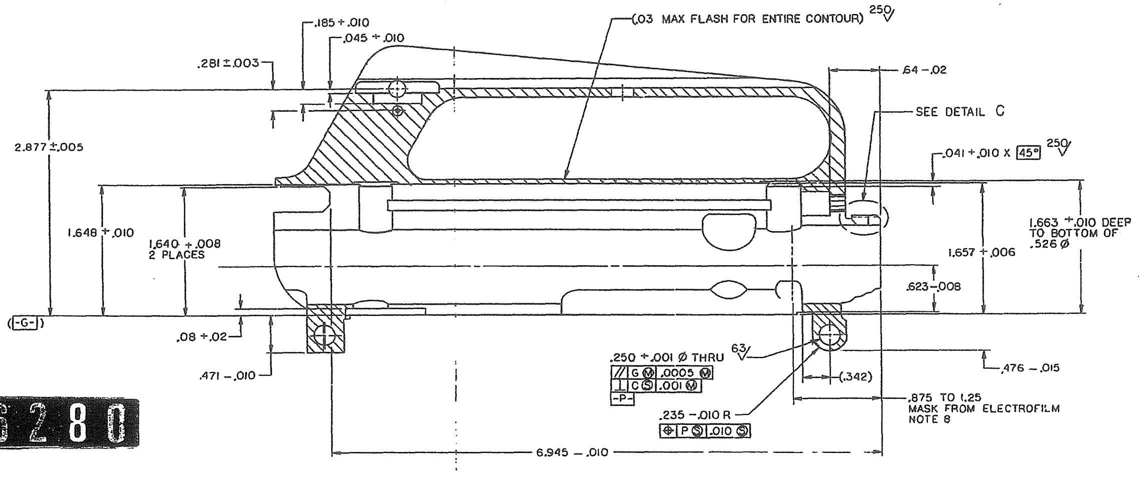

ALL CORNERS IN THIS AREA MUST BE BROKEN .005 + .010 4 PLACES
.161 - .010
.190 + .010
.01 + .02 R ALL AROUND .380 R (K-13)
43° + 4° 4 PLACES
.083 - .010 3 PLACES
.312 + .007 2 PLACES
.41 + .02
(1.640) FROM -G-
.151 + .010 3 PLACES
FULL R 2 PLACES
.06 - .02
.050 - .010
.04 - .02
47° - 4°

VIEW B-B


.07 + .02
44° + 2°
.04 - .02 R
1.250 - 18 UNEF - 2AG
MAJOR Ø 1.2473 - 1.2390 SPL BEFORE
PITCH Ø 1.2100 - 1.2059 SPL BEFORE
MINOR Ø 1.1791 MAX SPL BEFORE CO
⊕ C Ⓢ Ø .006 Ⓢ
MAJOR Ø 1.2485 - 1.2398 AFTER COA
PITCH Ø 1.2124 - 1.2075 AFTER COAT
MINOR Ø 1.1803 MAX AFTER COATING

DETAIL C


-F-
.05 MAX DIA
(2.65)
B
B
.041
.755 + .010 R 2 PLACES
(1.165) R 2 PLACES
.010 R MAX 4 PLACES
47°
2 PL
OPTI
FRON
(.413 FOR
.496 - .0
BOTH LU
⊕ D .0


.185 + .010
.045 + .010
.281 ± .003
(.03 MAX FLASH FOR ENTIRE CONTOUR) 250√
.64 - .02
SEE DETAIL C
2.877 ± .005
.041 + .010 X 45° 250√
1.648 + .010
1.640 + .008 2 PLACES
1.663 + .010 DEEP TO BOTTOM OF .526 Ø
1.657 + .006
.623 - .008
(-G-)
.08 + .02
.250 + .001 Ø THRU 63√
// G Ⓜ .0005 Ⓜ
⊥ C Ⓢ .001 Ⓜ
-P-
.476 - .015
.471 - .010
(.342)
.875 TO 1.25 MASK FROM ELECTROFILM NOTE 8
.235 - .010 R
⊕ P Ⓢ .010 Ⓢ
6.945 - .010

SECTION A-A

J12576280
REV. -
F-1/3

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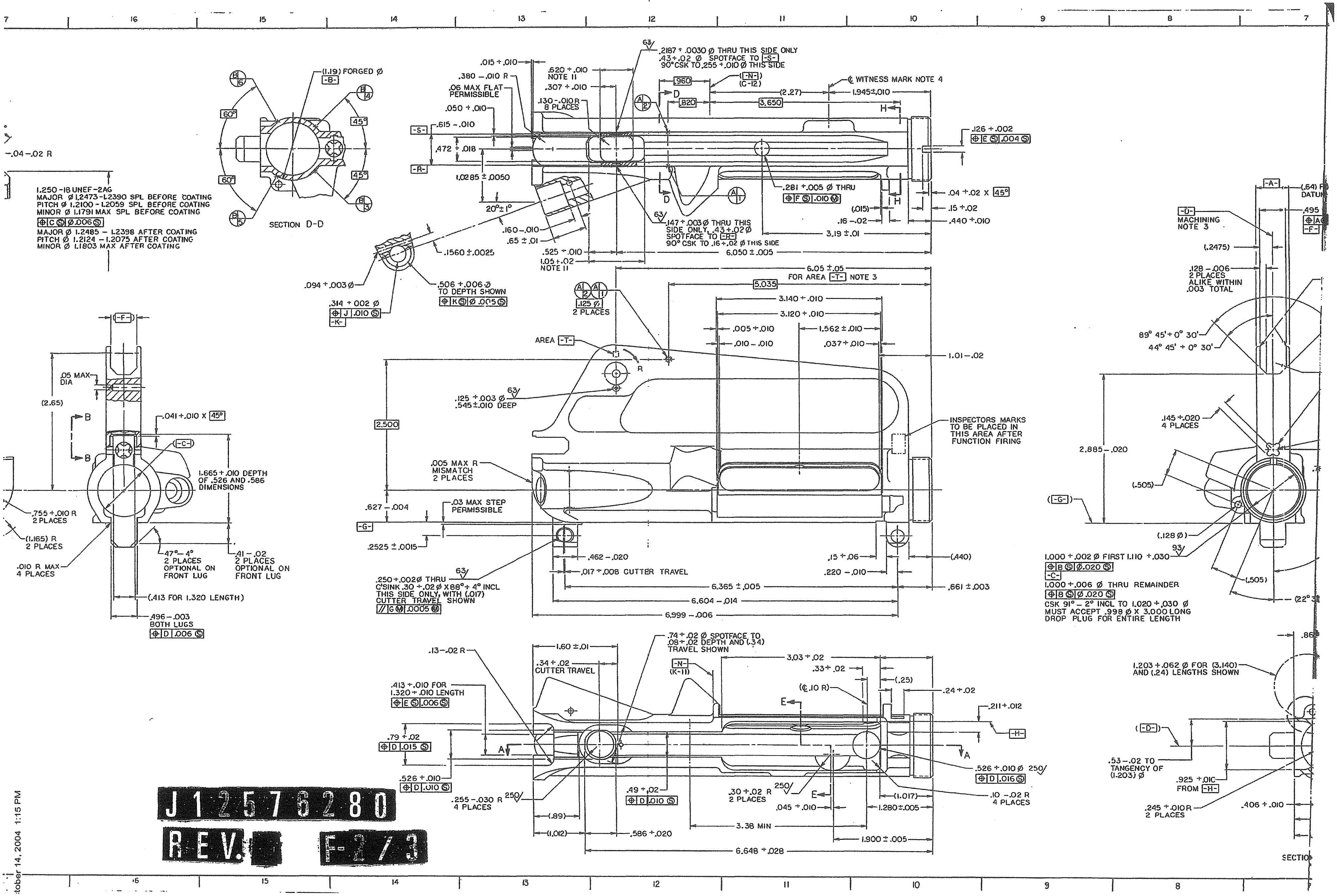

7
16
15
14
13
12
11
10
9
8
7
-.04-.02 R
1.250 -18 UNEF-2AG
MAJOR Ø 1.2473-1.2390 SPL BEFORE COATING
PITCH Ø 1.2100-1.2059 SPL BEFORE COATING
MINOR Ø 1.1791 MAX SPL BEFORE COATING
⊕ C Ⓢ Ø.006 Ⓢ
MAJOR Ø 1.2485 - 1.2398 AFTER COATING
PITCH Ø 1.2124 - 1.2075 AFTER COATING
MINOR Ø 1.1803 MAX AFTER COATING
(1.19) FORGED Ø
-B-
60°
45°
60°
45°
SECTION D-D
.015 + .010
.380 - .010 R
.06 MAX FLAT PERMISSIBLE
.050 + .010
.620 + .010 NOTE 11
.307 + .010
.130-.010 R 8 PLACES
63
.2187 + .0030 Ø THRU THIS SIDE ONLY
.43 + .02 Ø SPOTFACE TO -S-
90° CSK TO .255 + .010 Ø THIS SIDE
960
(-N-) (C-12)
℄ WITNESS MARK NOTE 4
D
.820
(2.27)
1.945±.010
3.650
H
-S-
.615 - .010
.472 + .018
.126 + .002
⊕ E Ⓢ .004 Ⓢ
-R-
1.0285 ± .0050
20° ± 1°
D
.281 + .005 Ø THRU
⊕ F Ⓢ .010 Ⓜ
.04 + .02 X 45°
.15 + .02
(.015)
H
.16 - .02
.440 + .010
.160 - .010
.65 ± .01
63
.147 + .003 Ø THRU THIS SIDE ONLY, .43 + .02 Ø SPOTFACE TO -R-
90° CSK TO .16 + .02 Ø THIS SIDE
3.19 ± .01
.1560 ± .0025
.525 + .010
1.05 + .02 NOTE 11
6.050 ± .005
.094 + .003 Ø
.506 + .006 Ø TO DEPTH SHOWN
⊕ K Ⓢ Ø .005 Ⓢ
.314 + .002 Ø
⊕ J .010 Ⓢ
-K-
6.05 ± .05
FOR AREA -T- NOTE 3
5.035
.125 Ø
2 PLACES
3.140 + .010
3.120 + .010
.005 + .010
1.562 ± .010
.010 - .010
.037 + .010
AREA -T-
R
1.01 - .02
.125 + .003 Ø
.545 ± .010 DEEP
63
2.500
INSPECTORS MARKS TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
.005 MAX R MISMATCH 2 PLACES
.627 - .004
.03 MAX STEP PERMISSIBLE
-G-
.2525 ± .0015
.462 - .020
.15 + .06
(.440)
.017 + .008 CUTTER TRAVEL
.220 - .010
63
.250 + .002 Ø THRU
C'SINK .30 + .02 Ø X 88° + 4° INCL
THIS SIDE ONLY, WITH (.017) CUTTER TRAVEL SHOWN
// G Ⓜ .0005 Ⓜ
6.365 ± .005
.661 ± .003
6.604 - .014
6.999 - .006
-F-
.05 MAX DIA
(2.65)
B
B
.041 + .010 X 45°
-C-
1.665 + .010 DEPTH OF .526 AND .586 DIMENSIONS
.755 + .010 R 2 PLACES
(1.165) R 2 PLACES
.010 R MAX 4 PLACES
47° - 4° 2 PLACES OPTIONAL ON FRONT LUG
.41 - .02 2 PLACES OPTIONAL ON FRONT LUG
(.413 FOR 1.320 LENGTH)
.496 - .003 BOTH LUGS
⊕ D .006 Ⓢ
-A-
(.64)
DATUM
.495
-D-
MACHINING NOTE 3
⊕ A
-F-
(.2475)
.128 - .006 2 PLACES ALIKE WITHIN .003 TOTAL
89° 45' + 0° 30'
44° 45' + 0° 30'
.145 + .020 4 PLACES
2.885 - .020
(.505)
(-G-)
(.128 Ø)
93
1.000 + .002 Ø FIRST 1.110 + .030
⊕ B Ⓢ Ø .020 Ⓢ
-C-
1.000 + .006 Ø THRU REMAINDER
⊕ B Ⓢ Ø .020 Ⓢ
CSK 91° - 2° INCL TO 1.020 + .030 Ø
MUST ACCEPT .998 Ø X 3.000 LONG DROP PLUG FOR ENTIRE LENGTH
(.505)
(22° 3
.13 - .02 R
1.60 ± .01
.34 + .02 CUTTER TRAVEL
.74 + .02 Ø SPOTFACE TO .08 + .02 DEPTH AND (.34) TRAVEL SHOWN
-N- (K-11)
3.03 + .02
.33 + .02
(.25)
(℄ .10 R)
.24 + .02
.413 + .010 FOR 1.320 + .010 LENGTH
⊕ E Ⓢ .006 Ⓢ
E
.211 + .012
-H-
.79 + .02
⊕ D .015 Ⓢ
A
A
.526 + .010
⊕ D .010 Ⓢ
.526 + .010 Ø 250
⊕ D .016 Ⓢ
.255 - .030 R 4 PLACES
250
.49 + .02
⊕ D .010 Ⓢ
250
.30 + .02 R 2 PLACES
E
(1.017)
.10 - .02 R 4 PLACES
.045 + .010
1.280 ± .005
(.89)
(1.012)
.586 + .020
3.38 MIN
1.900 ± .005
6.648 + .028
.86
1.203 + .062 Ø FOR (3.140) AND (.24) LENGTHS SHOWN
(-D-)
.53 - .02 TO TANGENCY OF (1.203) Ø
.925 + .010 FROM -H-
.245 + .010 R 2 PLACES
.406 + .010
SECTIO
16
15
14
13
12
11
10
9
8

J12576280

REV. F-2/3

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NOTICE: RESTRICTIONS ON USE AND DISCLOSURE

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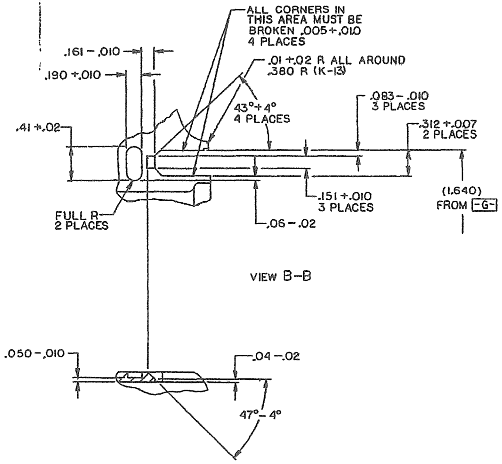
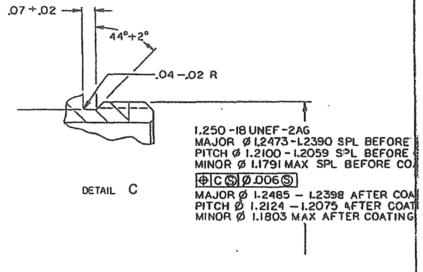
NOTES:-

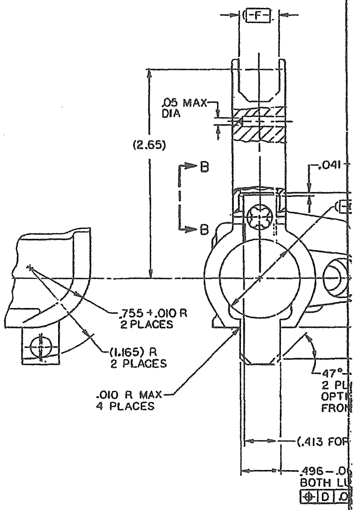
1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL:-MAKE FROM FORGING, UPPER RECEIVER-12576279.
3- CENTER LINE -D- (H-7) AND -J- (E-7) ARE ESTABLISHED WHEN LOCATING ON Ø -C-, AND SLOT -F- AT AREA -T- (G-12).
4- WITNESS MARK (K-11) TO DETERMINE STARTING POINT FOR MACHINING.
5- ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
6- BREAK SHARP EDGES .005 + .010 UNLESS OTHERWISE NOTED.
7- FILLET RADII .015 - .012 UNLESS OTHERWISE NOTED.
8- EVERLUBE 626 OR 626S CURED AT 275° F ± 25° F FOR 1 HOUR OR MIL-L-46010 CURED 300° F TO 325° F FOR 2 HOURS, TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .875 TO 1.25 LENGTH (B-19). FILM THICKNESS .0002 + .0001.
9- FINISH 125/ ALL MACHINED SURFACES, EXCEPT AS NOTED.
10- PROTECTIVE FINISH:-MIL-A-8625. TYPE III CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, BUT NOT LIGHTER THAN GRAY, NO. 36076, OF FED-STD-595, AND SEAL. GRIT BLAST PRIOR TO FINISH TO PROVIDE NON REFLECTIVE MATTE SURFACE AFTER FINISH.
11- LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND 1.06 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT -F-

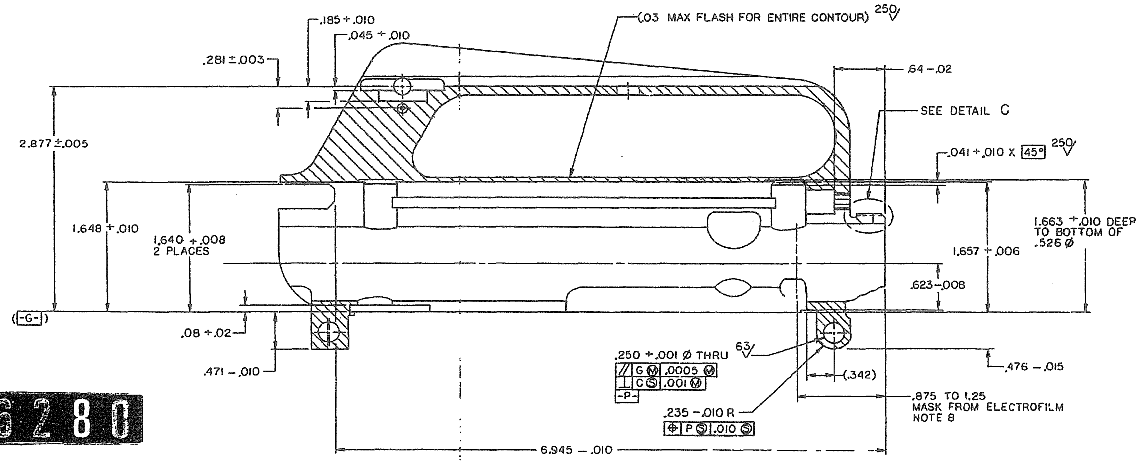

ALL CORNERS IN THIS AREA MUST BE BROKEN .005 + .010 4 PLACES
.161 - .010
.190 + .010
.01 + .02 R ALL AROUND
.380 R (K-13)
43° + 4°
4 PLACES
.083 - .010
3 PLACES
.312 + .007
2 PLACES
.41 + .02
.151 + .010
3 PLACES
(1.640)
FROM -G-
FULL R
2 PLACES
.06 - .02
.050 - .010
.04 - .02
47° - 4°

VIEW B-B


.07 + .02
44° + 2°
.04 - .02 R
1.250 -18 UNEF -2AG
MAJOR Ø 1.2473 - 1.2390 SPL BEFORE
PITCH Ø 1.2100 - 1.2059 SPL BEFORE
MINOR Ø 1.1791 MAX SPL BEFORE CO
⊕ C Ⓢ Ø .006 Ⓢ
MAJOR Ø 1.2485 - 1.2398 AFTER COA
PITCH Ø 1.2124 - 1.2075 AFTER COAT
MINOR Ø 1.1803 MAX AFTER COATING

DETAIL C


-F-
.05 MAX DIA
(2.65)
B
B
.041
.755 + .010 R
2 PLACES
(1.165) R
2 PLACES
.010 R MAX
4 PLACES
47°
2 PL
OPTI
FRON
(.413 FOR
.496 - .0
BOTH LU
⊕ D .0


.185 + .010
.045 + .010
.281 ± .003
(.03 MAX FLASH FOR ENTIRE CONTOUR) 250/
.64 - .02
SEE DETAIL C
.041 + .010 X 45° 250/
2.877 ± .005
1.648 + .010
1.640 + .008
2 PLACES
1.663 + .010 DEEP TO BOTTOM OF .526 Ø
1.657 + .006
.623 - .008
-G-
.08 + .02
.471 - .010
.250 + .001 Ø THRU 63/
// G Ⓜ .0005 Ⓜ
⊥ C Ⓢ .001 Ⓜ
-P-
(.342)
.476 - .015
.235 - .010 R
⊕ P Ⓢ .010 Ⓢ
.875 TO 1.25
MASK FROM ELECTROFILM
NOTE 8
6.945 - .010

SECTION A-A

J12576280
REV. -
F-1/3

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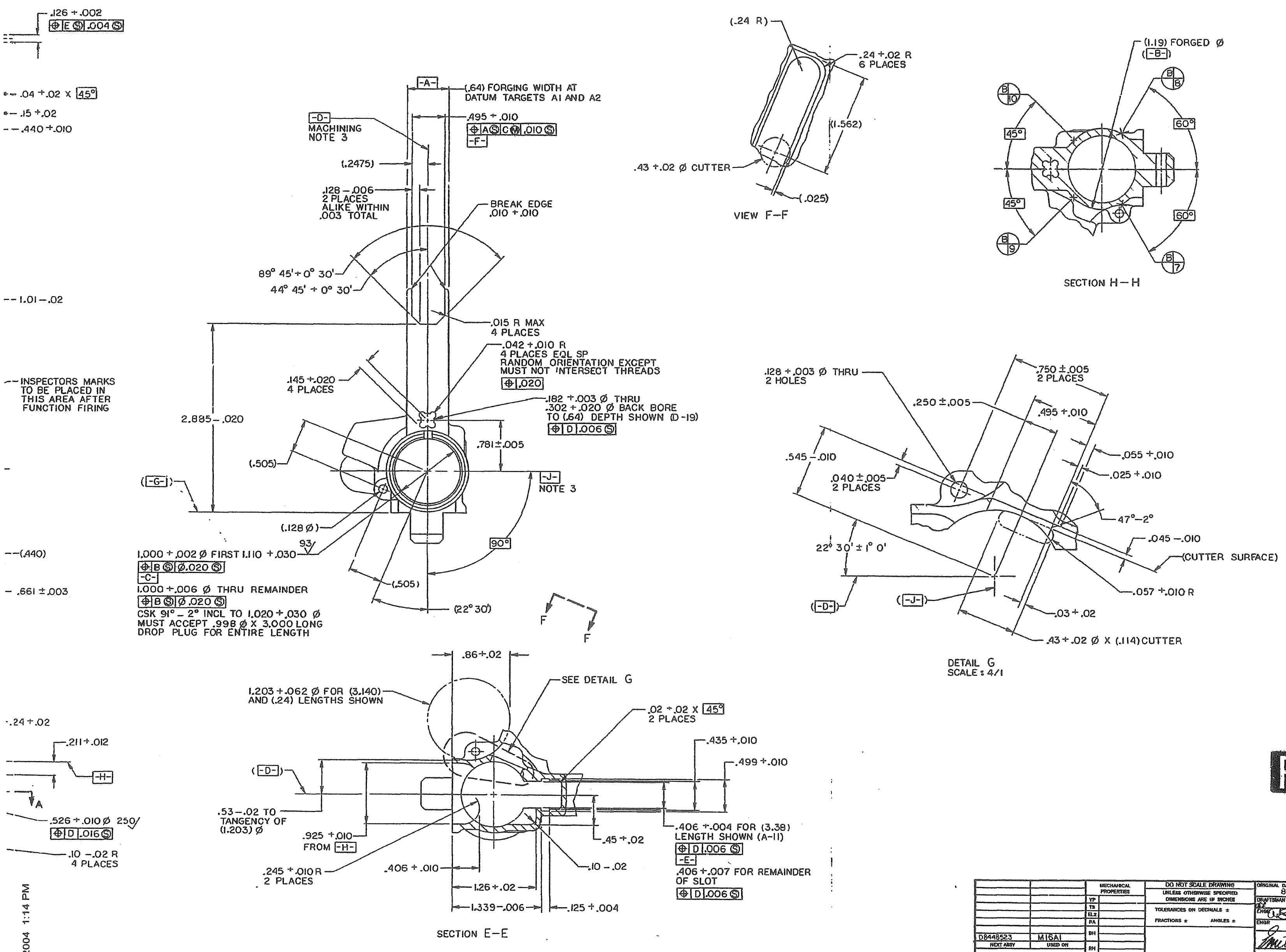
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERR W6S0010	861105	



.126 ± .002
⊕ E Ⓢ .004 Ⓢ
.04 ± .02 X 45°
.15 ± .02
.440 ± .010
1.01 – .02
INSPECTORS MARKS TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
(.440)
.661 ± .003
.24 ± .02
.211 ± .012
-H-
A
.526 ± .010 Ø 250
⊕ D .016 Ⓢ
.10 – .02 R
4 PLACES
-A-
(.64) FORGING WIDTH AT DATUM TARGETS A1 AND A2
-D-
MACHINING NOTE 3
.495 ± .010
⊕ A Ⓢ C Ⓜ .010 Ⓢ
-F-
(.2475)
.128 – .006
2 PLACES
ALIKE WITHIN
.003 TOTAL
BREAK EDGE
.010 ± .010
89° 45' ± 0° 30'
44° 45' ± 0° 30'
.015 R MAX
4 PLACES
.042 ± .010 R
4 PLACES EQL SP
RANDOM ORIENTATION EXCEPT
MUST NOT INTERSECT THREADS
⊕ .020
.145 ± .020
4 PLACES
.182 ± .003 Ø THRU
.302 ± .020 Ø BACK BORE
TO (.64) DEPTH SHOWN (D-19)
⊕ D .006 Ⓢ
2.885 – .020
.781 ± .005
(.505)
-J-
NOTE 3
(-G-)
(.128 Ø)
93
90°
1.000 ± .002 Ø FIRST 1.110 ± .030
⊕ B Ⓢ Ø.020 Ⓢ
-C-
1.000 ± .006 Ø THRU REMAINDER
⊕ B Ⓢ Ø.020 Ⓢ
CSK 91° – 2° INCL TO 1.020 ± .030 Ø
MUST ACCEPT .998 Ø X 3.000 LONG
DROP PLUG FOR ENTIRE LENGTH
(.505)
(22° 30')
F
F
(.24 R)
.24 ± .02 R
6 PLACES
(1.562)
.43 ± .02 Ø CUTTER
(.025)
VIEW F–F
(1.19) FORGED Ø
(-B-)
B 10
B 8
45°
60°
45°
60°
B 9
B 7
SECTION H – H
.128 ± .003 Ø THRU
2 HOLES
.750 ± .005
2 PLACES
.250 ± .005
.495 ± .010
.545 – .010
.055 ± .010
.025 ± .010
.040 ± .005
2 PLACES
47° – 2°
.045 – .010
22° 30' ± 1° 0'
(CUTTER SURFACE)
(-J-)
(-D-)
.057 ± .010 R
.03 ± .02
.43 ± .02 Ø X (.114) CUTTER
DETAIL G
SCALE : 4/1
.86 ± .02
1.203 ± .062 Ø FOR (3.140)
AND (.24) LENGTHS SHOWN
SEE DETAIL G
.02 ± .02 X 45°
2 PLACES
.435 ± .010
.499 ± .010
(-D-)
.53 – .02 TO
TANGENCY OF
(1.203) Ø
.925 ± .010
FROM -H-
.406 ± .004 FOR (3.38)
LENGTH SHOWN (A-11)
⊕ D .006 Ⓢ
-E-
.406 ± .007 FOR REMAINDER
OF SLOT
⊕ D .006 Ⓢ
.45 ± .02
.10 – .02
.245 ± .010 R
2 PLACES
.406 ± .010
1.26 ± .02
1.339 – .006
.125 ± .004
SECTION E–E

F-3 / 3

PART NO. 12576280

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING 86-11-05		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER NEW JERSEY 07801		
		YP		TOLERANCES ON DECIMALS ±	DRAFTSMAN	CHECKER	RECEIVER, UPPER		
		TS		FRACTIONS ± ANGLES ±	ENGR U.S.	ENGR			
		ELz			ENGR	ENGR			
		RA			Emil ...		SIZE J	CODE IDENT NO. 19200	12576280
D8448523	M16A1	BH							
NEXT ASSY	USED ON	RH					SCALE 2/1	UNIT WT	SHEET
APPLICATION									

12576280

October 14, 2004 1:14 PM

5 4 3 2 1

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
~~M~~	-	B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NORW2S0011 / 82-04-13 (ECPW2S0034 / 82-07-15) (ECP W3S3120 / 83-07-07)	83-11-04	R. Goff
		E	NOR GIS2018 / 91-07-08	91-10-11	RR SL

B8448520

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.
3. ROCKWELL HARDNESS SHALL BE 15N 84.5 MIN.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003+.012.

SPRING, HELICAL, COMRESSION

WIRE DIAMETER _______________ .0240 ± .0005
COIL DIAMETER (O.D.) _______________ .175 ± .004
FREE LENGTH AFTER SETTING _______________ 1.250 REF
TOTAL COILS _______________ 21 REF
DIRECTION OF HELIX _______________ OPTIONAL
LOAD AT COMPRESSED LENGTH OF .750 IN. __ 3.50 LB ± .35 LB
SOLID LENGTH _______________ .535 MAX
TYPE OF ENDS _______________ CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

CURRENT
FSCM NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448520

MECHANICAL PROPERTIES				
YS MIN		8448517	M4	
YS MAX		B8448517	M231	
EL 2			M16	
RA		B8448517	M16A1	
BH		NEXT ASSY	USED ON	
RH	SEE NOTE 3	APPLICATION		

~~UNLESS OTHERWISE SPECIFIED~~ DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

~~CONTRACT NO:~~
DATE 27 APR 70

PREP	P. Vernon	L. Gutman
CHK	G. Dreselhaus	D. Krolik
ENGR	R. Elbe	L. Bunton

SUBMITTED A. A. Cole
APPROVED R. S. Henry

DEPT OF THE ~~ARMY~~
U.S. ARMY WEAPONS ~~COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

SPRING, CHARGING HANDLE LATCH

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448520

SCALE — SHEET 1 OF 1

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

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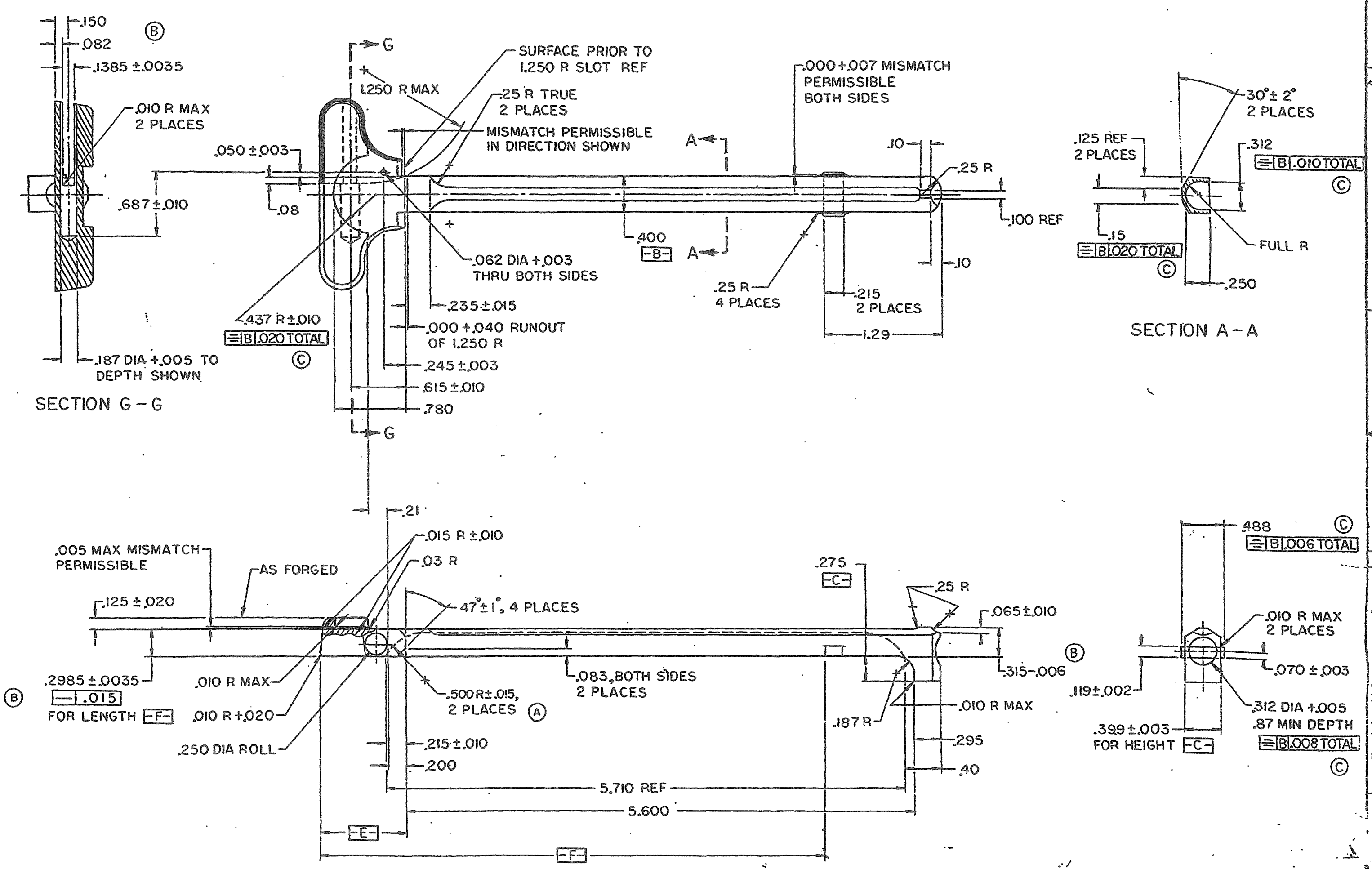
NOTE:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. BEFORE FINISH, GRIT BLAST EXTERIOR OVER LENGTH -E- MIN TO PRODUCE NON-REFLECTIVE MATTE FINISH AFTER FINISH.
4. FINISH MIL-A-8625 TYPE III, CLASS 2, FILM THICKNESS .0010 ±.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL. Ⓒ Ⓐ
5. BREAK SHARP EDGES .005-.010 UNLESS OTHERWISE SPECIFIED.
6. MIL-W-13855 APPLIES. Ⓑ

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J.62288 REV E	27 APR 70	
		A	(2) SEE EO MRD 02197-3	15 JULY 70	
		B	(4) SEE EO HQR 10635	20 FEB 71	
		C	(6) SEE ERR HQR 20778	6 OCT 72	R.E.
		D	NOR W9S2009 80-02-13	80-05-15	
		E	NOR W2S3258/82-12-30	84-0904	
		F	NORW6S3005/85-03-12	87-02-17	
		G	NORGIS2018 91 07 08	91-10-11	



.150
.082
.1385 ±.0035
.010 R MAX 2 PLACES
.687 ±.010
.187 DIA +.005 TO DEPTH SHOWN
Ⓑ
Ⓒ
SECTION G-G
G
1.250 R MAX
.050 ±.003
.08
SURFACE PRIOR TO 1.250 R SLOT REF
.25 R TRUE 2 PLACES
MISMATCH PERMISSIBLE IN DIRECTION SHOWN
.000+.007 MISMATCH PERMISSIBLE BOTH SIDES
A
.10
.25 R
.100 REF
.10
.400
-B-
.062 DIA +.003 THRU BOTH SIDES
.437 R ±.010
B .020 TOTAL
.235 ±.015
.000+.040 RUNOUT OF 1.250 R
.245 ±.003
.615 ±.010
.780
.25 R 4 PLACES
.215 2 PLACES
1.29
.125 REF 2 PLACES
30° ± 2° 2 PLACES
.312
B .010 TOTAL
.15
B .020 TOTAL
FULL R
.250
SECTION A-A
.21
.005 MAX MISMATCH PERMISSIBLE
AS FORGED
.015 R ±.010
.03 R
47° ±1°, 4 PLACES
.125 ±.020
.2985 ±.0035
— .015
FOR LENGTH -F-
.010 R MAX
.010 R +.020
.250 DIA ROLL
.500 R ±.015, 2 PLACES
.215 ±.010
.200
.083, BOTH SIDES 2 PLACES
.275
-C-
.25 R
.065 ±.010
.315-.006
.187 R
.010 R MAX
.295
.40
5.710 REF
5.600
-E-
-F-
.488
B .006 TOTAL
.010 R MAX 2 PLACES
.070 ±.003
.119 ±.002
.312 DIA +.005 .87 MIN DEPTH
B .008 TOTAL
.399 ±.003 FOR HEIGHT -C-

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL 2		8448517	M4
RA		B8448517	M231
BH			M16 M16A1
RH		B8448517	M16A2
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
MAKE FROM CHARGING HANDLE FORGING D 8448647

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO:
DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED F.R. Gilhooly
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HANDLE, CHARGING

SIZE F
CODE IDENT NO. 19204
DRAWING NO. 8448518
SCALE 2/1
SHEET 1 OF 1

CD1

F8448518

October 14, 2004 1:13 PM

02/24/93 ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER COVER SHEET

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO : - - -
LATCH, CHARGING HANDLE REQUEST/PRON ID :GALA73

TDPL COVER SHEET B.F. RELEASED BY: John B Slanin

---

1. MANUFACTURE AND ACCEPTANCE INSPECTION OF THE ABOVE MATERIAL SHALL BE IN ACCORDANCE WITH ALL DRAWINGS, SPECIFICATIONS AND OTHER TECHNICAL DATA LISTED IN THIS TDPL.
2. THIS TDPL IS COMPRISED OF THE FOLLOWING SECTIONS WHICH LIST THE DRAWINGS AND ASSOCIATED DOCUMENTS (WITH THEIR REVISION AND AMENDMENT LEVELS) REQUIRED TO PRODUCE, PACKAGE AND INSPECT THE MATERIAL BEING PRODUCED. (NA INDICATES NOT APPLICABLE)

			FROM	TO
A.	PRODUCT DRAWING AND ASSOCIATED LISTS	SHEET NO(S)	0001	0001
B.	PACKAGING DRAWINGS AND DOCUMENTS	SHEET NO(S)	0002	0002
C.	INSPECTION DRAWINGS AND DOCUMENTS	SHEET NO(S)	0003	0003
D.	SPECIFICATIONS AND STANDARDS	SHEET NO(S)	0004	0004
E.	OUTSTANDING APPROVED ENGINEERING CHANGES	SHEET NO(S)	NA	
F.	TDPL NOTE LEGEND	SHEET NO(S)	0005	

3. DRAWINGS/DOCUMENTS AND ASSOCIATED LISTS LISTED IN THE ABOVE TDPL SECTIONS ARE IDENTIFIED AS TO TYPE BY PREFIX CODES AS FOLLOWS:

PD	PACKAGING DATA SHEET	QS	SUPPLEMENTAL QUALITY ASSURANCE PROVISION

4. THE SPECIFICATIONS AND STANDARDS SECTION OF THE TDPL IS A COMPILATION OF ALL SPECIFICATIONS AND STANDARDS WHICH ARE ESSENTIAL FOR BIDDING AND MANUFACTURING PURPOSES. THE ABSENCE OF ANY SPECIFICATION OR STANDARD FROM THE LISTING WHICH IS OTHERWISE REFERRED TO IN ANY SPECIFICATION OR STANDARD LISTED THEREIN OR IS CALLED OUT ON A PRODUCT, PACKAGING OR INSPECTION DRAWING IS NOT TO BE CONSTRUED AS CONSTITUTING RELIEF FROM REQUIREMENTS OF THE SPECIFICATIONS. THE AMENDMENT OR REVISION LEVEL FOR SUCH UNLISTED SPECIFICATIONS AND STANDARDS SHALL BE AS SPECIFIED IN THE LATEST ISSUE OF DOD INDEX OF SPECIFICATIONS AND STANDARDS IN EFFECT AS OF THE DATE OF THIS TDPL. SUPERSEDED SPECIFICATIONS AND STANDARDS WHICH MAY BE REFERENCED ON DRAWINGS ARE LISTED TOGETHER WITH THE APPROPRIATE SUPERSEDING SPECIFICATION OR STANDARD. WHEN INTERIM CHANGES TO SPECIFICATIONS AND STANDARDS ARE ISSUED (AMENDMENTS, NOTICES OR CHANGE NOTICES), ONLY THE LATEST ISSUE IS LISTED IN THE TDPL. WHERE THESE INTERIM CHANGES ARE NOT CUMULATIVE, ALL PREVIOUS ISSUES ALSO APPLY, UNLESS THE DOCUMENT ITSELF STATES OTHERWISE.
5. ALL REFERENCES ON DRAWINGS/DOCUMENTS AND ASSOCIATED LISTS TO PICATINNY, FRANKFORD OR ROCK ISLAND ARSENALS WILL BE CONSIDERED AS CHANGED TO COMMANDER, ARDEC, ATTN: SMCAR-BAC, PICATINNY ARSENAL, NJ 07806-5000
6. ALL REFERENCES TO PARTS LISTS ON US ARMY TANK AUTOMOTIVE COMMAND (TACOM) DRAWINGS SHALL BE DISREGARDED.

Distribution Statement F.
Further distribution only as directed by ARDEC,
SMCAR-BAC-CW, or higher DoD authority;
12Mar93

```
02/24/93                     ARMAMENT RESEARCH,DEVELOPMENT & ENGINEERING CENTER                   SHEET NO     1 of 5

                                PICATINNY ARSENAL, NEW JERSEY  07806-5000

                                                   CAGE 19200
TECHNICAL DATA PACKAGE LIST :   19204 8448519
DOCUMENT NUMBER             : D 19204 8448519
SPECIFICATION               : MIL-W-63150
NATIONAL STOCK NO           :     -  -   -
LATCH,CHARGING HANDLE                             REQUEST/PRON ID :GALA73

-------------------------------------------------------------------------------------------------------------------------------
PREFIX  DRAWING/DOCUMENT         -SHEET-  REV DOCUMENT SEC          DOCUMENT TITLE                          NOTE       REVIEW
 CODE  SIZE CAGE    NUMBER       NO   OF  SYM  DATE    CL                                                             DATE
-------------------------------------------------------------------------------------------------------------------------------


                                   PRODUCT DRAWINGS AND ASSOCIATED LISTS

        E 19200 12579607          1    1  A  01/08/88       GEOMETRIC SYMBOLS FOR DIMENSIONING AND TOLERANCING
        D 19204 8448519           1    1  H  08/11/92 LIM   LATCH,CHARGING HANDLE
```

02/24/93 ARMAMENT RESEARCH,DEVELOPMENT & ENGINEERING CENTER SHEET NO 2

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO : - - -
LATCH,CHARGING HANDLE REQUEST/PRON ID :GALA73

PREFIX CODE	DRAWING/DOCUMENT SIZE	CAGE	NUMBER	-SHEET- NO	OF	REV SYM	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE	REVIEW DATE
PACKAGING DRAWINGS AND DOCUMENTS											
PD		19204	8448519	1	1	B	06/11/80	LIM	PKG DATA SHT -LATCH,CHARGING HANDLE		

ctober 14, 2004 1:12 PM

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO : - - -
LATCH, CHARGING HANDLE
REQUEST/PRON ID : GALA73

INSPECTION DRAWINGS AND DOCUMENTS

PREFIX CODE	DRAWING/DOCUMENT SIZE	CAGE	NUMBER	-SHEET- NO	OF	REV SYM	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE	REVIEW DATE
	B	19204	8443551	1	1	A	10/24/69		GAGE, FIXTURE, COMPARATOR		
	D	19204	8443842	1	1	B	10/19/73		PLATE, COMPARATOR		
	D	19204	8443905	1	2	A	09/16/70		GAGE, LOCATION		
				2	2	A	09/16/70				
	D	19204	8443948	1	1	A	09/16/70		ADAPTER COMPARATOR FIXTURE		
QS		19204	8448519	1	4	D	09/10/92	LIM	SQAP -LATCH, CHARGING HANDLE		
				2	4	D	09/10/92	LIM			
				3	4	D	09/10/92	LIM			
				4	4	D	09/10/92	LIM			

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO : - - -
LATCH,CHARGING HANDLE REQUEST/PRON ID :GALA73

SPECIFICATIONS AND STANDARDS

QPL/ RECMAT	DOCUMENT NUMBER	REV SYM	AMD NO	INT CHG	SUPPL NO	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
	PPP-B-00636	L				01/01/91		BOXES, SHIPPING, FIBERBOARD	*
	PPP-B-636		(REPLACED BY PPP-B-00636					)	
	PPP-T-76	C				08/02/84		TAPE, PACKAGING, PAPER /FOR CARTON SEALING/	*
	QQ-A-250	F				09/25/78		ALUMINUM AND ALUMINUM ALY, PLATE & SHEET,GENL SPEC FOR	*
	QQ-A-250/12	F		1		11/05/91		ALUMINUM ALY, PLATE AND SHEET, 7075	*
	FED-STD-595	B				12/15/89		COLORS	*
	MIL-A-8625	E	1			11/13/89		ANODIC COATINGS, FOR ALUMINUM AND ALUMINUM ALLOYS	*
	MIL-B-117	F	1			04/23/90		BAG,SLEEVE AND TUBING-INTERIOR PACKAGING	*
	MIL-G-10944	B	3			02/19/82		GAGES, DIMENSIONAL CONTROL	*
	MIL-P-116	J	1	1		10/24/91		PRESERVATION, METHODS OF	*
	MIL-P-14232	E	2	2		02/28/92		PARTS,EQPT AND TOOLS FOR ARMY MATERIEL,PKG OF	*
	MIL-W-13855	D		1		05/28/87		WEAPONS, SMALL ARMS & A/C ARMAMENT SUBSYSTEMS, SPEC	*
	MIL-W-63150		3			09/09/88		WEAPONS AND SPRT MATERIEL, STD QA PROV FOR	*
	MIL-STD-105	E				05/10/89		SMPLG PROCEDURES & TABLES FOR INSPECTION BY ATTRIBUTES	*
	MIL-STD-129	L		1		01/10/92		MARKING FOR SHIPMENT AND STORAGE	*
	MIL-STD-2073-1	B				06/21/91		DOD MATL PROC FOR DEV AND APPL OF PACKAGING REQT	*
	ANSI-B46.1					00/00/85		SURFACE TEXTURE/SURFACE ROUGHNESS,WAVINESS & LAY/	**
	ASA-B46.1		(REPLACED BY ANSI-B46.1					)	
	ANSI-B47.1					00/00/88		GAGE BLANKS	**
	CS8		(REPLACED BY ANSI-B47.1					)	
	ANSI-Y14.5					00/00/73		DIMENSIONING AND TOLERANCING FOR ENGINEERING DRAWINGS	**
	ANSI-Y14.5M					01/01/82		DIMENSIONING AND TOLERANCING FOR ENGINEERING DWGS.	**
	USASI-Y14.5		(REPLACED BY ANSI-Y14.5M					)	

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO : - - -
LATCH,CHARGING HANDLE REQUEST/PRON ID :GALA73

TDPL NOTE LEGEND

DESCRIPTION OF SYMBOLS IN THE NOTE COLUMN

* - Not Furnished - To be obtained from C.O. Naval Publications and Forms Ctr., 5801 Tabor Ave., Phila., Penna., 19120, ATTN. Code 105. If not available, immediately advise the procuring contracting officer.

** - Not Furnished - Commercial Specifications and Standards may be obtained from the publishers. They are not available from government sources.

ober 14, 2004 1:10 PM

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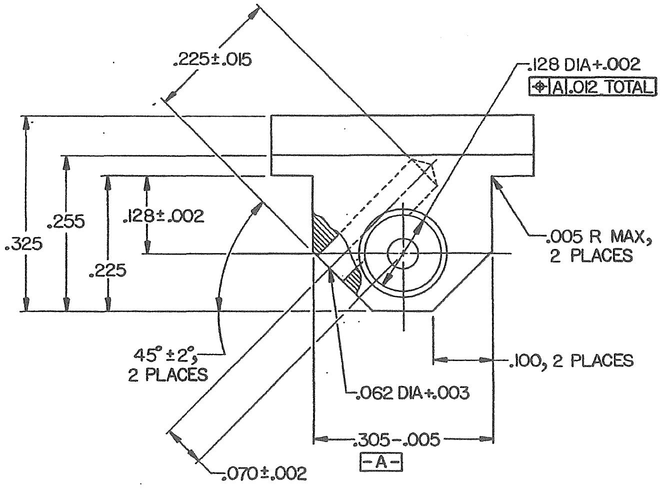
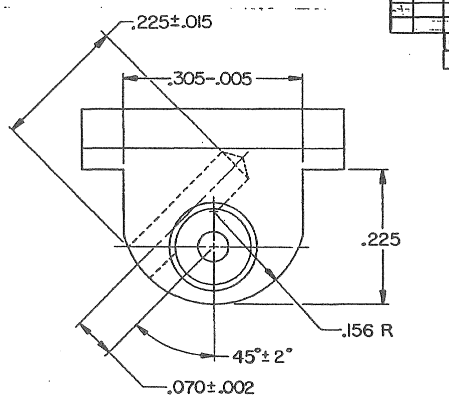
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	~~SEE ERR HQR 50625~~	~~18MAR75~~	~~B~~
		B	NOR W3S3139/83-08-08	84-01-27	ZB
		C	NOR G1S2018 91 07 08	91-10-11	RP
		D	NOR G3S3065 930715	930923	RV

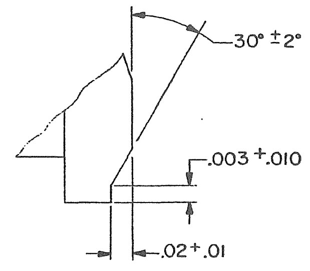
NOTES:

1. STEEL, CMPSN 1018 TO 1022, SPEC ~~ASTM A108~~, OR SINTERED STEEL, GRADE I, CLASS A, DENSITY TYPE II PER ASTM B484-70. SINTERED MAT'L SHALL BE SEALED WITH POLYESTER RESIN. Ⓐ
2. FINISH $\overset{125}{\surd}$.
3. BREAK ALL SHARP EDGES .005+.010 EXCEPT AS NOTED.
4. MIL-W-13855 APPLIES.

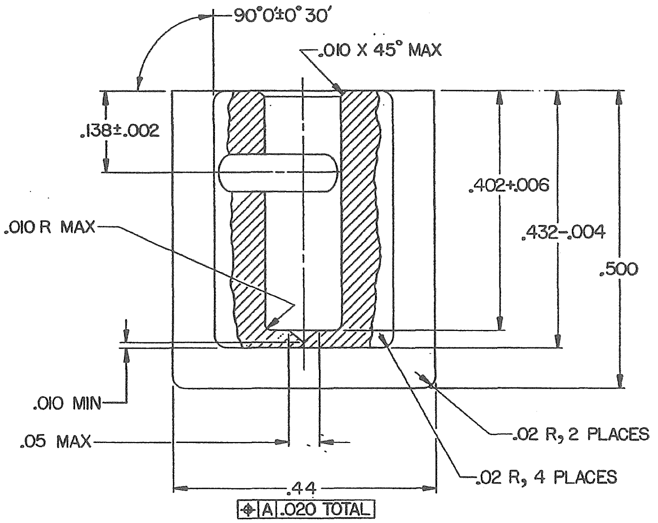

.225±.015
.128 DIA+.002
⌖ A .012 TOTAL
.325
.255
.128±.002
.225
.005 R MAX, 2 PLACES
45°±2°, 2 PLACES
.062 DIA+.003
.100, 2 PLACES
.305-.005
-A-
.070±.002

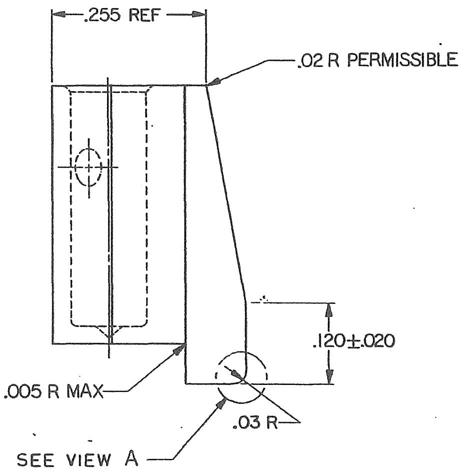

.225±.015
.305-.005
.225
.156 R
45°±2°
.070±.002

ALTERNATIVE DESIGN


30° ±2°
.003 +.010
.02+.01

VIEW A
ALTERNATIVE CONFIGURATION
NOT TO SCALE


90°0'±0°30'
.010 X 45° MAX
.138±.002
.402+.006
.432-.004
.500
.010 R MAX
.010 MIN
.05 MAX
.02 R, 2 PLACES
.02 R, 4 PLACES
.44
⌖ A .020 TOTAL


.255 REF
.02 R PERMISSIBLE
.120±.020
.005 R MAX
.03 R
SEE VIEW A

CURRENT DESIGN ACTIVITY FSCM No. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448784

DISTRIBUTION STATEMENT F
DISTRIBUTION IS AUTHORIZED TO DoD AGENCIES AND DoD QUALIFIED U.S. ORDNANCE CONTRACTORS, FURTHER DISSEMINATION AS DIRECTED BY
, OR HIGHER DoD AUTHORITY.

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA				
BH		8448783	M4	
RH		D8448783	M16/M16A1	
		NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 15 SEPT 72 M-
PREPARED R L Perry / P Vernon
CHECKED / D Krolak
ENGINEER L Burnton / R. Elbe
SUBMITTED Loren Brunton
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HOUSING, COVER LATCH

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448784

SCALE 10/1 SHEET 1 OF 1

D 8448784

AMSWE Form 403D, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED

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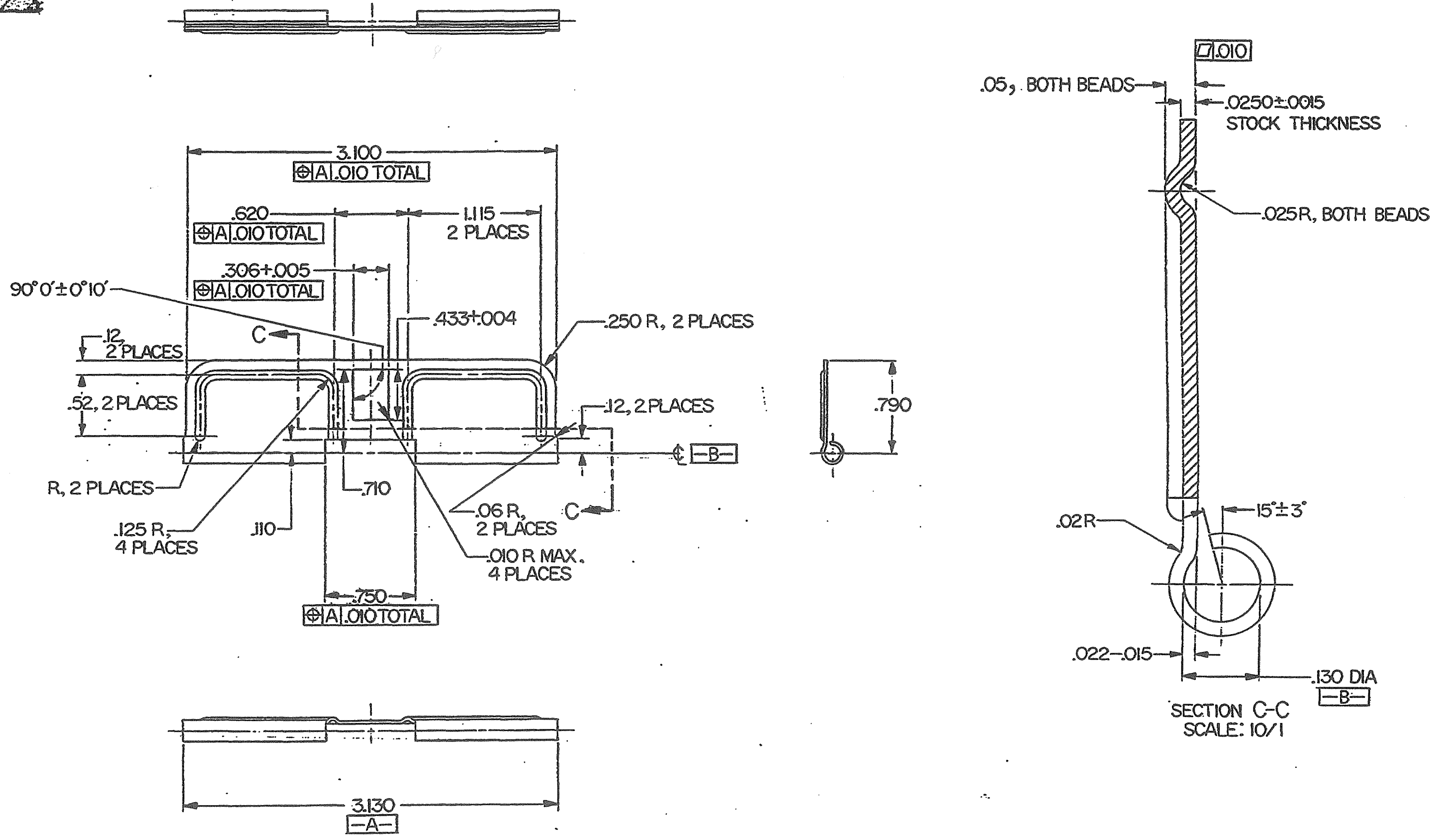
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	NOR W9S2009 80-02-13	80-05-16	
		B	NOR G9S3045 890731	891130	
		C	NOR G1S2018 91 07 03	91-10-11	

NOTES:

1. STEEL, CMPSN 1045 TO 1055, ANNEALED, COLD ROLLED STRIP, NO 2 FINISH, SPEC QQ-S-700.
2. BREAK ALL SHARP EDGES .005R±.005.
3. HEAT TREATMENT: AUSTEMPER TO HARDNESS SPECIFIED.
4. MIL-W-13855 APPLIES.


3.100
⊕ A .010 TOTAL
.620
⊕ A .010 TOTAL
1.115
2 PLACES
.306±.005
⊕ A .010 TOTAL
90°0'±0°10'
.433±.004
.250 R, 2 PLACES
.12
2 PLACES
C
.52, 2 PLACES
.12, 2 PLACES
B
R, 2 PLACES
.710
.06 R,
2 PLACES
C
.125 R,
4 PLACES
.110
.010 R MAX.
4 PLACES
.750
⊕ A .010 TOTAL
3.130
A
.790
▱ .010
.05, BOTH BEADS
.0250±.0015
STOCK THICKNESS
.025R, BOTH BEADS
.02R
15°±3°
.022–.015
.130 DIA
B
SECTION C-C
SCALE: 10/1

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448785

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2"			
RA		8448783	M4
BH		D8448525	XM 231
		D8448783	M16/M16A1
RH	15N 78.5/81.5	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 15 SEPT 72
PREPARED R. Fassig P. Vernon
CHECKED D. Kolek
ENGINEER R. Elbe
SUBMITTED Loren F. Bunton
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

COVER, EJECTION PORT

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448785

SCALE 2/1   SHEET 1 OF 1

EDITION OF 29 JUL 69 MAY BE USED

AMSWE Form 403D, 13 Nov 70

D8448785

October 14, 2004 1:08 PM

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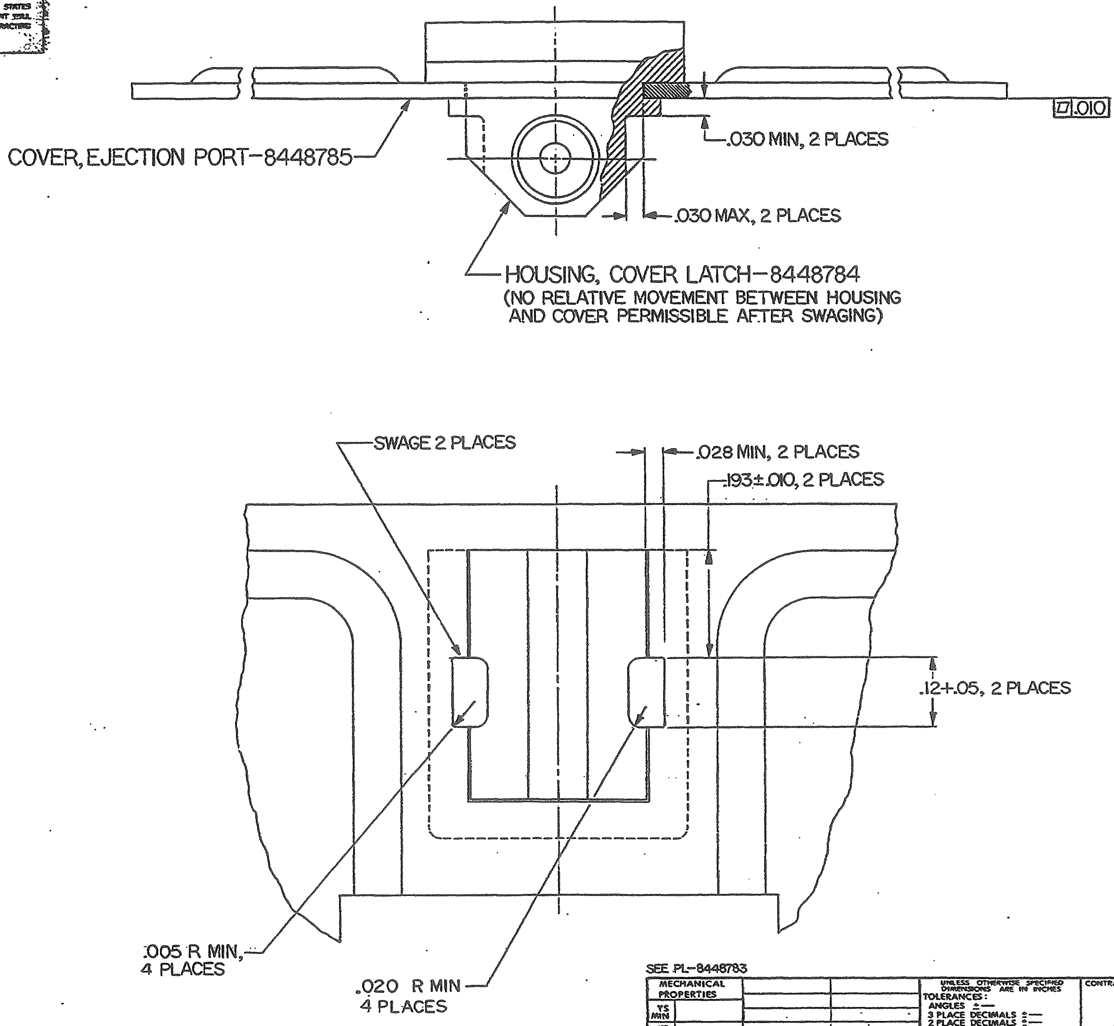
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	NOR W9S2009 80-02-13	80-05-16	
		B	NOR W3S 3123/83-07-07	83-08-16	R
		C	NOR GIS3071/910626	910821	GMS
		D	NOR GIS2018 91 07 08	91-10-11	RR

NOTES:

1. GRIT BLAST AFTER ASSEMBLY AND PRIOR TO FINISH TO PRODUCE NON-REFLECTIVE MATTE FINISH.
2. MIL-W-13855 APPLIES.



.010
.030 MIN, 2 PLACES
COVER, EJECTION PORT–8448785
.030 MAX, 2 PLACES
HOUSING, COVER LATCH–8448784
(NO RELATIVE MOVEMENT BETWEEN HOUSING AND COVER PERMISSIBLE AFTER SWAGING)
SWAGE 2 PLACES
.028 MIN, 2 PLACES
.193±.010, 2 PLACES
.12+.05, 2 PLACES
.005 R MIN, 4 PLACES
.020 R MIN 4 PLACES

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT CODE IDENT NO. 19200

PART NO. 8448783

SEE PL–8448783

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL2		8448525	M4
RA		8448525	M231
		8448525	M16/M16A1
BH		8448525	~~M16A2~~
		8448525	M4 CARBINE
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±—
3 PLACE DECIMALS ±—
2 PLACE DECIMALS ±—

MATERIAL —

FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

CONTRACT NO:

DATE 15 SEPT 72

PREPARED R. Parry | R. Vannoni
CHECKED G. Dausch | D. Kolak
ENGINEER L. Bunton | R. Elbo
SUBMITTED Lorin F. Bunton
APPROVED R. S. Henry

DEPT. OF THE ARMY
~~US ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS 61201~~

EJECTION PORT COVER AND LATCH HOUSING ASSY

SIZE D | CODE IDENT NO. ~~19204~~ | DRAWING NO. 8448783

SCALE 10/1 | SHEET 1 OF 1

D8448783

EDITION OF 29 JUL 69 MAY BE USED

E Form 403D, 13 Nov 70

ctober 14, 2004 1:06 PM

4 3 2 1

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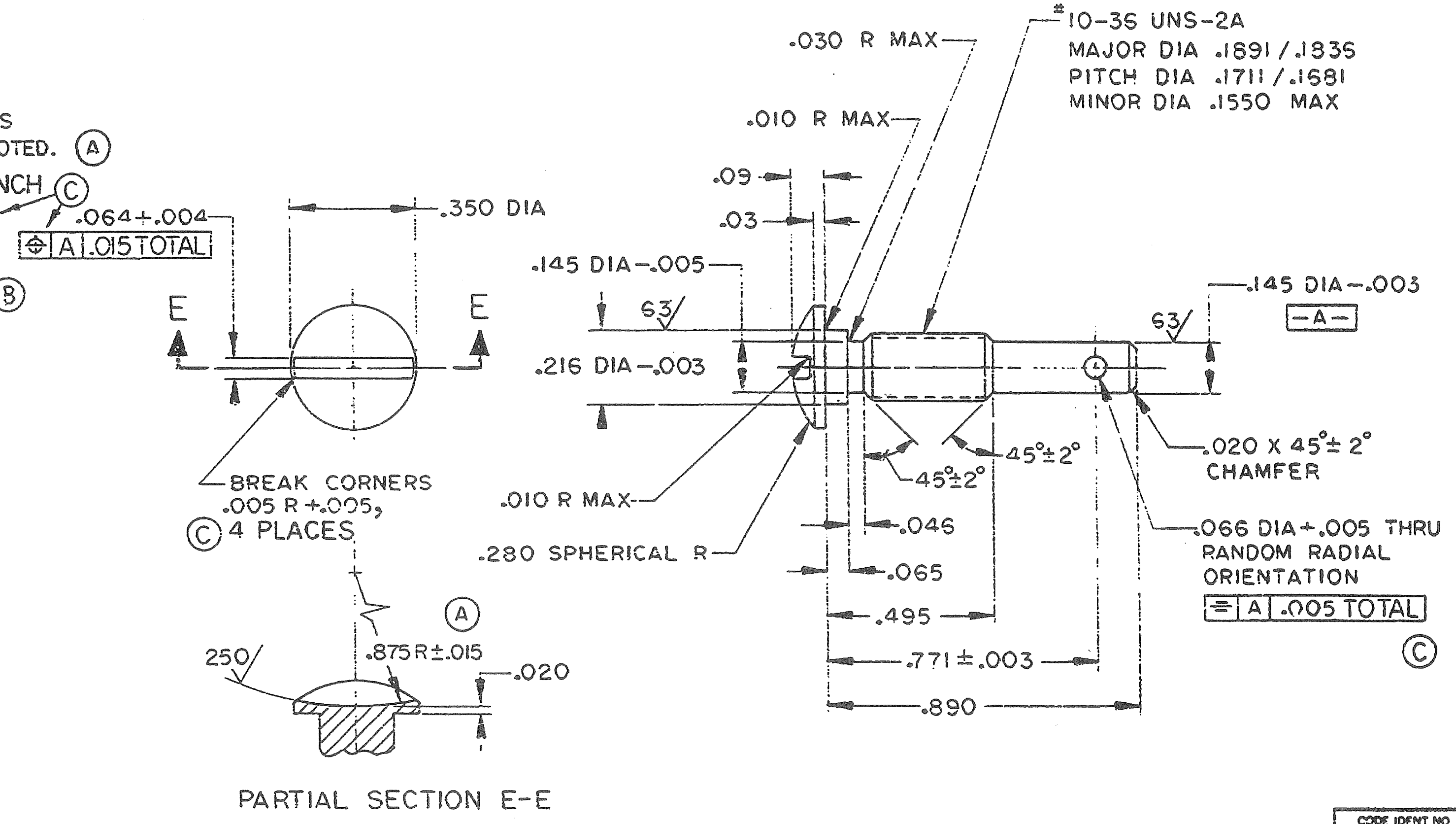
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING CS1702 REVISION A	27 APR 70	
		A	(3) SEE EO HRD C2197-3	15 JUL 70	
		B	(2) SEE HQR 10719	11 MAY 71	
M		C	(5) SEE ERR HQR 20778	6 OCT 72	
		D	NOR W9S2009 90 02-13	90 02-15	

D

NOTE:

1. FINISH 125√ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .010 MAX, EXCEPT AS NOTED. Ⓐ
3. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓒ
4. MIL-W-13855 APPLIES. Ⓑ



.064±.004
⌖ | A | .015 TOTAL
.350 DIA
E
E
BREAK CORNERS .005 R+.005, Ⓒ 4 PLACES
Ⓐ
250√
.875 R±.015
.020
PARTIAL SECTION E-E
.030 R MAX
#10-36 UNS-2A
MAJOR DIA .1891/.1836
PITCH DIA .1711/.1681
MINOR DIA .1550 MAX
.010 R MAX
.09
.03
.145 DIA-.005
63√
.216 DIA-.003
.145 DIA-.003
-A-
63√
45°±2°
45°±2°
.020 X 45°± 2° CHAMFER
.010 R MAX
.046
.280 SPHERICAL R
.065
.066 DIA+.005 THRU RANDOM RADIAL ORIENTATION
≡ | A | .005 TOTAL
Ⓒ
.495
.771±.003
.890

C

B C8448534

CODE IDENT NO
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

Ⓒ Ⓑ Ⓐ

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 72.5-76

Ⓒ

NEXT ASSY	USED ON
D8448602	M16
D8448523	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
STEEL, CMPSN 4130, 4140, 41L30, 41L40, OR 4037, ASTM A322

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO.

DATE 27 APR 1970

PREPARED	RGA	
CHECKED		Needham
ENGINEER		D. Billet

SUBMITTED
F. C. Gilhooly

APPROVED
R. S. Henry

SCREW, REAR SIGHT WINDAGE

SIZE	CODE IDENT NO.	DRAWING NO.
C	~~19204~~	8448534

SCALE 4/1 SHEET 1 OF 1

CDI

AMSWE Form 403C, 29 Jul 69

ctober 14, 2004 1:05 PM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	SEE ERR HQR 20778	6 OCT 72	
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NORW2S2015 82 08 20	83 02 03	
		D	NOR W2S0011 / 82-04-13 (ECP W3S3120 / 83-07-07	83-11-04	
		E	NOR G1S2018 91-07-08	91-10-11	KKSL
		F	NOR G2S3016/920213	920327	GMS SL

B8448787

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0120 ± .0003
COIL DIAMETER (O.D)	.120 ± .002
FREE LENGTH	.413 REF
TOTAL COILS	8 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .201	.80 LB ± .08 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	3.77 LB/IN REF
SOLID LENGTH	.0984 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN; ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH900. HOLD AT 900°F ±10°F FOR ONE HOUR. AIR COOL.
3. FINISH 5.4.1 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 + .012 .

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT PART NO. 8448787

FSCM NO. 19200

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX		8448525	M4
EL 2		D8448525	M231
RA		D8448525	M16/M16A1
BH			
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTE 3

CONTRACT NO:
DATE 15 SEPT 72
PREP R Passy / P. Vernon
CHK J. Dracalline / J. Krolak
ENGR L. Bunton / R. Elbe
SUBMITTED Loren Bunton
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, COVER LATCH

SIZE B | CODE IDENT NO. 19204 | DRAWING NO. 8448787

SCALE — | SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

ctober 14, 2004 1:08 PM

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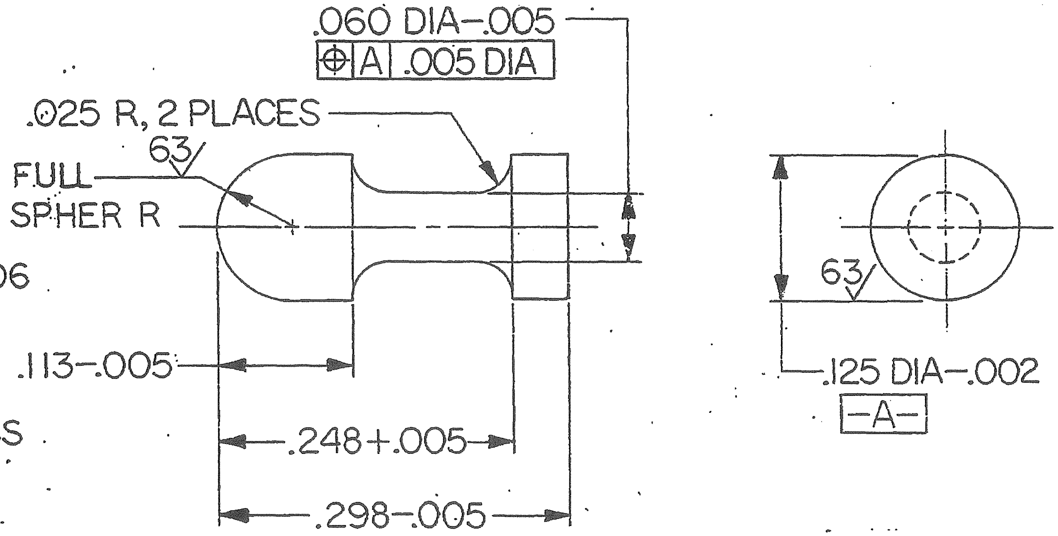
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	NOR W9S2009 80-02-13	80-05-16	
		B	NOR W3S 2023/83-06-06.	83-09-14	
		C	NOR GIS2018 91 07 08	91-10-11	RP

B8448786

NOTES:

1. FINISH $^{125}\surd$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. CARBURIZE .003 TO .006 TOTAL CASE DEPTH.
4. HEAT TREATMENT: QUENCH AND TEMPER TO SURFACE HARDNESS 15 N 90 MIN.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT DESIGN ACTIVITY FSCM NO.19200

PART NO. 8448786

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		8448525	M4
EL 2		D 8448525	M231
RA		D8448525	M16/M16A1
BH		NEXT ASSY	USED ON
RH	SEE NOTE 4	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
STEEL, CMPSN 1117
SPEC ASTM A108.

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO:
DATE 15 SEPT. 72

PREP		P. Vernon
CHK		W. Krolak
ENGR		R. Elbe

SUBMITTED Loren Buntin

APPROVED R. S. Henry

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS 61201~~

LATCH, COVER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448786

SCALE 10/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

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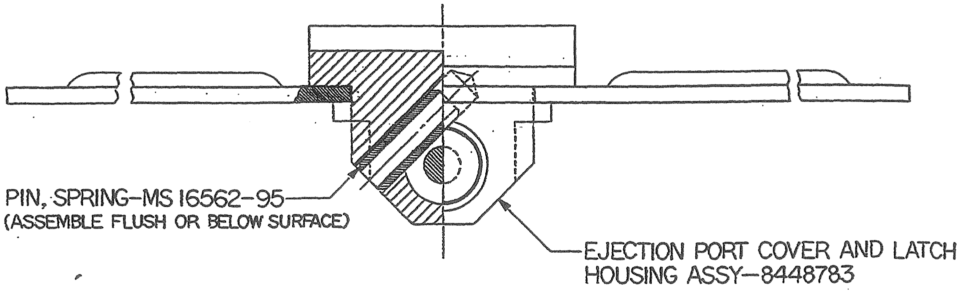
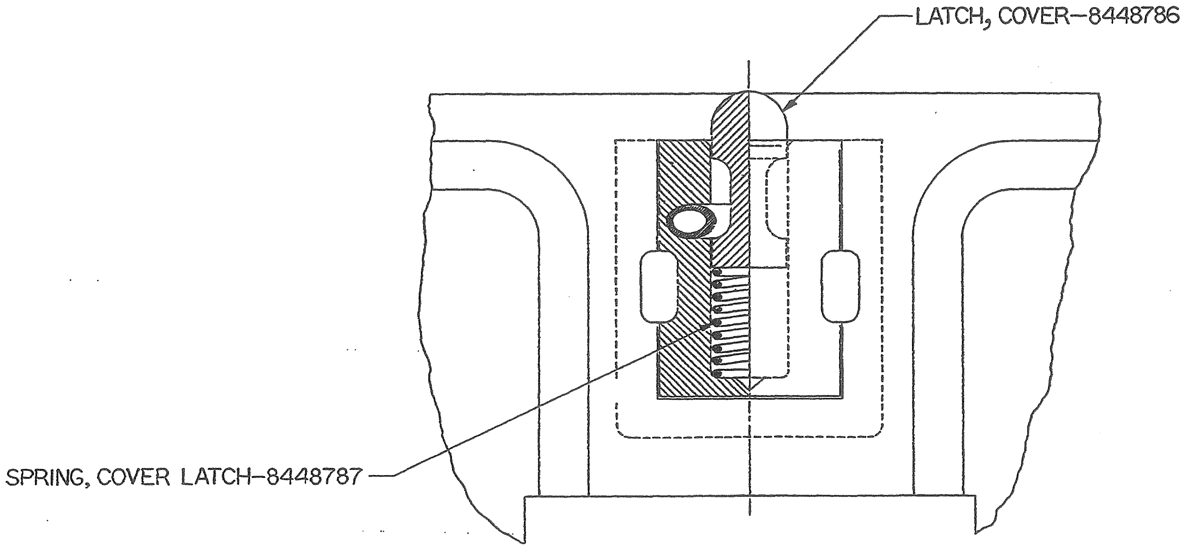
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	REPLACES REV (-) W/CHANGE SEE EPR HQR 20748	21 SEPT 72	
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G1S2018/910708	911011	RR
		D	NOR G2S3059/920716 (ECP G2S3060/920630)	92-08-11	AJL

NOTES:

1. THE LOAD NECESSARY TO DEPRESS THE LATCH, COVER 8448786, .060 INCHES FROM ITS ASSEMBLED POSITION SHALL BE 1.2±.3 LB.
2. MIL-W-13855 APPLIES.


PIN, SPRING-MS 16562-95
(ASSEMBLE FLUSH OR BELOW SURFACE)
EJECTION PORT COVER AND LATCH HOUSING ASSY-8448783



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SEE PL-8448525

PART NO 8448525

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		9390029	M4
RA		D9327228	XM 231
BH		D8448602	M16
		D8448523	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±—
3 PLACE DECIMALS ±—
2 PLACE DECIMALS ±—

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO:

DATE 27 APR 70

PREPARED		
CHECKED		
ENGINEER		R. Elbe

SUBMITTED Loren Brunton

APPROVED R. S. Kenny

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

EJECTION PORT COVER ASSY

SIZE	CODE IDENT NO	DRAWING NO
D	19204	8448525

SCALE 10/1 SHEET 1 OF 1

EDITION OF 29 JUL 69 MAY BE USED

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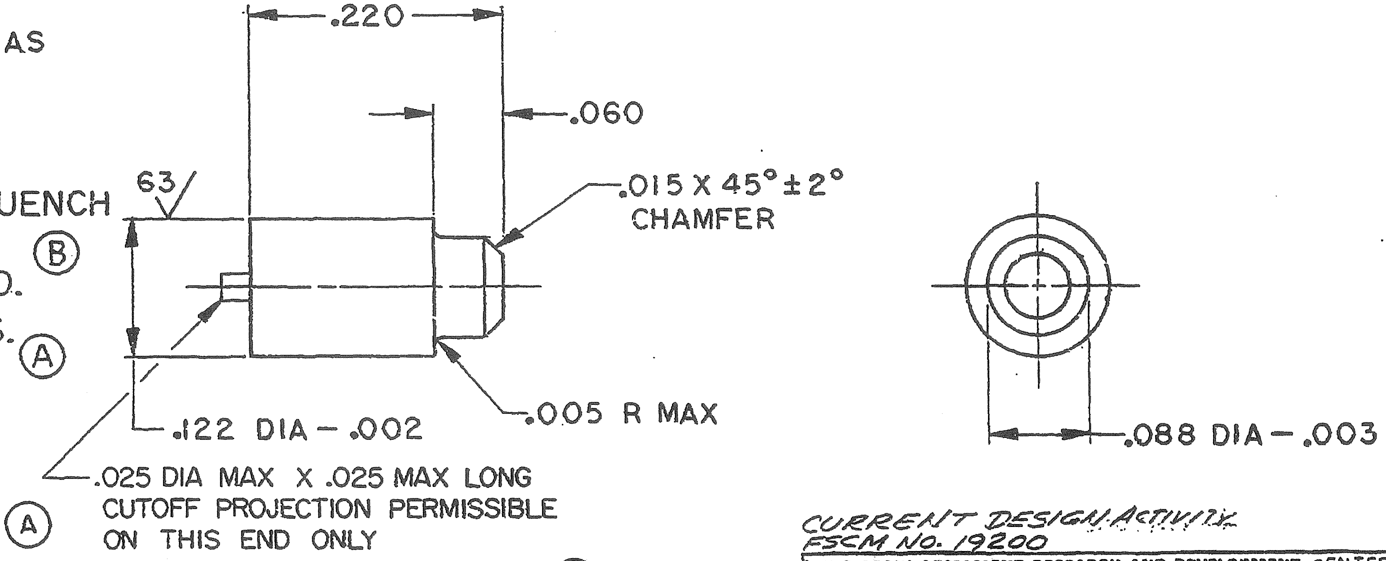
REVISIONS

ME	ZONE	LTR	DESCRIPTION	DATE	APPROVED
LM			REDRAWN FROM COLT'S DRAWING C61755 REVISION A	27 APR 70	
M		A	(2) SEE EO HRD 02253	15 OCT 70	
M.		B	(3) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NORM 353183 83-08-25	83-11-04	

NOTE:

1. TUMBLE TO BREAK SHARP EDGES TO .005R + .005.
2. FINISH 125/√ EXCEPT AS NOTED.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓑ
5. MIL-W-13855 APPLIES. Ⓐ



.025 DIA MAX X .025 MAX LONG CUTOFF PROJECTION PERMISSIBLE ON THIS END ONLY

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

Ⓑ

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 725-76

Ⓑ

NEXT ASSY	USED - ON
D8448602	M16
D8448523	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ±

MATERIAL
STEEL, CARBON, CMPSN 1137, 1137 OR 1141, 1141
SPEC ASTM A108-81

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO:
DATE 27 APR 1970
PREP A.J.H.
CHK
ENGR
SUBMITTED
APPROVED R.S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DETENT, REAR SIGHT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448537

SCALE 10/1
SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

tober 14, 2004 1:01 PM

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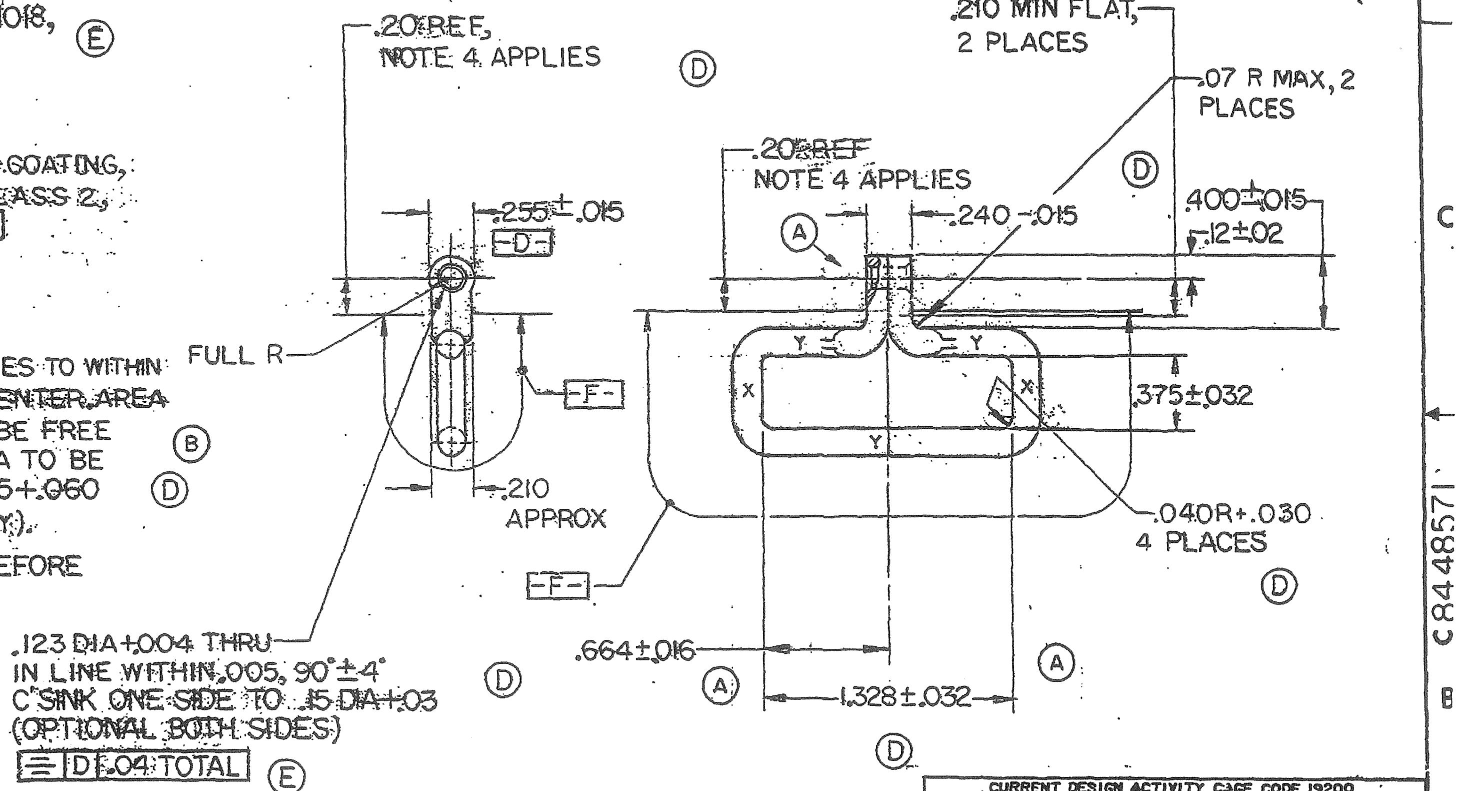
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62280 REV B	27 APR 70	
M		A	(4) SEE EO HRD-02197	15 JULY 70	
M		B	(2) SEE EO HRD 02197-3	1 SEPT 70	
		C	SEE ERR HQR 10822	9 AUG 71	
		D	(6) SEE ERR HQR 20652	9 APR 72	
M		E	(2) SEE ERR HQR 20827	14 DEC 72	RE
		F	NOR W9S2009 80-02-13	80-05-16	
		G	NOR W4S0024/84-10-17	85-01-25	
		H	NOR G9S2046 890828	891205	
		J	NOR G1S3013/910220	910419	GHS
		K	NOR G1S2018 91 07 08	91-10-11	RR
		L	NOR G1S3165 911113	920204	
		M	NOR G2S2013/920330	920428	RR
		N	NOR G2S3054/920626	920717	GHS

1. WIRE, STEEL, CMPSN 1010 OR 1018, .156 DIA, ASTM A510. Ⓔ
2. FINISH 63/
3. APPLY BLACK PLASTIC PLASTISOL COATING, PER MIL-P-20689, TYPE I, CLASS 2, TO AREAS INDICATED BY -F-
4. PLASTISOL COAT ALL SURFACES TO WITHIN .20±.05 OF MOUNTING HOLE CENTER. AREA AROUND MOUNTING HOLE MUST BE FREE OF COATING. PLASTIC COATED DIA TO BE .165+.040 (2) VERT. LEGS (X) .165+.060 ON (3) HORIZONTAL SECTIONS (Y). Ⓑ Ⓓ
5. FINISH 5.3.1.3 OF MIL-STD-171 BEFORE FINISH SPECIFIED IN NOTE 3.
6. TOOL AND FORMING MARKS PERMISSIBLE PRIOR TO PLASTISOL COATING, PROVIDED COATING IS NOT DEGRADED TO THE EXTENT OF SURFACE DISCONTINUITIES.
7. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

C8448571

Ⓑ Ⓐ Ⓒ

DISTRIBUTION STATEMENT F:
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR; 911113.

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL2	
RA	
BH	
RH	

NEXT ASSY	USED ON
9349057	M16A2
9390001	M4
C8448565	M16
C8448565	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTES 3, 4 AND 5

CONTRACT NO:

DATE 27 APR 1970
PREPARED GEW
CHECKED D. Ludlam
ENGINEER D. Billiet
SUBMITTED F. P. Gilhooly
APPROVED K. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SWIVEL, SLING

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448571

SCALE 2/1 SHEET 1 OF 1

AMSWE Form 403C, 29 Jul 69

ctober 14, 2004 12:52 AM

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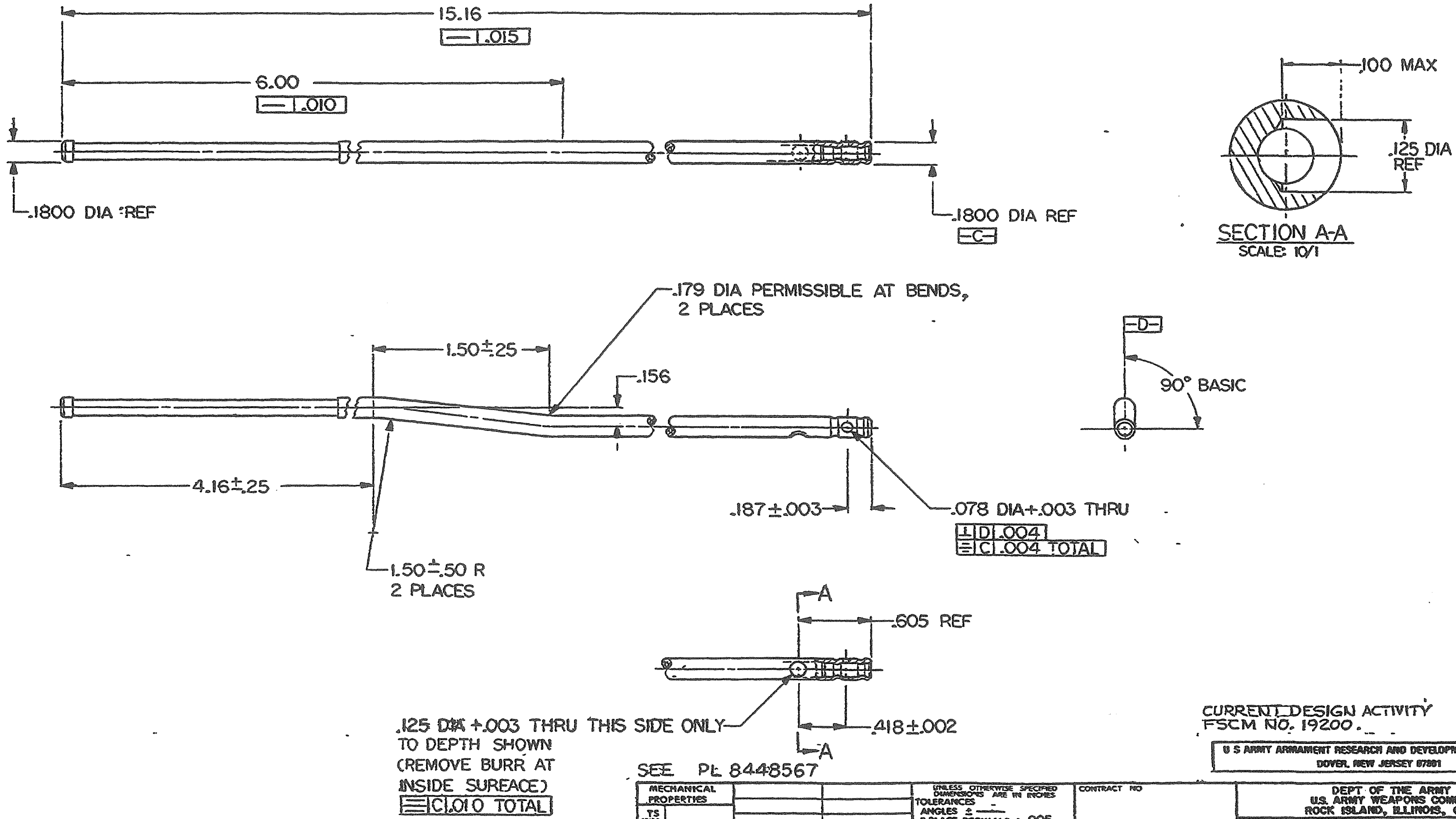
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D61645 REV B	27 APR 70	
		A	(1) SEE EO HRD 02197-3	15 JUL 70	
		B	(3) SEE ERR HQR 20778	6 OCT 72	RC
		C	NOR W182037 82-02-16	83-12-09	
		D	NOR W2S3258 / 82-12-30	84-09-04	RJH
		E	NOR G8S3007/880301	881003	
		F	NOR G2S3059/920716 (ECP G2S3060/920630)	92-08-11	AJL

NOTE
1. MAKE FROM GAS TUBE AND PLUG ASSEMBLY – 8448568
2. FINISH 125$\sqrt{}$.
3. MIL-W-13855 APPLIES.


15.16
$\boxed{—}\boxed{.015}$
6.00
$\boxed{—}\boxed{.010}$
.1800 DIA REF
.1800 DIA REF
-C-
.100 MAX
.125 DIA REF
SECTION A-A
SCALE: 10/1
.179 DIA PERMISSIBLE AT BENDS, 2 PLACES
1.50±.25
.156
-D-
90° BASIC
4.16±.25
.187±.003
.078 DIA+.003 THRU
⊥ D .004
≡ C .004 TOTAL
1.50±.50 R
2 PLACES
A
.605 REF
A
.125 DIA +.003 THRU THIS SIDE ONLY TO DEPTH SHOWN (REMOVE BURR AT INSIDE SURFACE)
≡ C .010 TOTAL
.418±.002

CURRENT DESIGN ACTIVITY
FSCM NO. 19200.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL 8448567

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES ± — 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201
YS MIN				DATE 27 APR 1970	GAS TUBE ASSEMBLY
YS MAX			MATERIAL SEE NOTE 1	PREPARED	
EL2				CHECKED	
RA				ENGINEER	
BH		M16		SUBMITTED	SIZE D · CODE IDENT NO 19204 · DRAWING NO 8448567
RH	C8448565	M16A2	FINAL PROTECTIVE FINISH 5.4.1 OF MIL-STD-171	APPROVED R. S. Henry	SCALE 2/1 · SHEET · OF
	NEXT ASSY	USED ON			
	APPLICATION				

CDI

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY, 92-06-22.

SWE Form 403D, 29 Jul 69

D8448567

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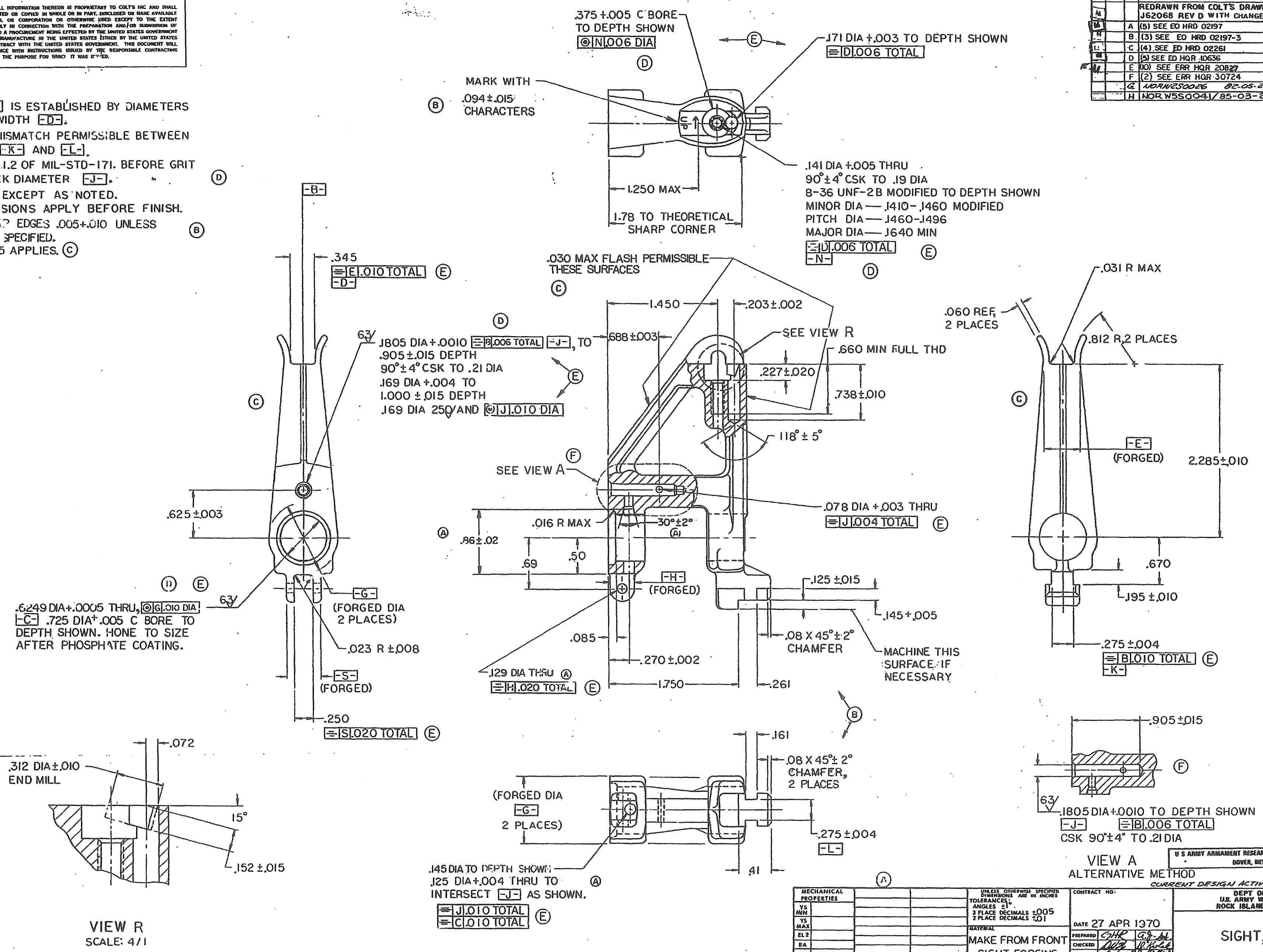
NOTE:
1. PLANE -B- IS ESTABLISHED BY DIAMETERS -C- AND WIDTH -D-.
2. .005 MAX MISMATCH PERMISSIBLE BETWEEN SURFACES -K- AND -L-.
3. FINISH, 5.3.1.2 OF MIL-STD-171. BEFORE GRIT BLAST, MASK DIAMETER -J-. Ⓓ
4. FINISH 125 EXCEPT AS NOTED.
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓑ
7. MIL-W-13855 APPLIES. Ⓒ

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62068 REV D WITH CHANGES	27 AP	
		A	(5) SEE EO HRD 02197	15 JUL 70	
		B	(3) SEE EO HRD 02197-3	1 SEPT 70	
		C	(4) SEE EO HRD 02261	15 OCT 70	
		D	(5) SEE EO HQR 10636	20 FEB 71	
		E	(10) SEE ERR HQR 20827	14 DEC 72	R.E.
		F	(2) SEE ERR HQR 30724	4 SEP 73	R.E.
		G	NORW2S0026 82-05-21	83-02-05	
		H	NOR W5S0041/85-03-25	85-07-12	


.375+.005 C BORE TO DEPTH SHOWN
◎ N .006 DIA
Ⓓ
E
.171 DIA +.003 TO DEPTH SHOWN
≡ D .006 TOTAL
MARK WITH .094±.015 CHARACTERS Ⓑ
1.250 MAX
1.78 TO THEORETICAL SHARP CORNER
.141 DIA +.005 THRU
90°±4° CSK TO .19 DIA
8-36 UNF-2B MODIFIED TO DEPTH SHOWN
MINOR DIA — .1410-.1460 MODIFIED
PITCH DIA — .1460-.1496
MAJOR DIA — .1640 MIN
≡ D .006 TOTAL
-N-
Ⓔ
Ⓓ
-B-
.345
≡ E .010 TOTAL Ⓔ
-D-
.030 MAX FLASH PERMISSIBLE THESE SURFACES Ⓒ
1.450
.203±.002
.688±.003
SEE VIEW R
.660 MIN FULL THD
.227±.020
.738±.010
118°± 5°
63
.1805 DIA+.0010 ≡ B .006 TOTAL -J-, TO .905±.015 DEPTH
90°±4° CSK TO .21 DIA
.169 DIA +.004 TO 1.000 ±.015 DEPTH
.169 DIA 250 AND ◎ J .010 DIA
Ⓔ
Ⓓ
Ⓒ
Ⓕ
SEE VIEW A
.078 DIA +.003 THRU
≡ J .004 TOTAL Ⓔ
.016 R MAX
30°±2° Ⓐ
.625±.003
Ⓐ
.86±.02
.69
.50
-H- (FORGED)
.6249 DIA+.0005 THRU, ◎ G .010 DIA -C- .725 DIA+.005 C BORE TO DEPTH SHOWN. HONE TO SIZE AFTER PHOSPHATE COATING.
Ⓓ Ⓔ
-G- (FORGED DIA 2 PLACES)
.023 R ±.008
-S- (FORGED)
.250
≡ S .020 TOTAL Ⓔ
.085
.270±.002
.129 DIA THRU Ⓐ
≡ H .020 TOTAL Ⓔ
1.750
.261
.125 ±.015
.145+.005
.08 X 45°±2° CHAMFER
MACHINE THIS SURFACE IF NECESSARY
.031 R MAX
.060 REF, 2 PLACES
.812 R, 2 PLACES
-E- (FORGED)
2.285±.010
.670
.195 ±.010
.275±.004
≡ B .010 TOTAL Ⓔ
-K-
Ⓑ
.161
.08 X 45°± 2° CHAMFER, 2 PLACES
(FORGED DIA -G- 2 PLACES)
.275 ±.004
-L-
.41
.145 DIA TO DEPTH SHOWN
.125 DIA+.004 THRU TO INTERSECT -J- AS SHOWN.
≡ J .010 TOTAL
≡ C .010 TOTAL Ⓔ
Ⓐ
.072
.312 DIA±.010 END MILL
15°
.152 ±.015
VIEW R
SCALE: 4/1
.905±.015
Ⓕ
63
.1805 DIA+.0010 TO DEPTH SHOWN
-J-
≡ B .006 TOTAL
CSK 90°±4° TO .21 DIA
VIEW A
ALTERNATIVE METHOD

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT DESIGN ACTIVITY FSCM No. 19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			M16
RH		C8448565	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL: MAKE FROM FRONT SIGHT FORGING F8448643

FINAL PROTECTIVE FINISH: SEE NOTE 3

CONTRACT NO:
DATE 27 APR 1970
PREPARED GHR
CHECKED
ENGINEER
SUBMITTED
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SIGHT, FRONT

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448566

SCALE 2/1 SHEET 1 OF 1

CDI

F8448566

SWE Form 403F, 29 Jul 69

October 14, 2004 12:49 AM

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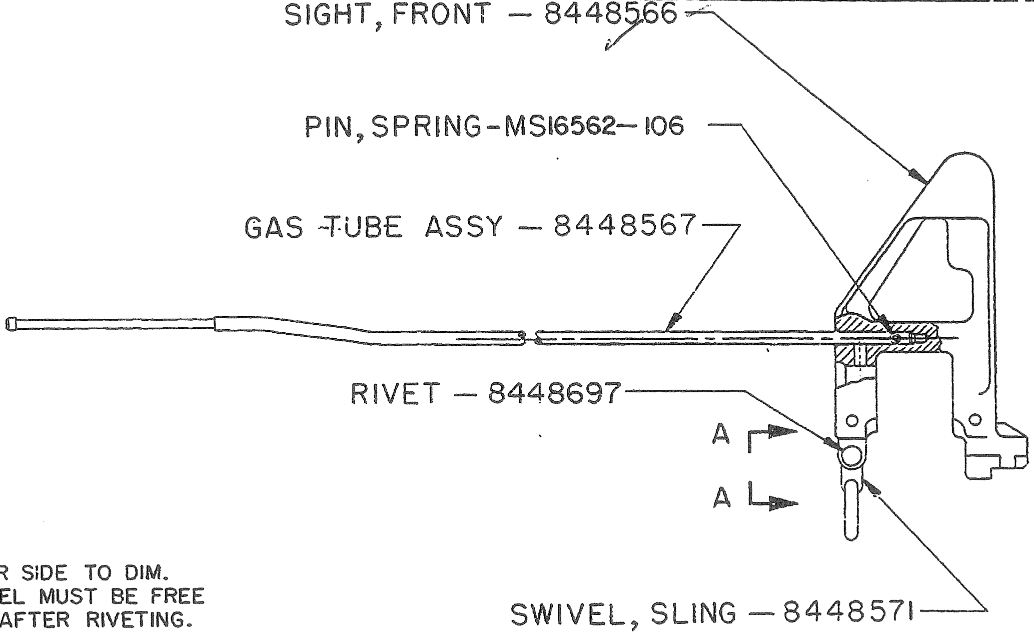
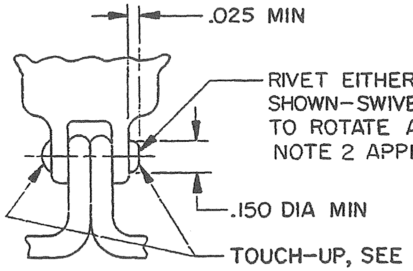
NOTES:

1. AFTER SPREADING, THE RIVET SHALL BE REFINISHED (TOUCHED-UP) IN ACCORDANCE WITH PARA 3.5.5.3 OF MIL-W-13855, OR LACQUER, MIL-L-19538, CLASS I, COLOR BLACK 37038.
2. CRACKS PERMISSIBLE, PROVIDED THAT:
   A. NO MORE THAN TWO CRACKS PER QUADRANT AND THREE PER RIVET APPEAR.
   B. NO CRACK EXTENDS INTO THE TUBULAR PORTION OF THE RIVET.
   C. NO BROKEN SECTIONS RESULT FROM ADJACENT CRACKS.
3. MIL-W-13855 APPLIES.

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REPLACES B8448565 REV(0) W/CHANGES		
		A	(4) SEE EO HRD 02197-1	15 JULY 70	
		B	(2) SEE ERR HQR 10730	26 MAY 71	ЖB
		C	SEE ERR HQR 10842	14 SEP 71	ЖB
		D	SEE ERR HQR 10862	8 OCT 71	RE
		E	(2) SEE ERR HQR 20665	11 APR 72	ЖB
		F	(2) SEE ERR HQR 20679	21 JUL 72	R.E.
		G	SEE ERR HQR 20778	6 OCT 72	RE
		H	NORW2S0020 82-06-09	83-02-03	LAH
		J	NORW2S 0026 82-05-21	83-09-22	




.025 MIN
RIVET EITHER SIDE TO DIM. SHOWN-SWIVEL MUST BE FREE TO ROTATE AFTER RIVETING. NOTE 2 APPLIES
.150 DIA MIN
TOUCH-UP, SEE NOTE 1

VIEW A-A

SCALE 2/1

SEE PL-8448565

C 8448565

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± — 3 PLACE DECIMALS ± — 2 PLACE DECIMALS ± —	CONTRACT NO:
YS MIN			MATERIAL	DATE 27 APR 70
YS MAX				PREPARED G. Duyselhaus T.A. Wilson
EL 2				CHECKED R.L. Tassig R.E. Picard
RA				ENGINEER D. Billet D. Krolek
BH	F 8448601	M16		SUBMITTED
	F 8448522	M16A1		
RH	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED R. S. Henry
	APPLICATION			

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SIGHT AND GAS TUBE ASSY

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448565

SCALE 1/1 SHEET 1 OF 1

October 14, 2004 12:48 AM

5 4 3 2 1

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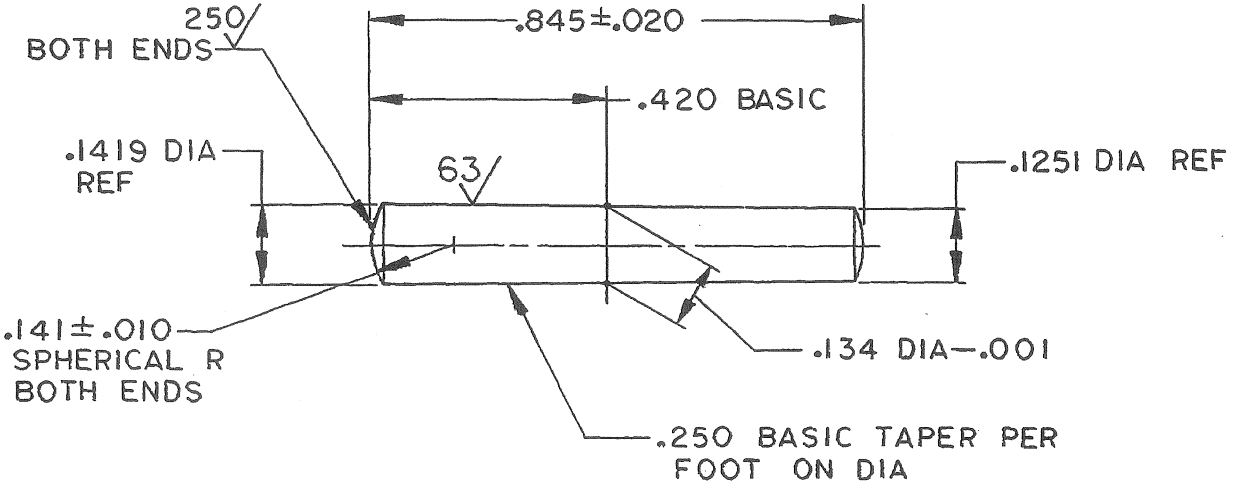
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		H	NOR G5S3009 / 950330	950726	DR

B8448575

NOTE:

1. SUGGESTED HEAT TREAT: LIQUID CARBURIZE AT 1550°F TO OBTAIN A TOTAL CASE DEPTH OF .010/.015.
2. BREAK SHARP EDGES .005+.010.
3. STEEL, CMPSN 4027, 4028, AND 4037, SPEC ASTM A 304 OR STEEL, CMPSN 1030, 1033, 1035, 1037, AND 1038, SPEC ASTM A108.
4. MIL-W-13855 APPLIES.



CURRENT

CODE IDENT NO.
19200

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390001	M4
EL 2		F8448601	M16
RA		F8448522	M16A1
BH		NEXT ASSY	USED ON
RH	15N 89-91	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± ——
MATERIAL
FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970
PREP RGA R. J. A
CHK DAK W. Leedham
ENGR D. Smart D. Billet
SUBMITTED F. P. Yellsoly
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

PIN, TAPER, FRONT SIGHT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448575
SCALE 5/1		SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CDI

ctober 14, 2004 12:48 AM

DRAWING SIZE C
(ARRADCOMR 70-12)

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW4S0030/84-11-15	85-04-02	HW EP
B	NOR G1S2018 91 07 08	91-10-11	RR SL
C	NOR G2S3057/920716	921030	RR
D	NOR G3S3132/940104	940426	DP EC
E	NOR G5S3014 950417	960521	RLV
F	NOR L7S3030 970530	970703	HJS

NOTES:-

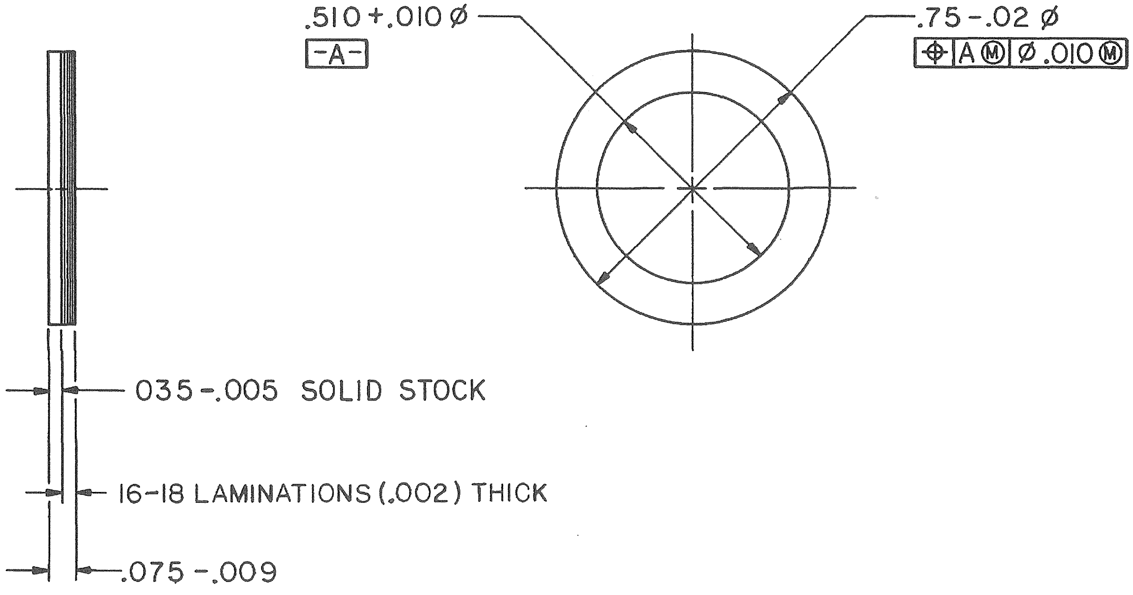
1-SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2-MATERIAL :-LAMINATED SHIM STOCK PER MIL-S-22499, COMPOSITION 3, TYPE TO BE AS SHOWN, CLASS 1.

3-BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE SPECIFIED.

4-FINISH $\sqrt{}^{125}$ ALL SURFACES.

5-



PART NO. 9349052

8448522	M16A1	MECHANICAL PROPERTIES	
8448601	M16	YP	
9327227	M231 FPW	TS	
9390001	M4	EL2	
9349050	M16A2E3 M16A2	RA	
NEXT ASSY	USED ON	BH	
APPLICATION		RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN EJZ
CHECKER DEW
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SPACER, COMPENSATOR

SIZE C
FSCM NO. 19200
9349052
SCALE 4/1
UNIT WT. —
SHEET 1 OF 1

ober 14, 2004 12:47 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
VI-		B	REPLACES REV A W/CHANGE SEE ERR HQR 20827	14 DEC 72	LB
		C	NORW2S0011 / 82-04-13 (ECP W2S0034 / 82-07-15) (ECP W3S3120 / 83-07-07)	83-11-04	
		D	NOR G1S2018 91 07 08	91-10-11	RR

B8448574

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0180 ±.0005
COIL DIAMETER (O.D)	.115 ±.003
FREE LENGTH	.75 REF
TOTAL COILS	20 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .557 AFTER SET	1.78 LB ± .18 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	
SOLID LENGTH	.390 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631 (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012 .

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448574

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390001	M4
EL 2		F8448601	M16
RA		F8448522	M16 A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO:		
DATE	27 APR 70	
PREP	P. Vernon	L. Gutman
CHK	J. Dreyelhaus	W Krolak
ENGR	R. Elbe	L. Brunton
SUBMITTED	A. A. Cole	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, FRONT SIGHT DETENT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448574

SCALE — SHEET 1 OF 1

AMSWE Form 403B 29 Jul 69

ober 14, 2004 12:46 AM

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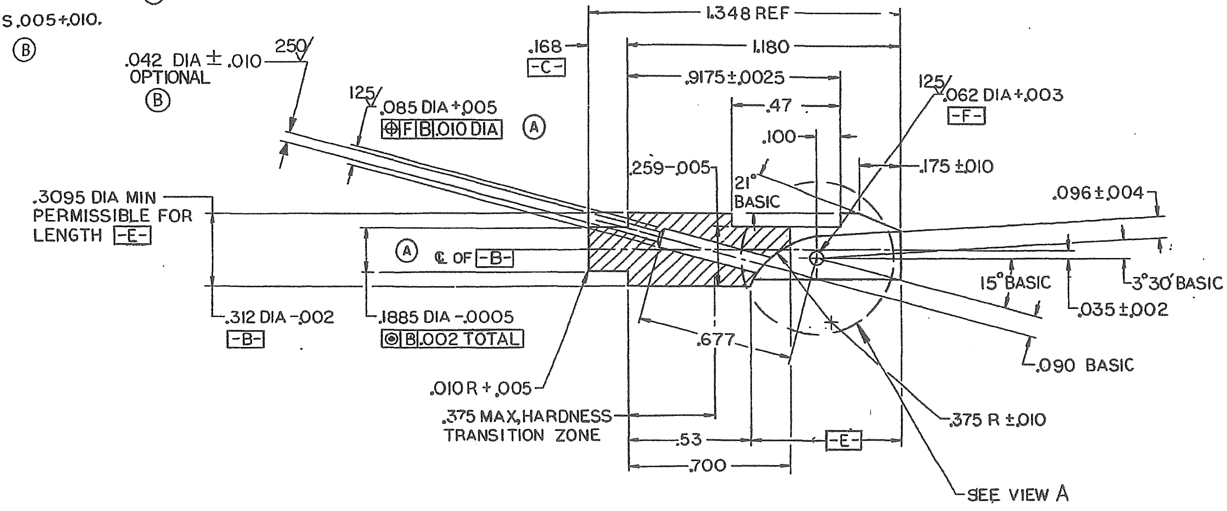
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62268 REV B	27APR70	
		A	(3) SEE EO HRD 02197-3	15 JULY 70	
		B	(3) SEE EO HQR 10625	20FEB71	
		C	SEE ERR HQR 10865	13OCT 71	
		D	NORW2S2013	820614	
		E	NORW3S0011 / 83-03-09	83-11-08	
		F	NORGIS2018 91 07 08	91-10-11	RR

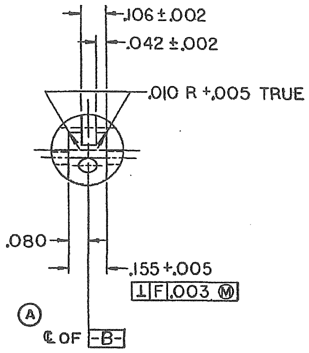
NOTE:

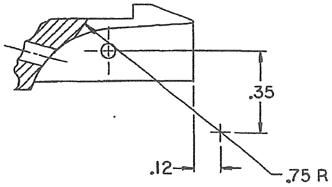
1. FINISH 63∀ EXCEPT AS NOTED.
2. ANNEAL FOR LENGTH -C-.

Ⓑ

3. BREAK SHARP EDGES .005+.010.
4. MIL-W-13855 APPLIES. Ⓑ


.042 DIA ± .010
OPTIONAL
Ⓑ
250∕
.168
-C-
1.348 REF
1.180
.9175±.0025
.47
.100
125∕
.062 DIA +.003
-F-
125∕
.085 DIA +.005
⊕ F B .010 DIA
Ⓐ
.259-.005
21°
BASIC
.175 ±.010
.096±.004
.3095 DIA MIN
PERMISSIBLE FOR
LENGTH -E-
Ⓐ ℄ OF -B-
15° BASIC
3°30' BASIC
.035±.002
.312 DIA -.002
-B-
.1885 DIA -.0005
◎ B .002 TOTAL
.677
.090 BASIC
.010 R +.005
.375 MAX, HARDNESS
TRANSITION ZONE
.375 R ±.010
.53
-E-
.700
SEE VIEW A


.106±.002
.042±.002
.010 R +.005 TRUE
.080
.155+.005
⊥ F .003 Ⓜ
Ⓐ
℄ OF -B-



VIEW A

ALTERNATIVE DESIGN

Ⓒ

CURRENT

FSCM NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA		9349085	M4	
BH			MI6AIEI ~~XM177E2~~	
RH	C47 - 51	9349085	MI6AI	
		NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
STEEL, AISI C1141

FINAL PROTECTIVE FINISH
—

CONTRACT NO:

DATE 27 APR 1970

PREPARED TTC a.J.A.
CHECKED
ENGINEER D. Billiot
SUBMITTED F. P. Killoug
APPROVED R. S. Kenney

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PLUNGER

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448546

SCALE 4/1 SHEET 1 OF 1

~~BACKFILE~~ CDI

SWE Form 403D, 29 Jul 69

D8448546

ctober 14, 2004 12:17 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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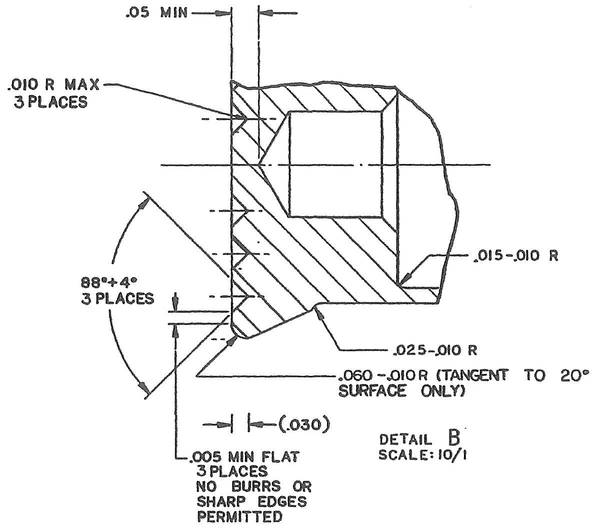
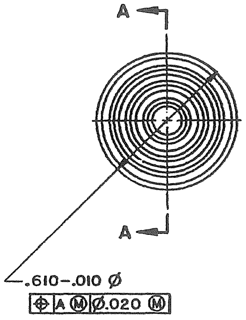
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
G	NOR G4S2136 941215	950428	HJS
H	NOR L7S3041 970725	970819	JB

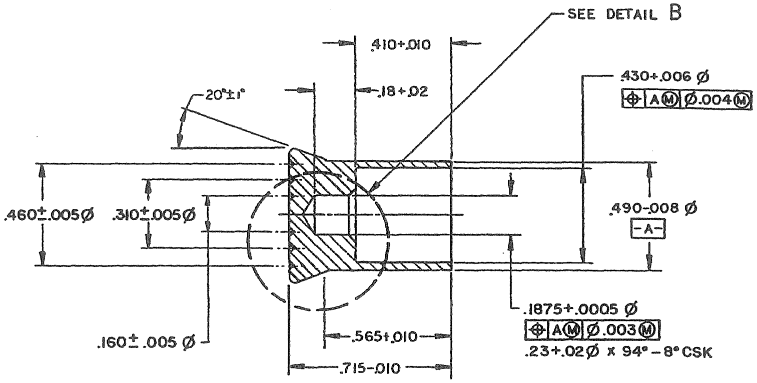
NOTES:—

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 — MATERIAL:- STEEL BAR, ASTM 108, CMPSN 1137, OR 1141. ANNEALED AND COLD DRAWN BRINELL HARDNESS 286 MAX.
3 — BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE NOTED.
4 — ALL DIAMETERS ⌖ | A Ⓜ | Ø .010 Ⓜ UNLESS OTHERWISE NOTED.
5 — FINISH 125√ ALL SURFACES UNLESS OTHERWISE NOTED.


.05 MIN
.010 R MAX
3 PLACES
.015-.010 R
88°+4°
3 PLACES
.025-.010 R
.060 -.010 R (TANGENT TO 20° SURFACE ONLY)
(.030)
.005 MIN FLAT
3 PLACES
NO BURRS OR
SHARP EDGES
PERMITTED

DETAIL B
SCALE: 10/1


A
A
.610-.010 Ø
⌖ | A Ⓜ | Ø.020 Ⓜ


SEE DETAIL B
.410+.010
20°±1°
.18+.02
.430+.006 Ø
⌖ | A Ⓜ | Ø.004 Ⓜ
.460±.005Ø
.310±.005Ø
.490-.008 Ø
-A-
.1875+.0005 Ø
⌖ | A Ⓜ | Ø.003 Ⓜ
.23+.02Ø x 94°-8° CSK
.160± .005 Ø
.565+.010
.715-.010

SECTION A-A

DISTRIBUTION STATEMENT F.
FURTHER DISSEMINATION ONLY AS DIRECTED
BY ARDEC, AMSTA-ARA-ESW, ROCK ISLAND, IL
ASQNC-ARI-CT 911025 OR HIGHER DoD
AUTHORITY.

PART NO. 9349084

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
9349085	M4	RA	
	M16A1		
9349085	M16A1E1	BH	
NEXT ASSY	USED ON		
APPLICATION		RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN MM
CHECKER DEW
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CAP, PLUNGER

SIZE D
FSCM NO. 19200
9349084
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

tober 14, 2004 12:16 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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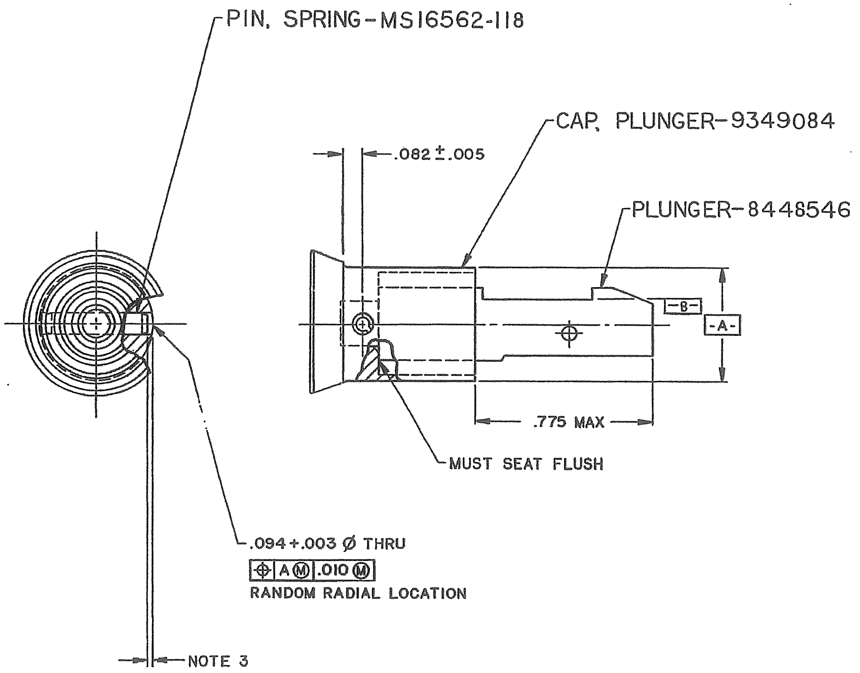
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S0011/83-03-09	83-11-08	
B	NORW3S3142/83-09-29	840612	
C	NORW4S 0030/84-11-15	850402	
D	NORW5S8002/850806	860626	
E	NOR GIS2018 91 07 08	91-10-11	RR

NOTES:—

1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2—BREAK SHARP EDGES .005+.010 EXCEPT AS NOTED.
3—INSERT SPRING PIN SO THAT ENDS ARE BELOW SURFACE ON EITHER SIDE AS SHOWN.
4—DIMENSIONS APPLY BEFORE PROTECTIVE FINISH.
5—FINISH 125√ ALL SURFACES.
6—PROTECTIVE FINISH:— 5.3.1.2 OF MIL-STD-171.



FOR ENGINEERING PARTS LIST SEE PL9349085

PART NO. 9349085

9349086	M4
	M16A1
9349086	M16A1E1
NEXT ASSY	USED ON
APPLICATION	

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN M M
CHECKER DEW
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PLUNGER ASSEMBLY

SIZE D
FSCM NO. 19200
9349085
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

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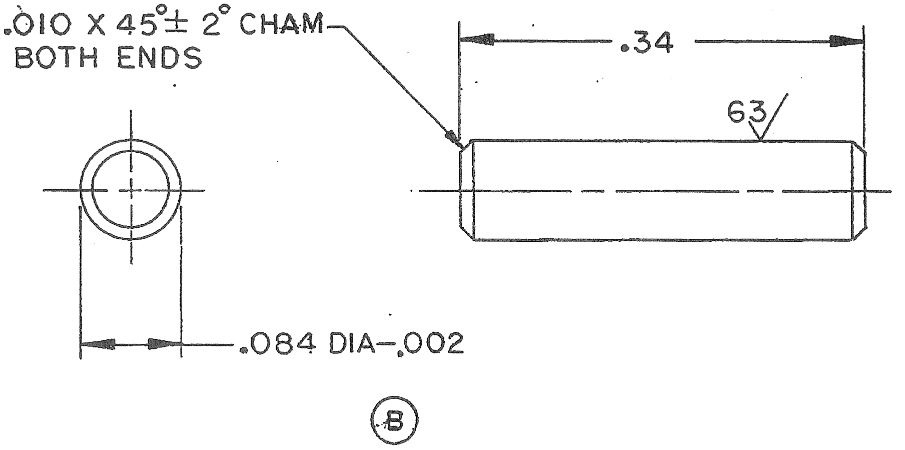
H	NOR G2S3059/920716 (ECP G2S3060/920630)	920811	AJL
J	NOR G2S3122/930108	930310	GHS

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING B62270 REVISION A	27 APR 70	
		A	(2) SEE EO HRD 02197-3	15 JULY 70	
		B	(2) SEE HQR 10689	26 APR 71	
	-	C	(2) SEE ERR HQR 20778	6 OCT 72	R.E.
		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W5S3037/850917	861211	MR
		F	NOR G1S3096 910814	910916	
		G	NOR G1S2018/910708	911011	RR

B8448544

NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT: LIQUID CARBURIZE AT 1550°F TO OBTAIN A TOTAL CASE DEPTH OF .010 TO .015. HARDEN AND TEMPER AT MIN OF 400°F. Ⓐ
3. BREAK SHARP EDGES .005+.010.
4. MIL-W-13855 APPLIES. Ⓑ
5. MATERIAL:
   WIRE, STEEL, CMPSN 1018 OR 1020 OR 1022, ASTM A108.
   ALTERNATE MATERIAL: BAR, STEEL, CMPSN 1117, ASTM A108.



DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

Ⓐ Ⓒ Ⓒ

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 89 MIN

NEXT ASSY	USED ON
9349086	M4
C8448541	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 5

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970
PREP RGA
CHK
ENGR
SUBMITTED
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DETENT, PAWL

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448544

SCALE 10/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

W5S3037 1B

CDI

tober 14, 2004 12:02 AM

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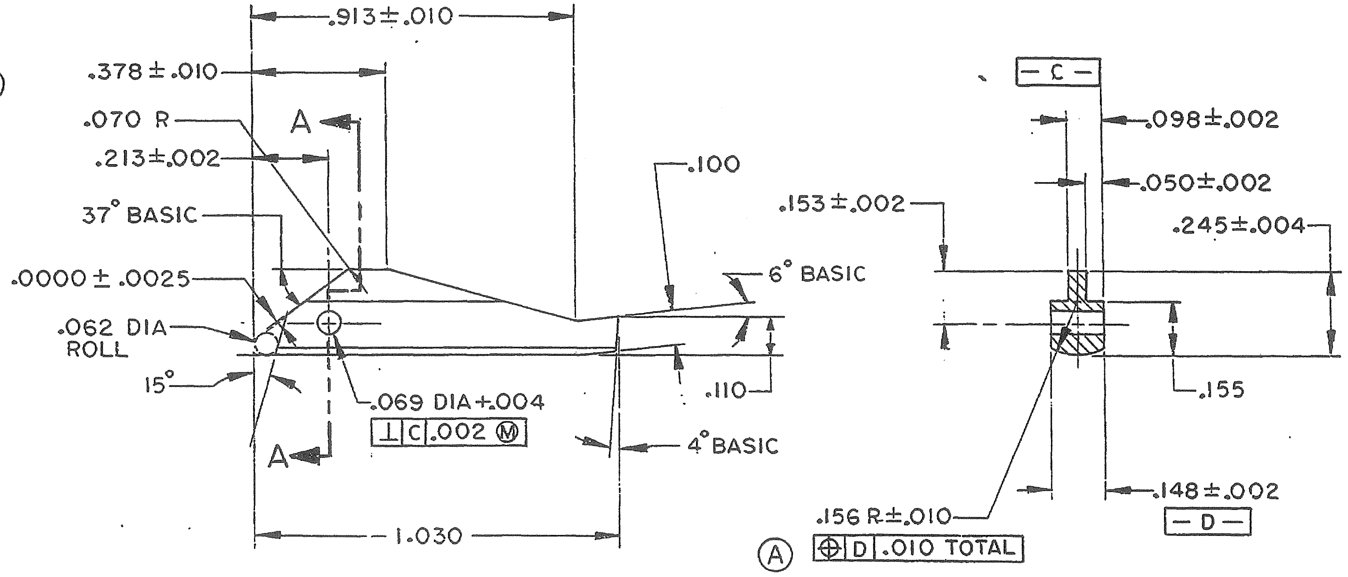
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62269 REVISION B	27 APR 70	
M		A	(3) SEE ERR HQR 20778	6 OCT 72	R.C.
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR G8S3063/880628	890110	ORF1-88
		D	NOR G1S2018 91 07 08	91-10-11	ER
		E	NOR G2S3059/920716 (ECP G2S3060/920630)	92-08-11	AJL

NOTE:-

1. FINISH 63/.
2. BREAK ALL EDGES .005+.005.
3. STEEL, GMPSN 1137, 1141, OR 1144, SPEC ASTM A108.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES. Ⓐ



SECTION A–A

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22. Ⓐ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		9349086	M4
		C8448541	M16A1
RH	C44-48	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± ——

MATERIAL
SEE NOTE 3

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970
PREPARED RGA
CHECKED
ENGINEER D. Smart D. Billiet
SUBMITTED F. P. Gellhorly
APPROVED K. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PAWL,
FORWARD ASSIST

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448543

SCALE 4/1 SHEET 1 OF 1

AMSWE Form 403C, 29 Jul 69

CDI

C8448543

tober 14, 2004 11:58 AM

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		B	REPLACES REV A W/CHANGE SEE ERR HQR.. 20778	6 OCT 72	
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NORW2S0011 / 82-04-13 (ECPW2S0034 / 82-07-15) (ECPW3S3120 / 83-07-07)	83-11-04	
		E	NOR GIS2018 / 91-07-08	91-10-11	RR SL

B8448520

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.
3. ROCKWELL HARDNESS SHALL BE 15N 84.5 MIN.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003±.012.

SPRING, HELICAL, COMRESSION

WIRE DIAMETER .... .0240 ± .0005
COIL DIAMETER (O.D.) .... .175 ± .004
FREE LENGTH AFTER SETTING .... 1.250 REF
TOTAL COILS .... 21 REF
DIRECTION OF HELIX .... OPTIONAL
LOAD AT COMPRESSED LENGTH OF .750 IN. ...... 3.50 LB ± .35 LB
SOLID LENGTH .... .535 MAX
TYPE OF ENDS .... CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

CURRENT FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448520

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		8448517	M4
YS MAX		B8448517	M231
EL 2			M16
RA		B8448517	M16A1
BH			
RH	SEE NOTE 3	APPLICATION	

~~UNLESS OTHERWISE SPECIFIED~~
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

~~CONTRACT NO:~~
DATE 27 APR 70

PREP	P. Vernon	L. Gutman
CHK	G. Dreselhaus	D. Hrolek
ENGR	R. Elbe	L. Bunton

SUBMITTED A. A. Cole

APPROVED R. S. Henry

DEPT OF THE ~~ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

SPRING, CHARGING HANDLE LATCH

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448520

SCALE — SHEET 1 OF 1

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

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REVISIONS

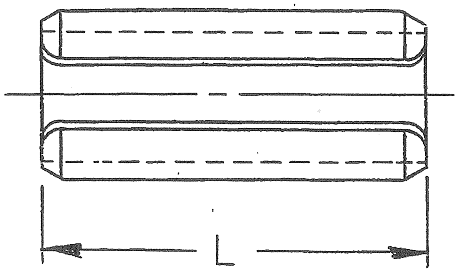
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REPLACES COLT'S PART NUMBERS 95103 95113 AND 95138-1 FROM COLT'S DRAWING D95101 REV C	27 APR 70	
		A	(4) SEE EO HRD 02197-3	15 JULY 70	
		B	SEE ERR HQR 10822	9 AUG 71	LB
		C	SEE ERR HQR 10836	13 SEP 71	LB
		D	NOR W9S2009 80-02-13	80-05-16	
		E	NORW2S0020 82-06-09	83-02-03	LAH
		F	NOR W4S3048 / 84-10-09	85-02-14	
		G	NOR G1S2018 / 91 07 08	91-10-11	RR SC

B8448521

NOTE:

1. BREAK ALL SHARP EDGES Ⓐ .003+.012.

PART NO.	MS MODIFIED Ⓐ	DIM L Ⓒ	NEXT ASSY
8448521-1	MS16562-130	.719±.010	C8448615
8448521-2	MS16562-97	.267±.010	B8448517 D9349086



CURRENT FSCM NO. 19200

Ⓑ

Ⓐ

ALTERED ITEM DRAWING

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

~~DEPT. OF THE ARMY~~
U.S. ~~ARMY~~ WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

MECHANICAL PROPERTIES			
YS MIN		8448517	M4
YS MAX		B8448517	M231
EL 2			M16
RA		SEE TABLE	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——

MATERIAL

FINAL PROTECTIVE FINISH ——

CONTRACT NO:
DATE 27 APR 1970
PREP G.E.W
CHK A.J.H.
ENGR S. Smart D. Billiet
SUBMITTED F.P.
APPROVED R.S. Henry

PIN, SPRING

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448521

SCALE NONE SHEET OF 1

CDI

AMSWE Form 403B, 29 Jul 69

ctober 14, 2004 11:38 AM

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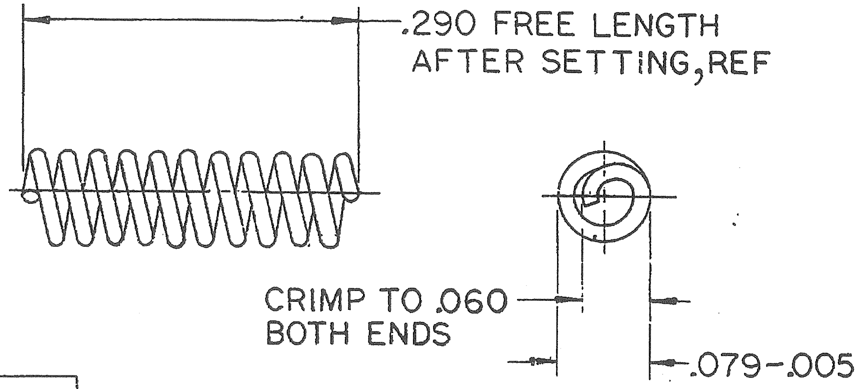
E	NOR G1S2018	91 07 08	91-10-11 se

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C 50381 REV A	27APR70	
M		A	(1) SEE EO HRD 02197-3	15JULY70	
	-	B	(2) SEE ERR HQR 20778	6 OCT 72	B
		C	NOR W2S0011 / 82-04-13 (ECP W3S3120 / 83-07-07)	83-11-04	
		D	NOR G8S2005/ 880310	880927	ORFI-V2

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, ASTM-A228 Ⓐ
2. STRESS RELIEVE. HOLD AT 475° F ±25° FOR 30 MINUTES.
3. MIL-W-13855 APPLIES. Ⓑ
4. BREAK SHARP EDGES .003+.012



SPRING DATA
WIRE DIA: .0140±.0003
TOTAL COILS: 10.5 REF
DIRECTION OF HELIX: OPTIONAL
LOAD AT COMRESSED LG OF .205 IN. = 1.75 LBS ±.25 LBS
SOLID LENGTH: .170 MAX
TYPE OF ENDS: PLAIN CRIMPED AS SHOWN

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572 Ⓑ

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		9349086	M4
RA		C8448541	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 27 APR 1970
PREP G.E.W. A.G.
CHK D.H.H. D.G.B.
ENGR D. Smart D. Billiet
SUBMITTED F. P. Fellwock
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, BOLT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448542

SCALE 10/1 SHEET 1 OF 1

B8448542

AMSWE Form 403B, 29 Jul 69

CDI

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DRAWING SIZE D
(ARRADCOMR 70-12)

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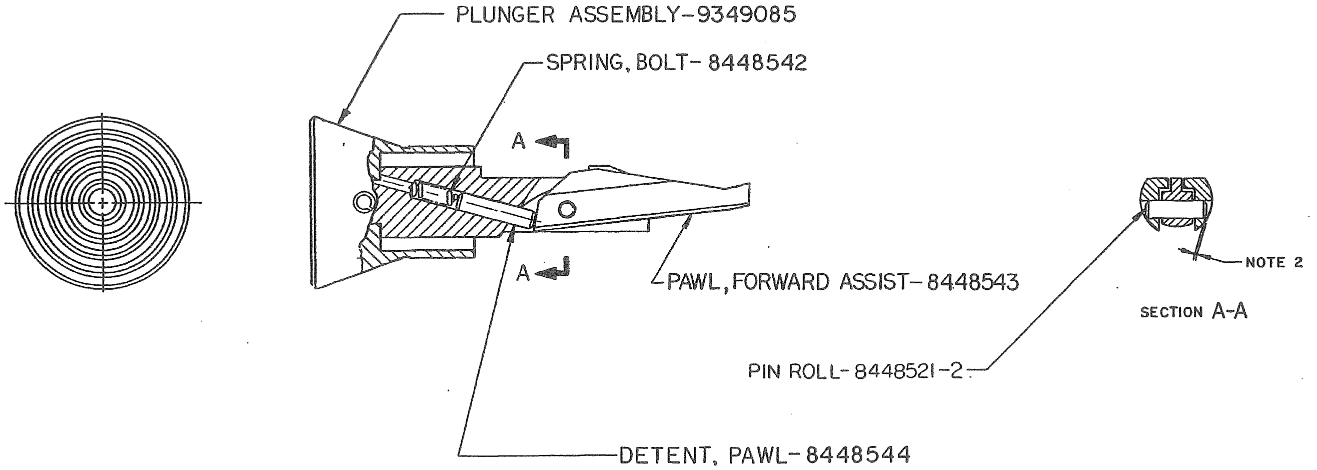
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S0011/83-03-09	83-11-09	
B	NORW2S3258/82-12-30	84-09-04	
C	NORW4S0030/84-11-15	850402	
D	NOR G7S3018/870312	880114	
E	NOR G1S2018/910708	911011	RR

NOTES:—

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 — INSERT ROLL PIN SUCH THAT ENDS ARE FLUSH WITH OR BELOW SURFACE ON BOTH SIDES AS SHOWN.



FOR ENGINEERING PARTS LIST SEE PL 9349086

PART NO. 9349086

9390029	M4	
8448523	M16A1	
9349062	M16A2	
NEXT ASSY	USED ON	APPLICATION

MECHANICAL PROPERTIES	
YP	
TS	
EL2	
RA	
BH	
RH	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09	
DRAFTSMAN DHB	CHECKER JWH
ENGR	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

FORWARD ASSIST ASSEMBLY

SIZE	FSCM NO.	
D	19200	9349086
SCALE 4/1	UNIT WT.	SHEET 1 OF 1

TECHNICAL DATA PACKAGE LIST 8448535
DOCUMENT NUMBER D 8448535
SPECIFICATION MIL-W-63150
NATIONAL STOCK NUMBER
DRUM,WINDAGE

ARMAMENT RESEARCH DEVELOPMENT & ENGINEERING CENTER
DOVER, NEW JERSEY 07801-5001
CAGE 19200

19 NOV 87

SHEET 1 oF 4

REQUEST/PRON 811713

PRODUCT DRAWINGS AND ASSOCIATED DOCUMENTS

CAGE CD	PRE-FIX CODE	DRAWING/DOCUMENT SZE	NUMBER	SHEET NO	OF	REV SYM	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
19204		D	8448535	1	1	D	02/06/85	LMTD	DRUM,WINDAGE	
19204	PS		8448535	1	1	C	06/11/80	LMTD	PKG DATA SHT - DRUM,WINDAGE	
19204	SQ		8448535	1	3	D	02/06/85	LMTD	SQAP - DRUM,WINDAGE	
				2	3	D	02/06/85			
				3	3	D	02/06/85			
		F	12579607	1	1		11/24/86		GEOMETRIC SYMBOLS FOR DIMENSIONING AND TOLERANCING	

LMTD - PROPRIETARY INFORMATION FOR WHICH THE GOVERNMENT HAS ONLY LIMITED RIGHTS FOR USE

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TECHNICAL DATA PACKAGE LIST 8448535
DOCUMENT NUMBER D 8448535
SPECIFICATION MIL-W-63150
NATIONAL STOCK NUMBER
DRUM,WINDAGE

ARMAMENT RESEARCH DEVELOPMENT & ENGINEERING CENTER
DOVER, NEW JERSEY 07801-5001
CAGE 19200

19 NOV 87

SHEET 2

REQUEST/PRON 811713

INSPECTION EQUIPMENT DRAWINGS AND ASSOCIATED DOCUMENTS

CAGE CD	PRE-FIX CODE	DRAWING/DOCUMENT SZE	NUMBER	SHEET NO	OF	REV SYM	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
19204		D	8443613	1	1	B	12/21/73		GAGE,LOCATION	
19204		D	8443856	1	1	B	12/21/73		GAGE,LOCATION	
19204	EL		8448535	1	1		02/05/75	LMTD	IEL - DRUM,WINDAGE	

LMTD - PROPRIETARY INFORMATION FOR WHICH THE GOVERNMENT HAS ONLY LIMITED RIGHTS FOR USE

tober 14, 2004 12:22 AM

TECHNICAL DATA PACKAGE LIST 8448535 ARMAMENT RESEARCH DEVELOPMENT & ENGINEERING CENTER 19 NOV 87
DOCUMENT NUMBER D 8448535 DOVER, NEW JERSEY 07801-5001
SPECIFICATION MIL-W-63150 CAGE 19200 SHEET 3
NATIONAL STOCK NUMBER
DRUM,WINCAGE REQUEST/PRON 811713

SPECIFICATIONS AND STANDARDS

QPL	DOCUMENT NUMBER	REV SYM	AMD NO	INT CHG NO.	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
Q	VV-L-800	C	1		09/15/86		LUBRICATING OIL, GENL PURPOSE PRESERVATIVE	*
	PPP-B-636	J	1		01/20/82		BOX,SHIPPING,FIREBOARD	*
	PPP-T-76	C			08/02/84		TAPE, PRESSURE-SENS ADH PAPER, WATER RES	*
	FED-STD-791	C			09/30/86		LUBRICANTS, LIQUID FUELS, REL PROD, MTHD OF TSTG	*
	MIL-P-116	H	1		04/11/85		METHOD OF PACK PRESERVATION	*
	MIL-B-117	E	1		07/15/75		BAG, SLEEVE & TUBING, INTERIOR PACKAGING	*
Q	MIL-P-3420	E	2		02/20/85		PACKAGING MATERIALS, VOLATILE CRSN INHIBITOR, TREATED	*
	MIL-G-10944	B	3		02/19/82		GAGES, DIMENSIONAL CONTROL	*
	MIL-W-13855	D		4	10/09/84		WEAPONS,SMALL ARMS AND AIRCRAFT ARMAMENT SYS.GEN SPEC	*
	MIL-P-14232	E	2		09/02/81		PARTS, EQUIPMENT AND TOOLS FOR ARMY MATERIAL, PKG OF	*
	DOD-P-16232	F			11/07/78		PHOSPHATE COATINGS, HEAVY, MANGANESE OR ZINC BASE	*
	MIL-P-16232	(REPLACED BY DOD-P-16232)						
	MIL-W-63150		1		09/15/81		WEAPONS AND SPRT MATERIEL, STD QA PROV FOR	*
	MIL-STD-105	D		2	03/20/64		SMPLG PROCEDURES & TABLES FOR INSPECTION BY ATTRIBUTES	*
	MIL-STD-129	J		1	11/05/86		MARKING FOR SHIPMENT AND STORAGE	*
	MIL-STD-171	D		3	12/17/85		FINISHING OF METAL AND WOOD SURFACES	*
	MIL-STD-1189	A			09/04/84		STANDARD DEPARTMENT OF DEFENSE BAR CODE SYMBOLOGY	*
	ANSI-B46.1				00/00/78		SURFACE TEXTURE	**
	ANSI-B47.1				00/00/81		GAGE BLANKS	**
	CS8	(REPLACED BY ANSI-B47.1)						
	ANSI-Y14.5				00/00/73		DIMENSIONING AND TOLERANCING FOR ENGINEERING DRAWINGS	**
	ASTM-A108				00/00/81		STEEL BARS, CARBON, COLD FINISHED, STD QUAL, SPEC FOR	**
	ASTM-B310				00/00/83		SINTERED CARBON STEEL STRUCTURAL PARTS SPEC FOR	**
	ASTM-D3951				00/00/82		STANDARD PRACTICE FOR COMMERCIAL PACKAGING	**

* - NOT FURNISHED - TO BE OBTAINED FROM C.O. NAVAL PUBLICATIONS AND FORMS CTR., 5801 TABOR AVE., PHILA., PENNA., 19120, ATTN. CODE 105. IF NOT AVAILABLE, IMMEDIATELY ADVISE THE PROCURING CONTRACTING OFFICER.

Q - THE LETTER (Q) BEFORE THE SPECIFICATION NUMBER INDICATES THAT A QUALIFIED PRODUCTS LIST IS REQUIRED. THE NUMBER OF THE QPL IS THE SAME AS THE NUMBER OF THE SPECIFICATION.

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TECHNICAL DATA PACKAGE 8448535
DOCUMENT NUMBER D8448535
SPECIFICATION MIL-W-63150
NATIONAL STOCK NUMBER
DRUM, WINDAGE

U. S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
DOVER, NEW JERSEY 07801- 5001
FSCM 19200

DATE 19 Nov 87
SHEET 4 of 4

REQUEST/PRON 811713

3. ENGINEERING CHANGES AND ADDITIONS:

a . THE FOLLOWING ENGINEERING CHANGE PROPOSAL FORMS A PART OF THIS TECHNICAL DATA PACKAGE:

ECP NO	NO OF CARDS
G7Q2043	1

ctober 14, 2004 12:21 AM

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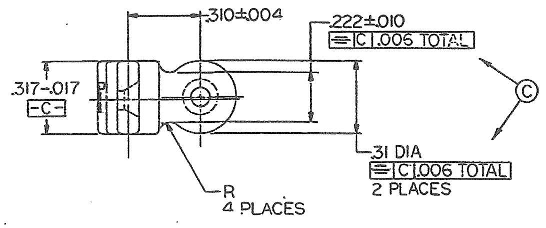
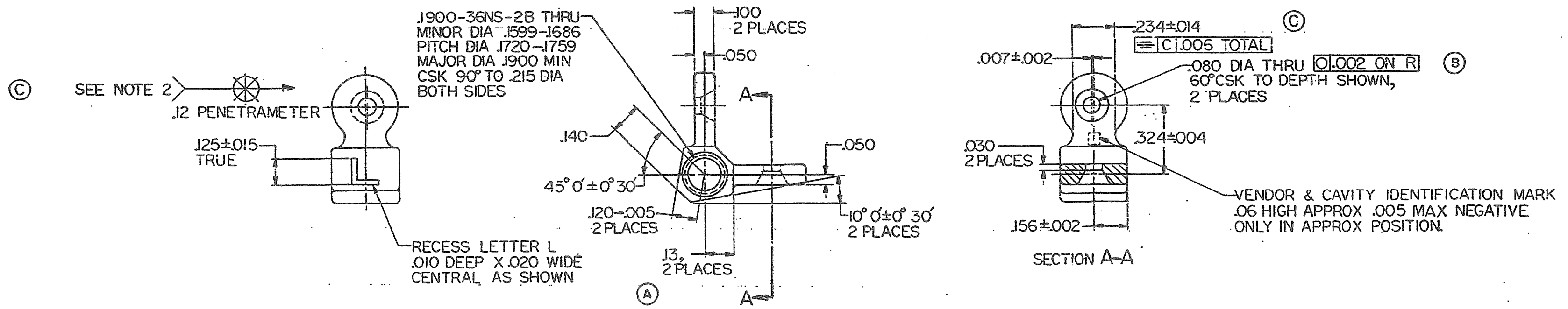
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D-61700 REV B	27 APR 70	
		A	(2) SEE EO HRD 02259	15 OCT 70	
		B	(1) SEE HQR 10689	25 APR 71	B
		C	(4) SEE ERR HQR 20778	6 OCT 72	R.E.
		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W5S2099 85-11-21	86-07-08	

NOTES:

1. STEEL, INVESTMENT CASTING, CMPSN IC 4130, SPEC MIL-S-22141, EXCEPT THAT SILICON CONTENT SHALL BE .20 TO .70%.
2. CLASSIFICATION AND INSPECTION OF CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE B, MIL-STD-2175. Ⓒ
3. FINISH 125/ EXCEPT AS NOTED.
4. ALL EDGES AND FILLETS ARE .005 TO .020 R.
5. EJECTOR PIN MARKS .005 POSITIVE TO .005 NEGATIVE.
6. PARTING LINE FLASH TO BE .005 MAX.
7. MIL-W-13855 APPLIES. Ⓐ



.310±.004
.222±.010
≡ C .006 TOTAL
Ⓒ
.317-.017
-C-
.31 DIA
≡ C .006 TOTAL
2 PLACES
R
4 PLACES



Ⓒ
SEE NOTE 2
.12 PENETRAMETER
.125±.015
TRUE
RECESS LETTER L
.010 DEEP X .020 WIDE
CENTRAL AS SHOWN
.1900-36NS-2B THRU
MINOR DIA .1599-.1686
PITCH DIA .1720-.1759
MAJOR DIA .1900 MIN
CSK 90° TO .215 DIA
BOTH SIDES
.100
2 PLACES
.050
A
.140
45° 0'±0° 30'
.050
.120-.005
2 PLACES
10° 0'±0° 30'
2 PLACES
.13
2 PLACES
Ⓐ
A
.234±.014
≡ C .005 TOTAL
Ⓒ
.007±.002
.080 DIA THRU ○ .002 ON R
60° CSK TO DEPTH SHOWN,
2 PLACES
Ⓑ
.324±.004
.030
2 PLACES
VENDOR & CAVITY IDENTIFICATION MARK
.06 HIGH APPROX .005 MAX NEGATIVE
ONLY IN APPROX POSITION.
.156±.002
SECTION A-A

ORIGINAL DESIGN ACTIVITY FSCM NO. 19204

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 1° 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.010	CONTRACT NO: DATE 27 APR 1970	~~DEPT OF THE ARMY~~ ~~U.S. ARMY WEAPONS COMMAND~~ ~~ROCK ISLAND, ILLINOIS 61201~~
YS MIN			MATERIAL SEE NOTE 1	PREPARED	SIGHT, REAR
YS MAX				CHECKED	
EL 2				ENGINEER	
RA				SUBMITTED F. P. Gilbody	SIZE D
BH	D8448602	M16			CODE IDENT NO. ~~19204~~
RH	D8448523	M16A1	FINAL PROTECTIVE FINISH 5.3.12 OF MIL-STD-171	APPROVED K. S. Henry	DRAWING NO. 8448539
	NEXT ASSY	USED ON			SCALE 4/1
	APPLICATION				SHEET 1 OF 1

CDI

D8448539

AMSWE Form 403D, 29 Jul 69

ctober 14, 2004 12:21 AM

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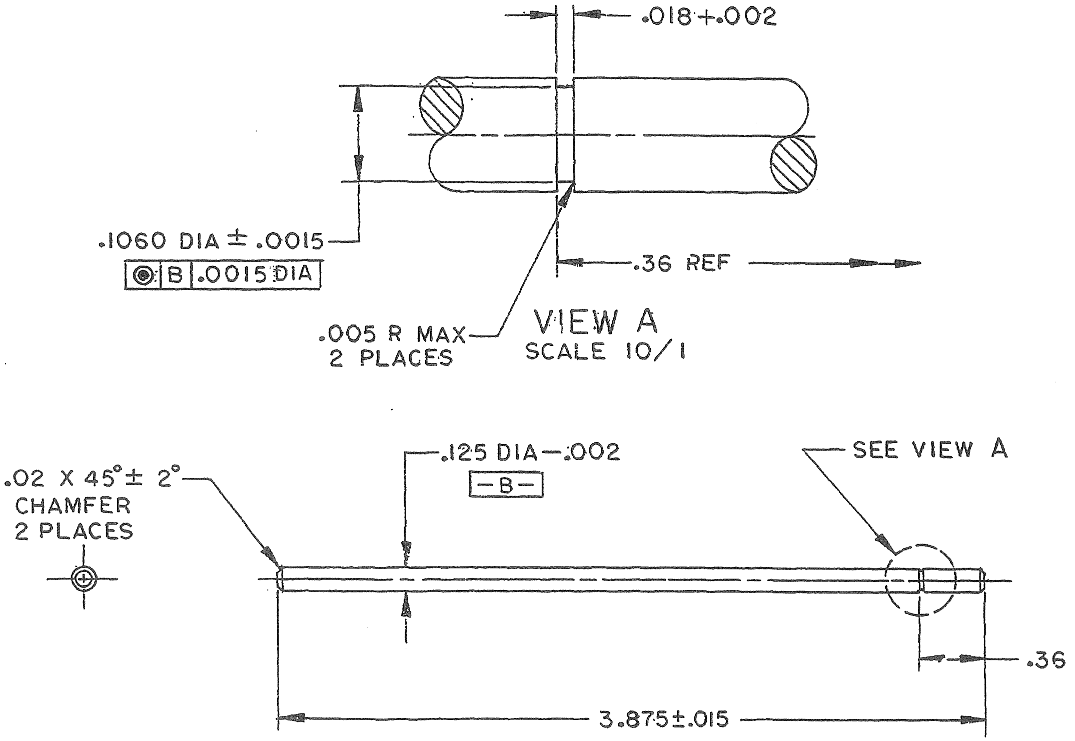
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		H	NOR G4S3137 950105	950426	HJS
		J	NOR G6S3132 960814	961003	HJS
		K	NOR G6S3157 961125	970103	JB

NOTE:

1. STEEL, COLD FINISHED, AISI 1018, 1112, OR 1215. SPEC ASTM A108.
2. FINISH 63/√.
3. BREAK SHARP EDGES .003 MAX.
4. MIL-W-13855 APPLIES
5. HEAT TREAT: CARBURIZE .003 TO .008 TOTAL CASE DEPTH, HARDNESS SHALL BE R15N 80-87.



C8448533

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL2		9390029	M4
RA		9349062	M16A2
		D9327228	XM 237
BH		D8448602	M16
		D8448523	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970

PREPARED	RGH	a. J. st
CHECKED	DHH	Z. Feidlem
ENGINEER	D. Smart	B. Billet

SUBMITTED
F. P. Fellerly

APPROVED
R. S. Henry

DEPT. OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, COVER, HINGE

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448533

SCALE 2/1 SHEET 1 OF 1

CDI

AMSWE Form 403C, 29 Jul 69

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J	NOR G0S3091/890613	901022	GHS GSC	
K	NORG1S2018/910708	911011	RR	
L	NOR G5S3014 950417	960521	RLV	

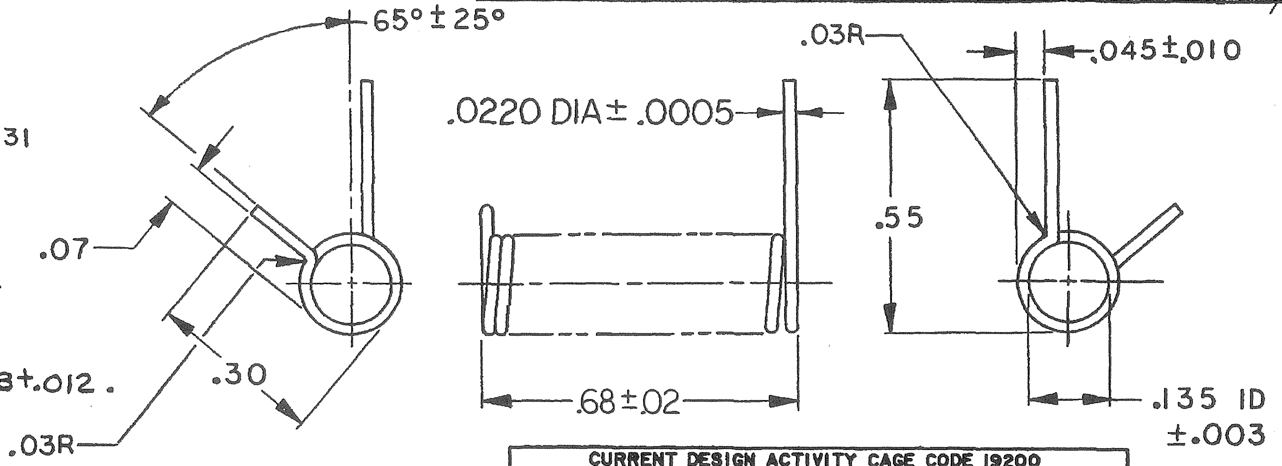
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61518 REVISION A	27APR 70	
		A	(1) SEE EO HRD 02197-3	15JULY 70	
		B	(2) SEE EO HRD 02256	15 OCT 70	
		C	(4) SEE EO HQR 10619	20 FEB 71	
		D	(3) SEE ERR HQR 20778	6 OCT 72	LB
M		E	NOR W9S2009 80-02-13	80-05-16	
		F	NORW2S0011 / 82-04-13 (ECPW2S0034 / 82-07-15) (ECPW3S3120 / 83-07-07)	83-11-04	
		G	NOR W6S0109/ 86-11-07	870224	
		H	NOR G9S3034 890616	891130	

B 8448532

NOTE:

1. WIRE, CORROSION RESISTING, TYPE 631, COLD DRAWN, PER ASTM A313, OR STEEL, CORROSION RESISTING, COMPSN 302, CONDTN B, SPEC. MIL-S-7720, EXCEPT % ELONGATION AND % REDUCTION OF AREA IN TABLE II SHALL NOT APPLY.
2. DIRECTION OF HELIX – LEFT HAND.
3. TOTAL COILS 29 3/4.
4. PRECIPITATION HEAT TREAT TYPE 631 MATERIAL AFTER FORMING. HOLD AT 900°F ± 10° FOR ONE HOUR.
5. SPRING SHALL BE FREE FROM BURRS, NICKS, SNAGS AND OTHER INJURIOUS DEFECTS.
6. MIL-W-13855 APPLIES.
7. BREAK SHARP EDGES .003±.012.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN		9390029	M4
YS MAX		9349062	M16A2
EL 2		D9327228	M231
RA		D8448602	M16
BH		D8448523	M16A1
		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

Ⓓ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
3.3.4 OF MIL-STD-171

CONTRACT NO
DATE 27 APR 1970
PREP A. J. A.
CHK H. Leedham
ENGR D. Smart D. Billiet
SUBMITTED F. P. Gillooly
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, COVER

SIZE B | CODE IDENT NO 19204 | DRAWING NO 8448532
SCALE 5/1 | SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

tober 14, 2004 12:20 AM

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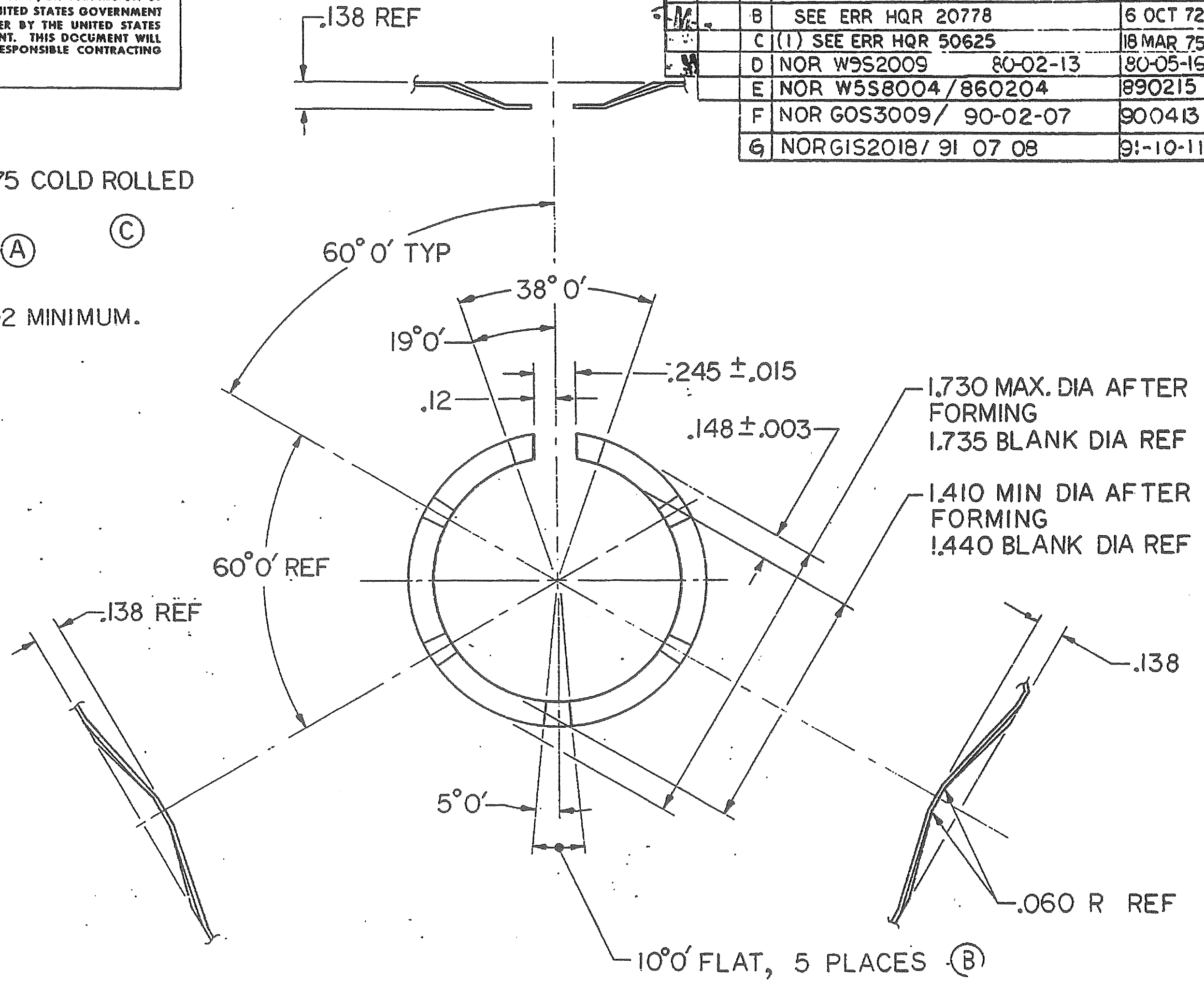
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D61961 REV A	27 APR 70	
		A	(2) SEE ERR HQR 10726	26 MAY 71	YB
		B	SEE ERR HQR 20778	6 OCT 72	R.E.
		C	(1) SEE ERR HQR 50625	18 MAR 75	YB
		D	NOR W9S2009 80-02-13	80-05-15	
		E	NOR W5S8004/860204	890215	ORFI-B.B.
		F	NOR G0S3009/ 90-02-07	900413	
		G	NORG1S2018/ 91 07 08	91-10-11	RR

NOTE:

1. STEEL, ASTM A684, 1075 COLD ROLLED STRIP ANNEALED. MATERIAL THICKNESS .020 ± .001. Ⓐ Ⓒ
2. FINISH 125√.
3. DEBURR AND BREAK EDGES TO .002 MINIMUM.
4. BEND RADII .06.
5. MIL-W-13855 APPLIES. Ⓐ



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

C8448556 Ⓑ

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
C8448555	M4
C8448555	M231
	M16, M16A2
C8448555	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±0°30'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR. 1970
PREPARED P.O.R. A.J.St.
CHECKED D.S.H. J. Ledham
ENGINEER D. Billiet
SUBMITTED F.P. Gilhooly
APPROVED K.J. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

SPRING SECTION, HAND GUARD SLIP RING

SIZE C | CODE IDENT NO. 19204 | DRAWING NO. 8448556

SCALE 2/1 | SHEET | OF

CDI

AMSWE Form 403C, 29 Jul 69

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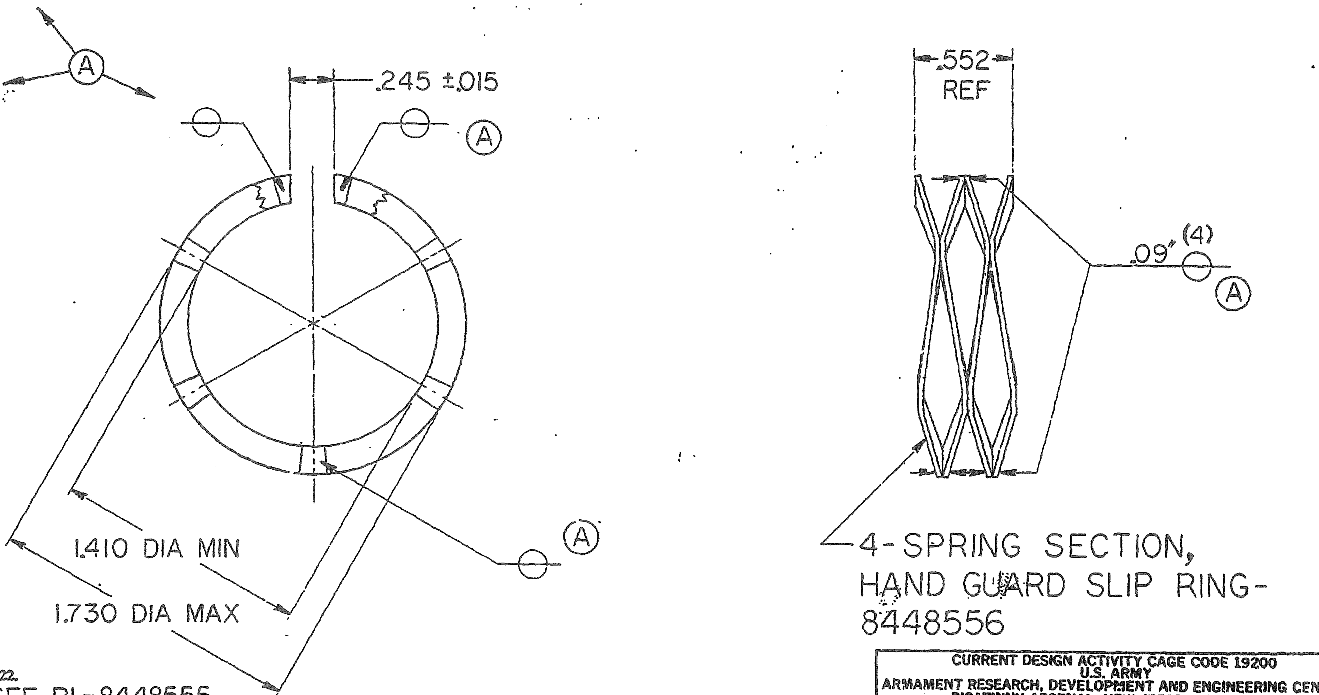
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61962 REV. A	27 APR 70	
		A	(4) SEE ERR HQR 20778	10 DEC 72	GE
		B	NOR W9S2009 80-02-13	80-05-15	
		C	NOR W5S8004 / 860204	890215	
		D	NOR GIS2018 91-07-08	91-10-11	RB SL
		E	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL

NOTES:

1. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171, EXCEPT: CLEAN IN ACCORDANCE WITH METHOD II, SPEC TT-C-490. ABRASIVE BLASTING SHALL NOT BE USED.
2. SPOT WELDS MUST HOLD AFTER COMPRESSION TO .215 HEIGHT ON SPRING TESTER.
3. MIL-W-13855 APPLIES.



C8448555

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SEE PL-8448555

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448711	M4
			M231
BH			M16, M16A2
		B8448711	M16A1
RH	15N 82.5-84.5	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——

MATERIAL
——

FINAL PROTECTIVE FINISH
SEE NOTE 1

CONTRACT NO:

DATE 27 APRIL 1970

PREPARED	ECL	A. J.
CHECKED		
ENGINEER		D. Billiet
SUBMITTED	F. P. Gilhooly	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

SPRING WELD ASSEMBLY, HAND GUARD SLIP RING

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448555

SCALE 2/1 SHEET OF

CDI

AMSWE Form 403C, 29 Jul 69

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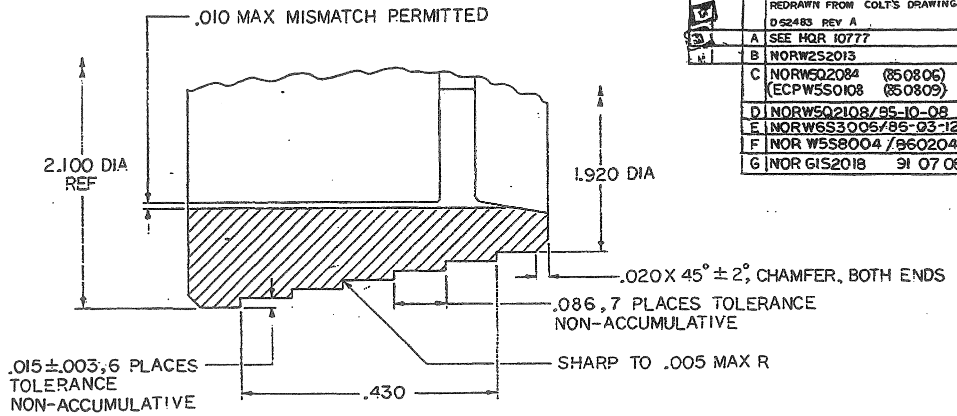
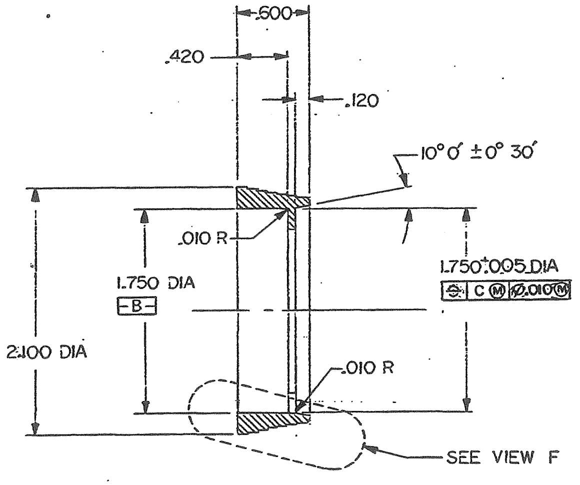
NOTE:

1. FINISH 125√
2. BREAK SHARP EDGES .005 MAX.
3. ALL DIAMETERS ⊕ | C | .010 Ⓜ
4. ALL DIMENSIONS APPLY BEFORE FINISH.
5. GRIT BLAST CONTOURED O.D. PRIOR TO FINISH TO PRODUCE NON REFLECTIVE MATTE SURFACE AFTER FINISH.
6. FINISH MIL-A-8625, TYPE 3, CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX. BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL.

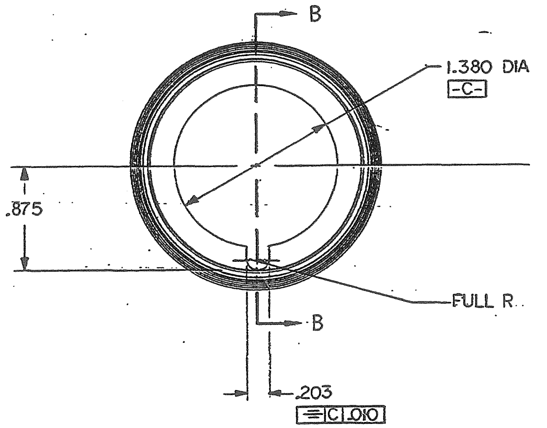
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D52483 REV A	27 APRIL 1970	
		A	SEE HQR 10777	18 JUN 71	L R
		B	NORW2S2013	820614	
		C	NORW5Q2084 (850806) (ECPW5S0108 (850809)	85-08-22	R Hall
		D	NORW5Q2108/85-10-08	86-01-30	
		E	NORW6S3005/85-03-12	87-02-17	
		F	NOR W5S8004 / 860204	890215	
		G	NOR G1S2018 91 07 08	91-10-11	RE SR


.010 MAX MISMATCH PERMITTED
2.100 DIA REF
1.920 DIA
.020 X 45° ± 2°, CHAMFER, BOTH ENDS
.086, 7 PLACES TOLERANCE NON-ACCUMULATIVE
SHARP TO .005 MAX R
.015 ± .003, 6 PLACES TOLERANCE NON-ACCUMULATIVE
.430

VIEW F
SCALE 10/1


.600
.420
.120
10° 0' ± 0° 30'
.010 R
1.750 DIA
-B-
1.750 ±.005 DIA
⌯ | C Ⓜ | ⌀.010 Ⓜ
2.100 DIA
.010 R
SEE VIEW F

SECTION B-B


B
1.380 DIA
-C-
.875
FULL R
B
.203
⌯ | C | .010

Ⓐ

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		8448711	M4
EL2			M231
RA			M16
			M16A1
BH			M16A2
		B8448711	XM177E2
RH		NEXT ASST	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ±

MATERIAL
ALUMINUM ALLOY
7075-T6
QQ-A-225/9

FINAL PROTECTIVE FINISH
SEE NOTE 6

CONTRACT NO:

DATE 27 APRIL 1970

PREPARED	Par	R.O. St.
CHECKED		
ENGINEER		D. Elliot

SUBMITTED
F.P. Yellard

APPROVED
R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SLIP RING,
HAND GUARD

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448712

SCALE 2/1 SHEET 1 OF 1

D 8448712

ober 14, 2004 12:25 AM

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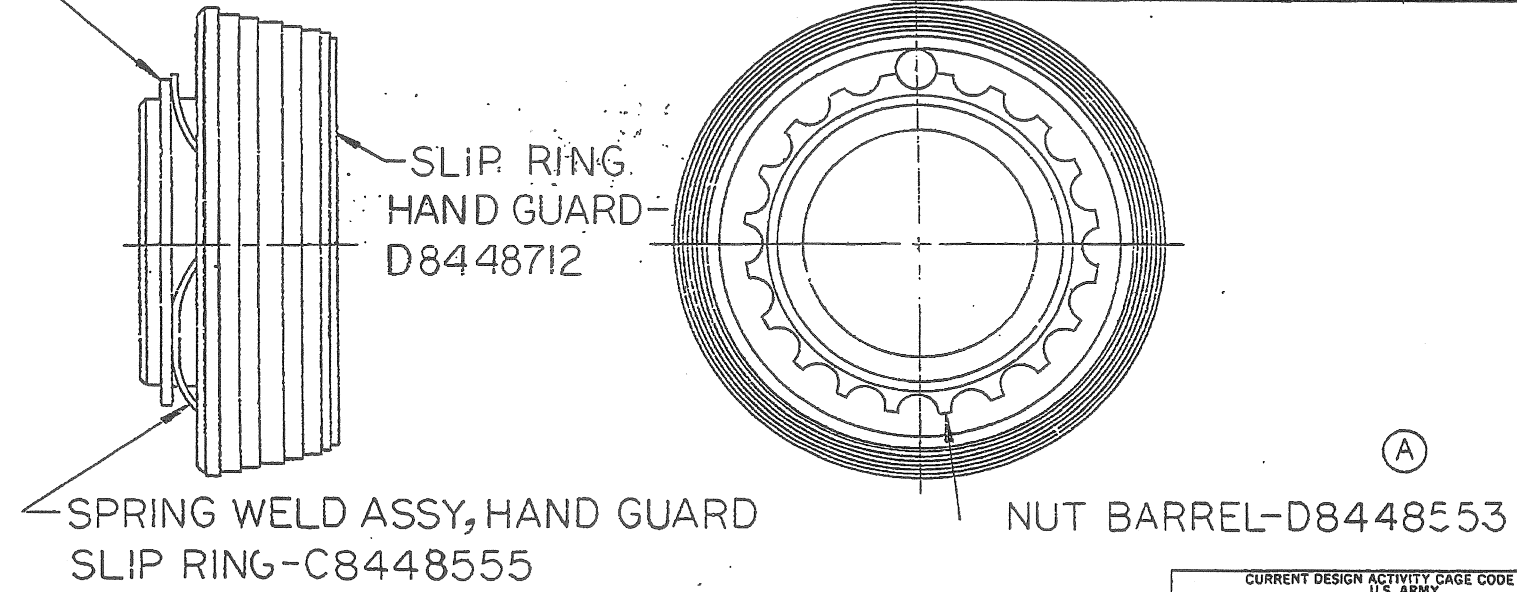
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C 62482 REV A	27 APR 70	
		A	SEE HQR 10777	18 JUN 71	LB
		B	NORW2S2013	820614	
		C	NOR W5S8004 / 860204	890215	ORFI-BEV
		D	NOR GOS3010/ 90-02-28	30 09 06	
		E	NOR GIS2018 91-07-08	91-10-11	RR

B8448711


RING, RETAINING-MS16626-3137
SLIP RING HAND GUARD-D8448712
SPRING WELD ASSY, HAND GUARD SLIP RING-C8448555
NUT BARREL-D8448553
A

SEE SEPARATE PARTS LIST-8448553

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		9390001	M4
YS MAX		F9327230	M231
EL 2		F8448601	M16
RA		F8448522	M16A1
BH		D9349050	M16A2
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——
MATERIAL
——
FINAL PROTECTIVE FINISH

CONTRACT NO
DATE 27 APR 1970
PREP G.E.W. A.J.D.
CHK
ENGR
SUBMITTED F.P. Fillwock
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BARREL NUT ASSY

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448711

SCALE 2/1 SHEET OF

AMSWE Form 403B, 29 Jul 69

~~BACKFILE~~

CDI
DUPLICATE ORIGINAL

tober 14, 2004 12:23 AM

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NOTES:-

1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2- MATERIAL:-PLASTIC COMPOUND PER 9349123.

3- REMOVE ALL FLASH AND BREAK SHARP EDGES .005-.010 R.

4- FILLET RADII .015-.012 UNLESS OTHERWISE NOTED.

5- EJECTOR PIN MARKS PERMISSIBLE ON SURFACE -M-, .010 MAX. NEGATIVE ONLY.

6- ENTIRE CONFIGURATION OF PART TO BE ≡ R .020 TOTAL. CENTER LINE -R- TO BE ESTABLISHED AS A LINE THROUGH THE CENTER OF DIAS -P- AND -L-.

7- CONTOUR OF ENTIRE PART IS ESTABLISHED BY DIMENSIONS DEPICTED IN SECTIONS B-B AND C-C.

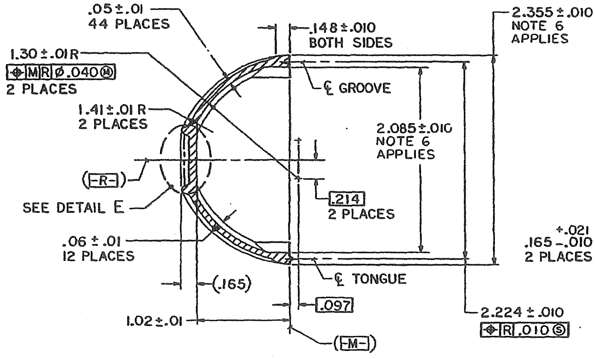
8- FINISH:-ALL EXTERIOR SURFACES TO BE DULL MATTE FINISH.

9- FINISH $\sqrt{125}$ ALL SURFACES EXCEPT AS NOTED.

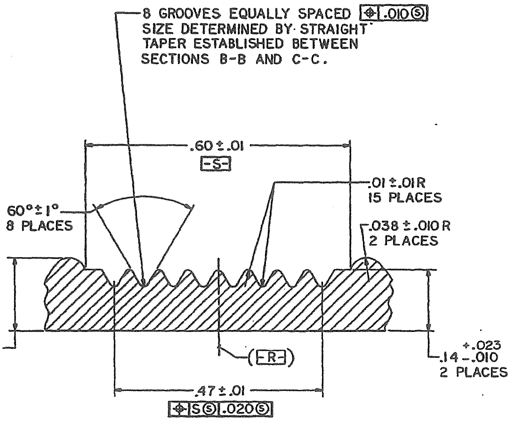
10- MARK OPTIONAL CAVITY IDENT FLUSH TO .010 BELOW -M- BY .10±.02 HIGH IN EJECTOR PIN MARK, IN POSITION SHOWN ONLY.

11- EACH HANDGUARD SHALL BE CAPABLE OF WITHSTANDING A 50 POUND + 1 STATIC LOAD APPLIED PARALLEL TO -M- WITHOUT CRACKING OR BREAKAGE. THE HANDGUARD SHALL BE SECURELY HELD IN THE ORIENTATION SHOWN AND SHALL BE UNIFORMLY LOADED ALONG EACH END.

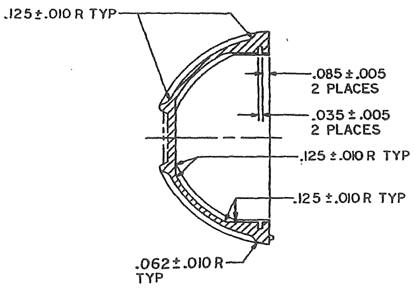
12- FLATNESS SHOWN IS IN A FREE STATE CONDITION. DATUM -M- IS ESTABLISHED WHEN PART IS IN A CONSTRAINED STATE, WITH FLATNESS OF .010 OR LESS.


.05±.01
44 PLACES
.148±.010
BOTH SIDES
2.355±.010
NOTE 6
APPLIES
1.30±.01R
⌖ M R Ø.040 Ⓜ
2 PLACES
℄ GROOVE
1.41±.01 R
2 PLACES
2.085±.010
NOTE 6
APPLIES
(-R-)
.214
2 PLACES
SEE DETAIL E
.06±.01
12 PLACES
(.165)
℄ TONGUE
.097
1.02±.01
(-M-)
2.224±.010
⌖ R .010 Ⓢ

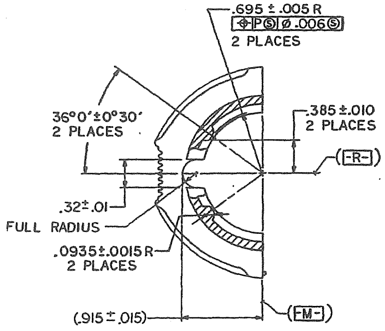
SECTION B-B
NOTE 6


8 GROOVES EQUALLY SPACED ⌖ .010 Ⓢ
SIZE DETERMINED BY STRAIGHT
TAPER ESTABLISHED BETWEEN
SECTIONS B-B AND C-C.
.60±.01
-S-
.01±.01R
15 PLACES
60°±1°
8 PLACES
.038±.010R
2 PLACES
+.021
.165 -.010
2 PLACES
(-R-)
+.023
.14 -.010
2 PLACES
.47±.01
⌖ S Ⓢ .020 Ⓢ

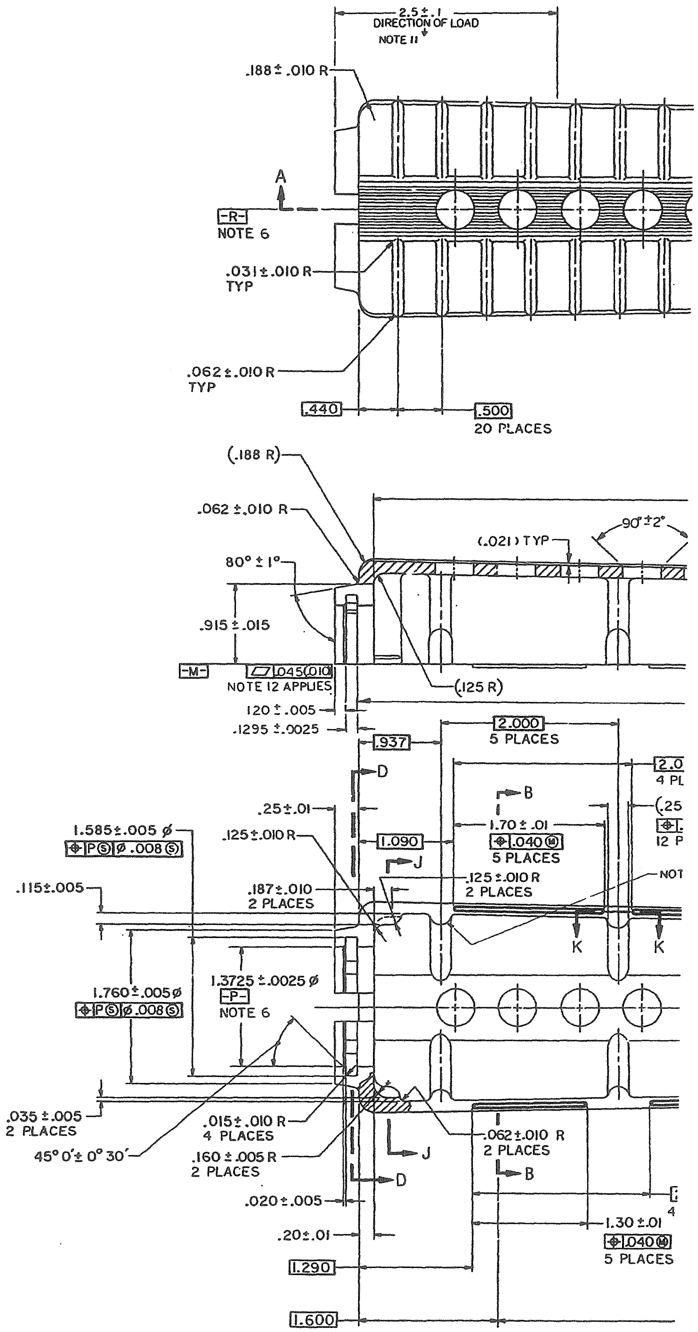
DETAIL E
ROTATED 90° C W
SCALE: 10/1


.125±.010 R TYP
.085±.005
2 PLACES
.035±.005
2 PLACES
.125±.010R TYP
.125±.010R TYP
.062±.010R
TYP

SECTION J-J

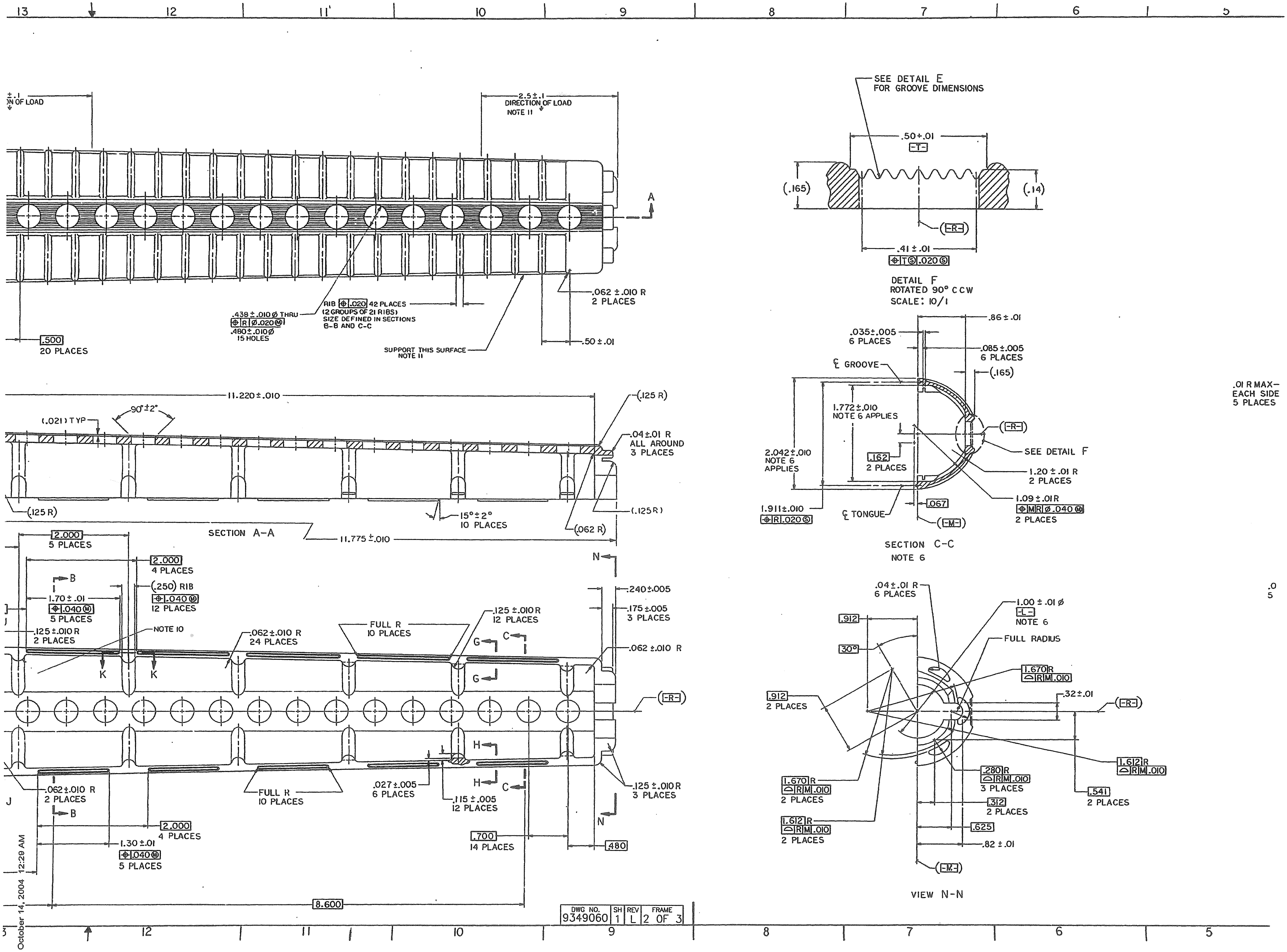

.695±.005R
⌖ P Ⓢ Ø.006 Ⓢ
2 PLACES
36°0'±0°30'
2 PLACES
.385±.010
2 PLACES
(-R-)
.32±.01
FULL RADIUS
.0935±.0015R
2 PLACES
(.915±.015)
(-M-)

SECTION D-D


2.5±.1
DIRECTION OF LOAD
NOTE 11
.188±.010 R
A
-R-
NOTE 6
.031±.010R
TYP
.062±.010R
TYP
.440
.500
20 PLACES
(.188 R)
.062±.010 R
90°±2°
(.021) TYP
80°±1°
.915±.015
-M-
⏥ .045 .010
NOTE 12 APPLIES
(.125 R)
.120±.005
.1295±.0025
.937
2.000
5 PLACES
2.0
4 PL
D
B
.25±.01
(.25
1.585±.005 Ø
⌖ P Ⓢ Ø.008 Ⓢ
.125±.010R
1.090
1.70±.01
⌖ .040 Ⓜ
5 PLACES
12 P
J
.125±.010R
2 PLACES
NOT
.115±.005
.187±.010
2 PLACES
K
K
1.3725±.0025 Ø
-P-
NOTE 6
1.760±.005Ø
⌖ P Ⓢ Ø.008 Ⓢ
.035±.005
2 PLACES
.015±.010R
4 PLACES
.062±.010 R
2 PLACES
45°0'±0°30'
.160±.005R
2 PLACES
J
D
B
.020±.005
1.30±.01
⌖ .040 Ⓜ
5 PLACES
.20±.01
1.290
1.600

DWG NO.	SH	REV	FRAME
9349060	1	L	1 OF 3

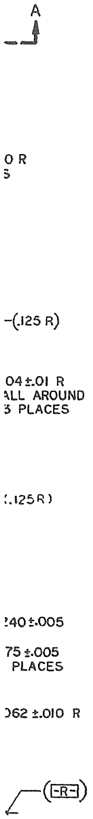
October 14, 2004 12:30 AM


13
12
11
10
9
8
7
6
5
±.1
ON OF LOAD
2.5±.1
DIRECTION OF LOAD
NOTE 11
A
.062 ±.010 R
2 PLACES
RIB ⌖ .020 42 PLACES
(2 GROUPS OF 21 RIBS)
SIZE DEFINED IN SECTIONS
B-B AND C-C
.438 ±.010 Ø THRU
⌖ R Ø.020 Ⓜ
.480 ±.010 Ø
15 HOLES
.500
20 PLACES
SUPPORT THIS SURFACE
NOTE 11
.50 ±.01
11.220 ±.010
(.125 R)
(.021) TYP
90°±2°
.04±.01 R
ALL AROUND
3 PLACES
(.125 R)
(.125 R)
15°±2°
10 PLACES
SECTION A-A
11.775 ±.010
(.062 R)
2.000
5 PLACES
2.000
4 PLACES
B
1.70 ±.01
⌖ .040 Ⓜ
5 PLACES
(.250) RIB
⌖ .040 Ⓜ
12 PLACES
.125 ±.010 R
2 PLACES
NOTE 10
K
K
.062 ±.010 R
24 PLACES
FULL R
10 PLACES
.125 ±.010 R
12 PLACES
G
C
G
N
.240 ±.005
.175 ±.005
3 PLACES
.062 ±.010 R
(-R-)
H
H
C
.062 ±.010 R
2 PLACES
B
J
J
FULL R
10 PLACES
.027 ±.005
6 PLACES
.115 ±.005
12 PLACES
.125 ±.010 R
3 PLACES
N
2.000
4 PLACES
1.30 ±.01
⌖ .040 Ⓜ
5 PLACES
.700
14 PLACES
.480
8.600
SEE DETAIL E
FOR GROOVE DIMENSIONS
.50 ±.01
-T-
(.165)
(.14)
(-R-)
.41 ±.01
⌖ T Ⓢ .020 Ⓢ
DETAIL F
ROTATED 90° CCW
SCALE: 10/1
.86 ±.01
.035 ±.005
6 PLACES
.085 ±.005
6 PLACES
℄ GROOVE
(.165)
1.772 ±.010
NOTE 6 APPLIES
(-R-)
2.042 ±.010
NOTE 6
APPLIES
.162
2 PLACES
SEE DETAIL F
1.20 ±.01 R
2 PLACES
1.09 ±.01 R
⌖ M R Ø.040 Ⓜ
2 PLACES
1.911 ±.010
⌖ R .020 Ⓢ
℄ TONGUE
.067
(-M-)
SECTION C-C
NOTE 6
.01 R MAX-
EACH SIDE
5 PLACES
.0
5
.04 ±.01 R
6 PLACES
1.00 ±.01 Ø
-L-
NOTE 6
.912
FULL RADIUS
30°
1.670 R
⌓ R M .010
.32 ±.01
.912
2 PLACES
(-R-)
1.612 R
⌓ R M .010
1.670 R
⌓ R M .010
2 PLACES
.280 R
⌓ R M .010
3 PLACES
.541
2 PLACES
.312
2 PLACES
1.612 R
⌓ R M .010
2 PLACES
.625
.82 ±.01
(-M-)
VIEW N-N

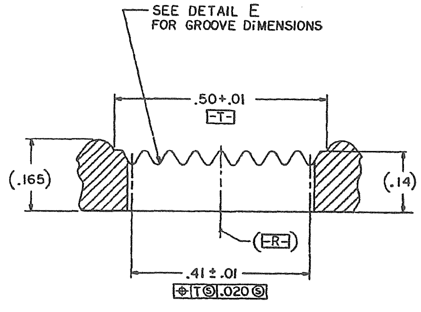
DWG NO.	SH	REV	FRAME
9349060	1	L	2 OF 3

October 14, 2004 12:29 AM

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S3114/83-05-05	830810	
B	NORW4S0030/84-11-15	850402	
C	NORW5S3000/85-02-08 (ECPW5S0032/85-03-25)	850625	
D	NORW6S0001 86-01-17	860304	
E	NORW6S3062/861204	870615	
F	NOR W5S8004 960204	890215	
G	ERRZ9Z1282AK (ECPG7S3176/880122) (ECPG9S2031/890706) (ECPG0S3090/900605	901115	
H	NORG0S3115/900718	910130	AJL
J	(NOR G1S3099 910814)	911101	
K	NOR G1S3143 911013	920122	
L	NOR L7S9451/970806	971002	FET

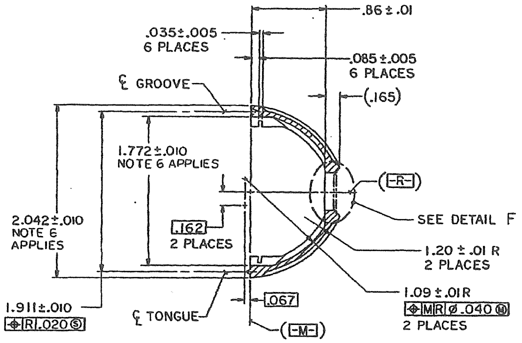


A
O R
S
-(.125 R)
.04±.01 R
ALL AROUND
3 PLACES
(.125 R)
.240±.005
.75±.005
PLACES
.062±.010 R
(-R-)
.125±.010 R
3 PLACES



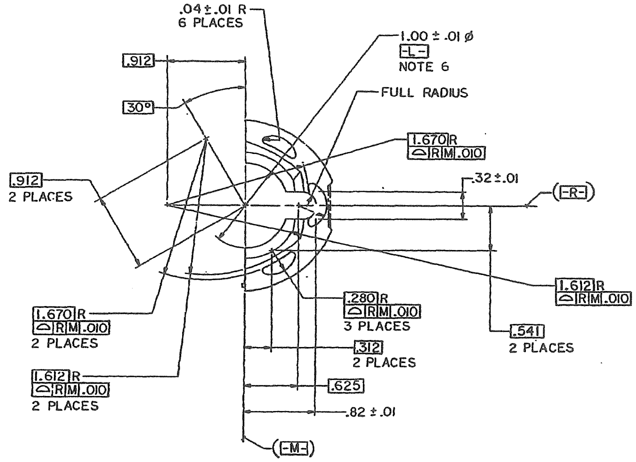
SEE DETAIL E
FOR GROOVE DIMENSIONS
.50±.01
-T-
(.165)
(.14)
(-R-)
.41±.01
⊕ T Ⓢ .020 Ⓢ

DETAIL F
ROTATED 90° CCW
SCALE: 10/1



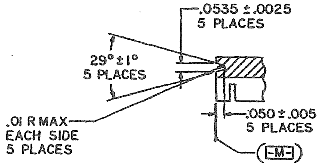
.86±.01
.035±.005
6 PLACES
.085±.005
6 PLACES
℄ GROOVE
(.165)
1.772±.010
NOTE 6 APPLIES
(-R-)
SEE DETAIL F
2.042±.010
NOTE 6
APPLIES
.162
2 PLACES
1.20±.01 R
2 PLACES
1.09±.01 R
⊕ M R Ø .040 Ⓜ
2 PLACES
1.911±.010
⊕ R .020 Ⓢ
℄ TONGUE
.067
(-M-)

SECTION C–C
NOTE 6



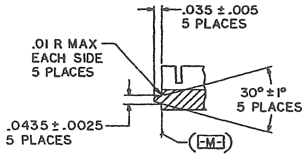
.04±.01 R
6 PLACES
1.00±.01 Ø
-L-
NOTE 6
.912
30°
FULL RADIUS
1.670 R
⌓ R M .010
.32±.01
(-R-)
.912
2 PLACES
1.612 R
⌓ R M .010
.280 R
⌓ R M .010
3 PLACES
1.670 R
⌓ R M .010
2 PLACES
.541
2 PLACES
.312
2 PLACES
1.612 R
⌓ R M .010
2 PLACES
.625
.82±.01
(-M-)

VIEW N–N



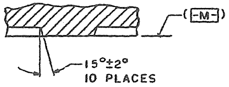
.0535±.0025
5 PLACES
29°±1°
5 PLACES
.01 R MAX
EACH SIDE
5 PLACES
.050±.005
5 PLACES
(-M-)

SECTION G–G
SCALE: 4/1



.035±.005
5 PLACES
.01 R MAX
EACH SIDE
5 PLACES
30°±1°
5 PLACES
.0435±.0025
5 PLACES
(-M-)

SECTION H–H
SCALE: 4/1



(-M-)
15°±2°
10 PLACES

SECTION K–K
SCALE: 4/1

PART NO. 9349060

		MECHANICAL PROPERTIES	
		YP	
		TS	
		EL2	
	M16	RA	
	M16A1	BH	
9349059	M16A2		
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN EJZ	CHECKER JWH
ENGR	ENGR
ENGR	ENGR

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

HANDGUARD

SIZE	FSCM NO.	
J	19200	9349060
SCALE 2/1	UNIT WT	SHEET 1 OF 1

3-FD

DWG NO.	SH	REV	FRAME
9349060	1	L	3 OF 3

October 14, 2004 12:29 AM

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NOTES: –

1 — SPEC MIL-W-13855 AND ANSI Y14.5 – 73 APPLY.

2 — MATERIAL: — ALUM ALLOY SAE TYPE 3003-H14 PER QQ-A-250/2 STK THICKNESS .0200±.0015.

3 — MIN THICKNESS AFTER FORMING .015.

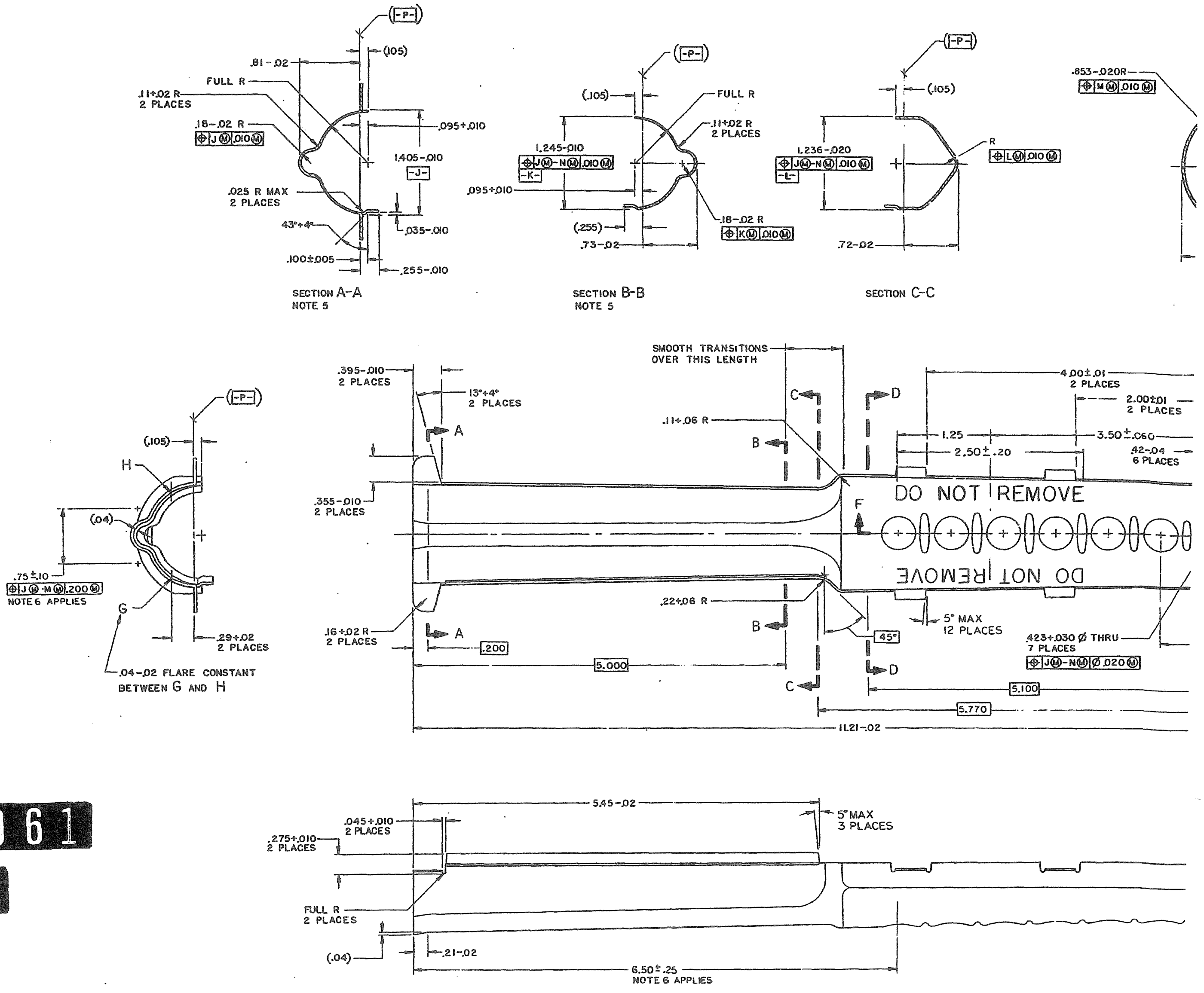
4 — BREAK SHARP EDGES .005+.010.

5 — CONTOUR OF PART BETWEEN SECTIONS A-A AND B-B IS ESTABLISHED BY DIMENSIONS DEPICTED IN THESE SECTIONS. CONTOUR OF PART BETWEEN SECTIONS D-D AND E-E IS ESTABLISHED BY DIMENSIONS DEPICTED IN THESE SECTIONS. THE PART MAY VARY FROM THIS CONTOUR IN ITS FREE STATE BUT MUST ASSUME THE DEFINED CONTOUR WHEN CONSTRAINED TO -J-, -K-, -M- AND -N- AT SECTIONS A-A, B-B, D-D AND E-E RESPECTIVLY.

6 — COAT INDICATED AREA CONVEX SIDE ONLY WITH EVERLUBE 626 OR 626S CURED AT 300°±25°F FOR 20 MINUTES, OR MOLYKOTE 3402 BONDED LUBRICANT AIR DRIED FOR 30 MINUTES MIN. AND CURED AT 325°±25°F FOR 20 MINUTES. COLOR TO BE APPROXIMATELY BLACK NO. 36076 AND NOT LIGHTER THAN GRAY NO. 36118 OF FED-STD-595. (.75) DIM. MAY BE MEASURED ALONG PART CONTOUR.

7 — FINISH 125√ ALL SURFACES EXCEPT AS NOTED.

8 — STAMP "DO NOT REMOVE" IN PLAIN LETTERS .25 IN HIGH, .005+.020 DEEP, NEGATIVE RECESS AS VIEWED IN HANDGUARD ASSEMBLY OPEN SIDE UP. (2 PLACES)


-P-
(.105)
.81-.02
FULL R
.11+.02 R
2 PLACES
.18-.02 R
⊕ J Ⓜ .010 Ⓜ
.095+.010
1.405-.010
-J-
.025 R MAX
2 PLACES
43°+4°
.035-.010
.100±.005
.255-.010
SECTION A-A
NOTE 5
(.105)
FULL R
.11+.02 R
2 PLACES
1.245-.010
⊕ J Ⓜ-N Ⓜ .010 Ⓜ
-K-
.095+.010
.18-.02 R
⊕ K Ⓜ .010 Ⓜ
(.255)
.73-.02
SECTION B-B
NOTE 5
(.105)
1.236-.020
⊕ J Ⓜ-N Ⓜ .010 Ⓜ
-L-
R
⊕ L Ⓜ .010 Ⓜ
.72-.02
SECTION C-C
.853-.020R
⊕ M Ⓜ .010 Ⓜ
(.105)
H
(.04)
.75±.10
⊕ J Ⓜ-M Ⓜ .200 Ⓜ
NOTE 6 APPLIES
G
.29+.02
2 PLACES
.04-.02 FLARE CONSTANT
BETWEEN G AND H
SMOOTH TRANSITIONS
OVER THIS LENGTH
.395-.010
2 PLACES
13°+4°
2 PLACES
A
.11+.06 R
C
D
B
4.00±.01
2 PLACES
2.00±.01
2 PLACES
1.25
2.50±.20
3.50±.060
.42-.04
6 PLACES
.355-.010
2 PLACES
F
DO NOT REMOVE
DO NOT REMOVE
.22+.06 R
5° MAX
12 PLACES
.16+.02 R
2 PLACES
.200
45°
.423+.030 Ø THRU
7 PLACES
⊕ J Ⓜ-N Ⓜ Ø .020 Ⓜ
5.000
5.100
5.770
11.21-.02
5.45-.02
.045+.010
2 PLACES
.275+.010
2 PLACES
5° MAX
3 PLACES
FULL R
2 PLACES
(.04)
.21-.02
6.50±.25
NOTE 6 APPLIES

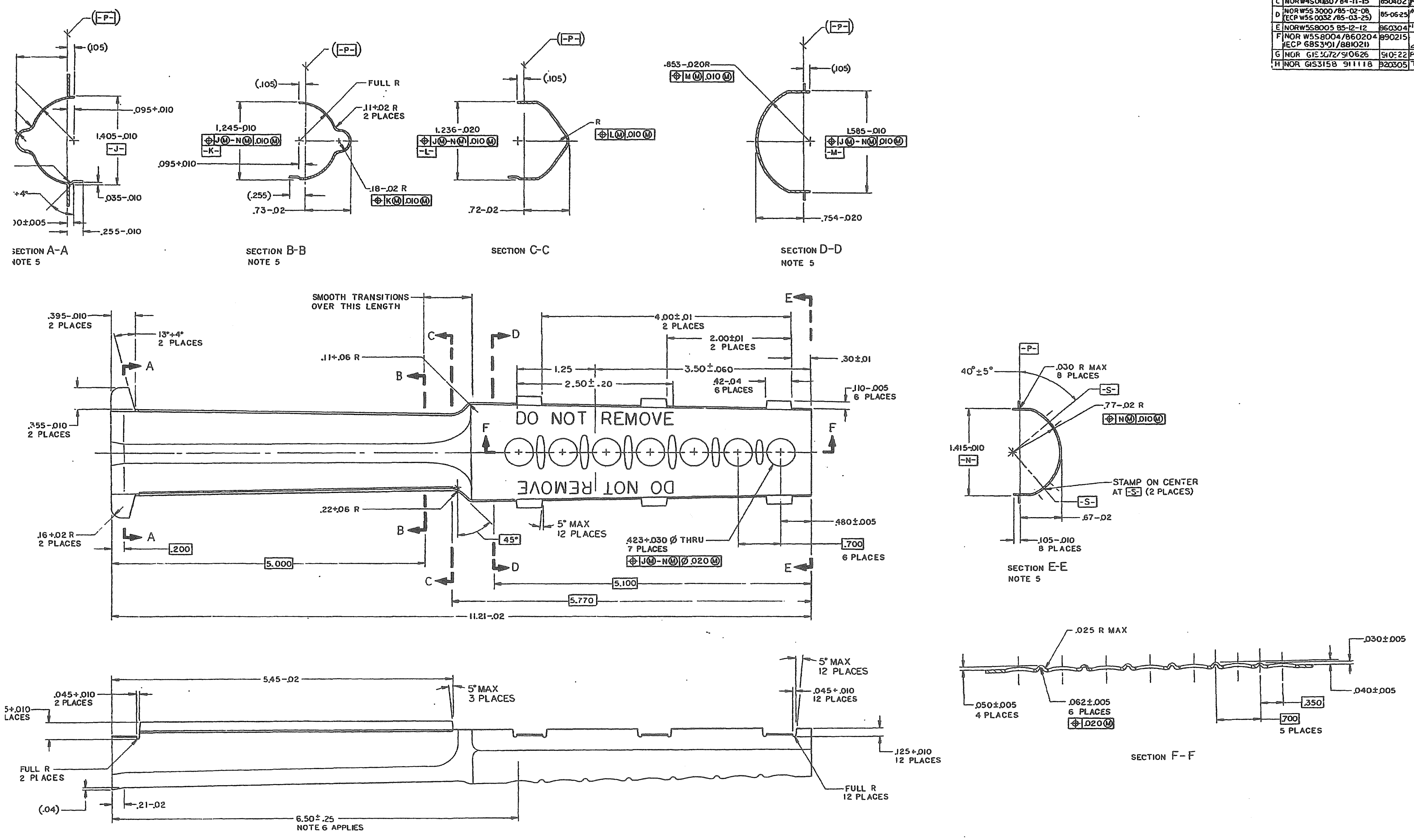
J9349061

REV H

F-1/2

DWG NO	SH	REV
9349061		H

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S3116/83-06-21 (ECP W3S3128/83-07-21) (ECP W4S3007/84 05 09)	840608	R M
B	NOR W2S3258/82-12-30	84-09-04	
C	NORW4S00080/84-11-15	850402	
D	NORW5S3000/85-02-08 (ECP W5S0032/85-03-25)	85-06-25	
E	NORW5S8005 85-12-12	860304	
F	NOR W5S8004/860204 (ECP 6BS3401/881021)	890215	
G	NOR GIS3072/910626	910-22	PF
H	NOR GIS3158 911118	920305	


(-P-)
(105)
.095+.010
1.405-.010
-J-
+4°
.035-.010
.00±.005
.255-.010
SECTION A-A
NOTE 5
(.105)
FULL R
.11+.02 R
2 PLACES
1.245-.010
⊕ J Ⓜ-N Ⓜ .010 Ⓜ
-K-
.095+.010
(.255)
.73-.02
.18-.02 R
⊕ K Ⓜ .010 Ⓜ
SECTION B-B
NOTE 5
(.105)
1.236-.020
⊕ J Ⓜ-N Ⓜ .010 Ⓜ
-L-
R
⊕ L Ⓜ .010 Ⓜ
.72-.02
SECTION C-C
.853-.020R
⊕ M Ⓜ .010 Ⓜ
(105)
1.585-.010
⊕ J Ⓜ-N Ⓜ .010 Ⓜ
-M-
.754-.020
SECTION D-D
NOTE 5
.395-.010
2 PLACES
13°+4°
2 PLACES
SMOOTH TRANSITIONS
OVER THIS LENGTH
.11+.06 R
4.00±.01
2 PLACES
2.00±.01
2 PLACES
1.25
3.50±.060
2.50±.20
.42-.04
6 PLACES
.30±.01
.110-.005
6 PLACES
.355-.010
2 PLACES
DO NOT REMOVE
DO NOT REMOVE
.22+.06 R
.16+.02 R
2 PLACES
45°
5° MAX
12 PLACES
.423+.030 Ø THRU
7 PLACES
⊕ J Ⓜ-N Ⓜ Ø .020 Ⓜ
.480±.005
.700
6 PLACES
.200
5.000
5.100
5.770
11.21-.02
A
B
C
D
E
F
40°±5°
-P-
.030 R MAX
8 PLACES
-S-
.77-.02 R
⊕ N Ⓜ .010 Ⓜ
1.415-.010
-N-
STAMP ON CENTER
AT -S- (2 PLACES)
.67-.02
.105-.010
8 PLACES
SECTION E-E
NOTE 5
.025 R MAX
.030±.005
.040±.005
.050±.005
4 PLACES
.062±.005
6 PLACES
⊕ .020 Ⓜ
.350
.700
5 PLACES
SECTION F-F
5.45-.02
.045+.010
2 PLACES
5+.010
LACES
5° MAX
3 PLACES
5° MAX
12 PLACES
.045+.010
12 PLACES
.125+.010
12 PLACES
FULL R
2 PLACES
FULL R
12 PLACES
(.04)
.21-.02
6.50±.25
NOTE 6 APPLIES

F-2/2

PART NO. 9349061

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER NEW JERSEY 07801		
		YP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	82-02-26		LINER , HANDGUARD		
		TS		TOLERANCES ON DECIMALS ±	DRAFTSMAN EJZ	CHECKER JWH			
		EL2		FRACTIONS ± ANGLES ±	ENGR	ENGR			
	M16	RA			ENGR	ENGR			
	M16A1	BH					SIZE J	FSCM NO 19200	9349061
9349059	M16A2	RH					SCALE 2/1	UNIT WT	SHEET 1 OF 1
NEXT ASSY	USED ON								
APPLICATION									

2-FR

9349061

SH	REV
	H

October 14, 2004 12:29 AM

DRAWING SIZE D
(ARRADC R 70-12)

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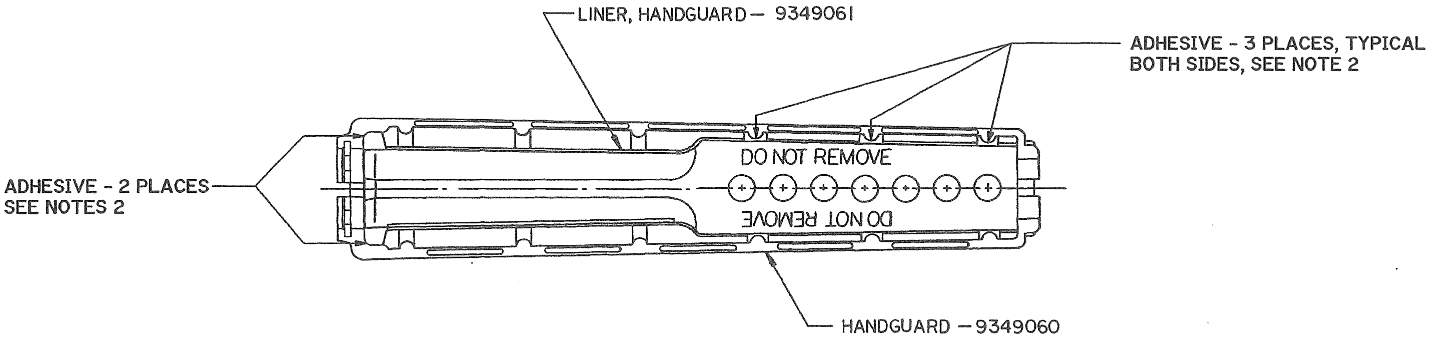
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S0030/84-11-15	850402	
B	NORW5S8005 85-12-12	860304	
C	NOR W5S8004/860204	890215	
D	NOR G5S2044 960206	960311	RLV

NOTES: —

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 - APPLY UNIFORM COATING OF ADHESIVE P/N 12012054 TO SLOTS BETWEEN HANDGUARD - 9349060 AND LINER, HANDGUARD - 9349061, 8 PLACES TOTAL.


LINER, HANDGUARD — 9349061
ADHESIVE - 3 PLACES, TYPICAL BOTH SIDES, SEE NOTE 2
ADHESIVE - 2 PLACES SEE NOTES 2
DO NOT REMOVE
DO NOT REMOVE
HANDGUARD — 9349060

FOR ENGINEERING PARTS LIST SEE PL 9349059

PART NO. 9349059

NEXT ASSY	USED ON
12012000	M16A3
8448601	M16
8448522	M16A1
9349050	M16A2

APPLICATION

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN DHB
CHECKER JWH
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HANDGUARD ASSEMBLY

SIZE D
FSCM NO 19200
9349059
SCALE 1/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 66 AUG 77 REPLACES DARPA FORM 1941 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

DRAWING SIZE D
(ARRADCOMR 70-12)

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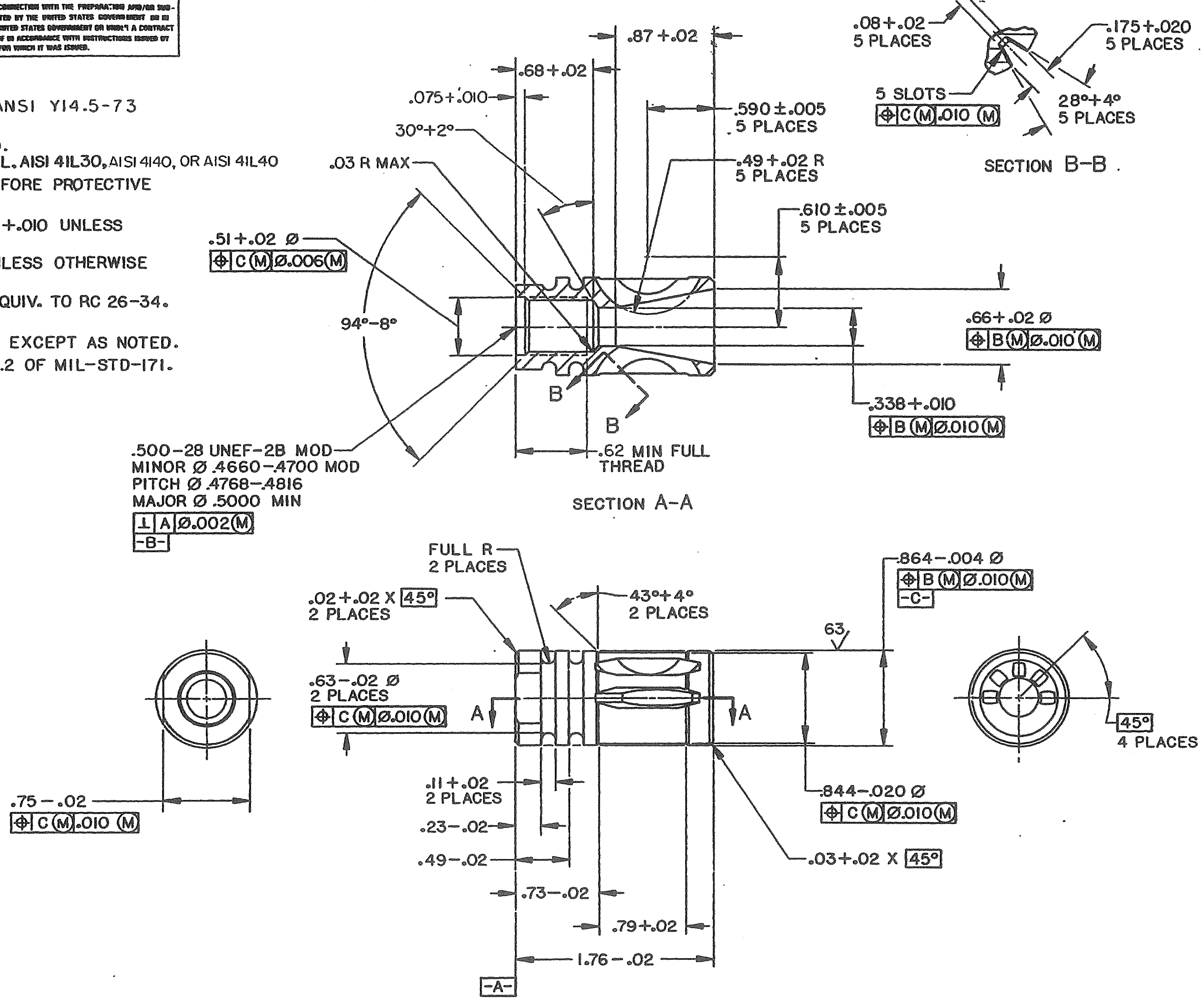
NOTES:-

1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2—MATERIAL:-STEEL. AISI 4130.
ALTERNATE MATERIAL:-STEEL. AISI 41L30, AISI 4140, OR AISI 41L40
3—ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH.
4—BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE NOTED.
5—FILLET RADII .015—.012 UNLESS OTHERWISE NOTED.
6—HEAT TREAT:—HARDNESS EQUIV. TO RC 26-34.
7—FINISH $\overset{125}{\surd}$ ALL SURFACES EXCEPT AS NOTED.
8—PROTECTIVE FINISH:—5.3.1.2 OF MIL-STD-171.

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW4S0030/84-11-15	850402	
B	NORW6S3021/86-05-07	870218	
C	NOR G1S2018 91-07-08	91-10-11	RP SR
D	NOR G2S3057/920716	921030	SR RP
E	NOR G4S3001 940204	940518	RC EL



8
7
6
5
4
3
2
1
D
C
B
A
.87+.02
.68+.02
.075+.010
30°+2°
.03 R MAX
.590±.005
5 PLACES
.49+.02 R
5 PLACES
.610±.005
5 PLACES
.51+.02 Ø
⌖ C Ⓜ Ø.006 Ⓜ
94°-8°
.66+.02 Ø
⌖ B Ⓜ Ø.010 Ⓜ
.338+.010
⌖ B Ⓜ Ø.010 Ⓜ
B
B
.62 MIN FULL THREAD
.500-28 UNEF-2B MOD
MINOR Ø .4660-.4700 MOD
PITCH Ø .4768-.4816
MAJOR Ø .5000 MIN
⊥ A Ø.002 Ⓜ
-B-
SECTION A-A
.08+.02
5 PLACES
.175+.020
5 PLACES
5 SLOTS
⌖ C Ⓜ .010 Ⓜ
28°+4°
5 PLACES
SECTION B-B
FULL R
2 PLACES
.02+.02 X 45°
2 PLACES
43°+4°
2 PLACES
63
.864-.004 Ø
⌖ B Ⓜ Ø.010 Ⓜ
-C-
.63-.02 Ø
2 PLACES
⌖ C Ⓜ Ø.010 Ⓜ
A
A
45°
4 PLACES
.75-.02
⌖ C Ⓜ .010 Ⓜ
.11+.02
2 PLACES
.23-.02
.49-.02
.844-.020 Ø
⌖ C Ⓜ Ø.010 Ⓜ
.03+.02 X 45°
.73-.02
.79+.02
1.76-.02
-A-

PART NO.9349051

NEXT ASSY	USED ON
8448522	M16A1
8448601	M16
9327227	M231 FPW
9390001	M4
9349050	M16A2E3 M16A2

APPLICATION

MECHANICAL PROPERTIES
YP
TS
EL2
RA
BH
RH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING
82-06-09
DRAFTSMAN SMI
CHECKER DEW
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

COMPENSATOR

SIZE D
FSCM NO 19200
9349051
SCALE 2/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES DARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

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G	NOR G2S3059/920716 (ECP G2S3060/920630)	920811	AJL SR

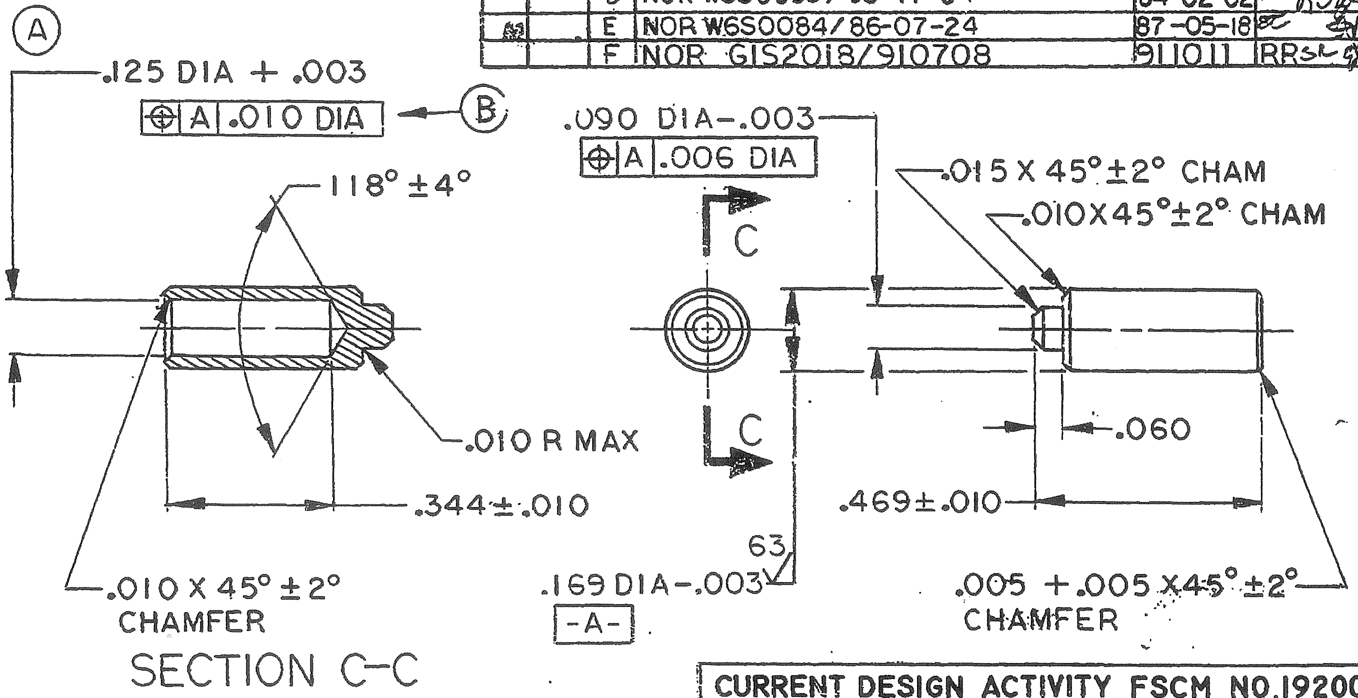
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61705 REVISION C	27APR 70	
		A	(1) SEE EO HRD 02197-3	15 JUL 70	
M		B	(4) SEE ERR HQR 20827	14 DEC 72	R.E.
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W3S0059/83-11-04	84-02-02	HW R.
		E	NOR W6S0084/86-07-24	87-05-18	
		F	NOR G1S2018/910708	911011	RR SR

B8448573

NOTES:

1. FINISH $\sqrt{}^{125}$ EXCEPT AS NOTED.
2. FINISH 5.3.1.2 OF MIL-STD-171.
3. BREAK SHARP EDGES .005+.010.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓑ
5. MIL-W-13855 APPLIES. Ⓑ



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Ⓑ

CURRENT DESIGN ACTIVITY FSCM NO.19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		9390001	M4
EL 2		F8448601	M16
RA		F8448522	M16A1
BH		NEXT ASSY	USED ON
RH	15N 72.5-76	APPLICATION	

Ⓑ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± ——

MATERIAL
WIRE, CMPSN 4130, ASTM A322 OR A331

FINAL PROTECTIVE FINISH
SEE NOTE 2

CONTRACT NO.		
DATE 27 APR 1970		
PREP		A. J. St
CHK		H. Gadham
ENGR		D. Billiet
SUBMITTED	T. P. Gallaohy	
APPROVED	R. S. Henry	

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

DETENT, FRONT SIGHT

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448573
SCALE 4/1		SHEET 1 OF 1

CDI

AMSWE Form 403B 29 Jul 69

ober 14, 2004 12:41 AM

DRAWING SIZE D
(ARRADCOMR 70-12)

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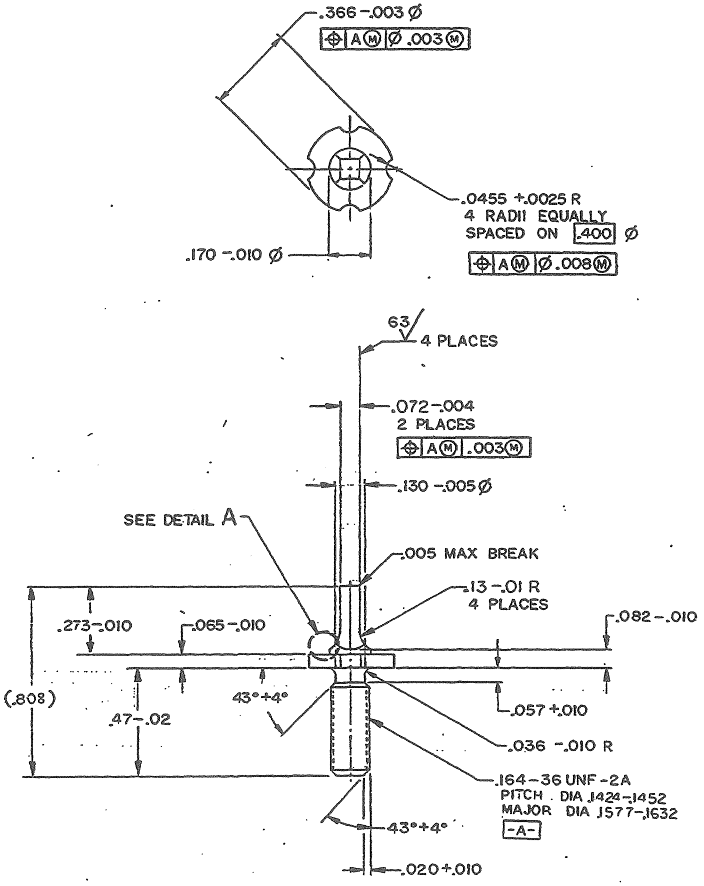
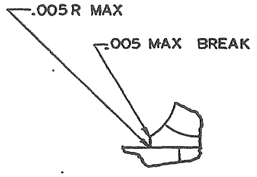
NOTES: –

1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL:- STEEL. COLD DRAWN BAR CMPSN 1117 THRU 1144. SPEC ASTM-A108. ALTERNATE MATERIAL: STEEL AISI 11L17.
3- ALL DIMENSIONS ARE BEFORE PROTECTIVE FINISH.
4- BREAK SHARP EDGES .005±.010 EXCEPT AS NOTED.
5- FILLET RADII .015-.012
6- FINISH 125√ ALL OVER
7- PROTECTIVE FINISH:- 5.3.1.2 OF MIL-STD-171.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERR.W2S2013	820514	
A	NOR W4S2016 / 84-05-13	84-06-07	RMH
B	NOR W2S3258/82-12-30	840904	RMH
C	NOR W4S3014/84-06-01 (ECPW4S3024/84-07-24)	841004	RMH
D	NOR W4S0030 / 84-11-15	850402	
E	NOR W5S8004/860204	890215	
F	NOR G0S3088/ 89-06-15	900823	
G	NOR G1S2018 9107 08	91-10-11	


.366 -.003 Ø
⌖ A Ⓜ Ø .003 Ⓜ
.0455 ±.0025 R
4 RADII EQUALLY
SPACED ON .400 Ø
⌖ A Ⓜ Ø .008 Ⓜ
.170 -.010 Ø
63√ 4 PLACES
.072 -.004
2 PLACES
⌖ A Ⓜ .003 Ⓜ
.130 -.005 Ø
SEE DETAIL A
.005 MAX BREAK
.13 -.01 R
4 PLACES
.273 -.010
.065 -.010
.082 -.010
(.808)
43° ±4°
.47 -.02
.057 ±.010
.036 -.010 R
.164-36 UNF-2A
PITCH DIA .1424-.1452
MAJOR DIA .1577-.1632
-A-
43° ±4°
.020 ±.010


.005 R MAX
.005 MAX BREAK

DETAIL A
SCALE 10/1

PART NO. 9349056

		MECHANICAL PROPERTIES	
		YP	
9390001	M4	TS	
8448601	M16	EL2	
8448522	M16A1	RA	
9349050	M16A2	BH	
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN M M
CHECKER JWH
ENGR
ENGR
ENGR
ENGR
Robert J. McHugh

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

POST, FRONT SIGHT

SIZE D
FSCM NO. 19200
9349056
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

ber 14, 2004 12:41 AM

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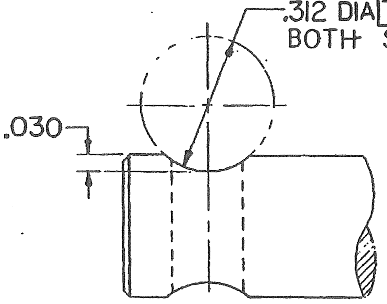
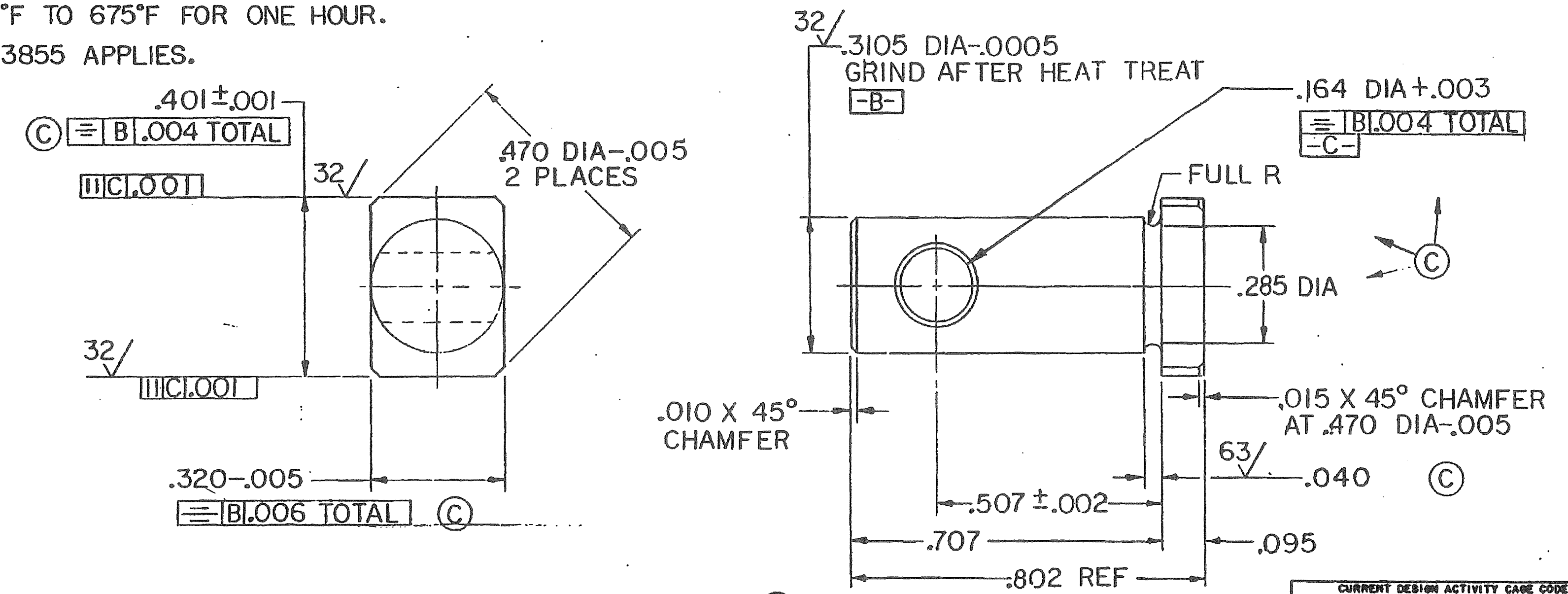
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D 61704 REV A WITH CHANGE	27 APR 70	
		A	(2) SEE EO HRD 02197-3	15 JULY 70	
		B	(2) SEE HQR 10720	11 MAY 71	YB
M		C	(6) SEE ERR HQR 20778	6 OCT 72	RG
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR G1S2018 91 07 08	91-10-11	KR SL
		F	NOR G3S3017 930323	930506	CVS SR

NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005+.005.
3. APPLY DRY FILM LUBRICANT MIL-L-46010. Ⓒ
   FILM THICKNESS .0002-.0004. CURE ONE HOUR AT 375° F. OR USE EVERLUBE 626 OR 626S, FILM THICKNESS .0002-.0004, CURE FOR 1 HOUR AT 375° F.
4. SUGGESTED HEAT TREATMENT:
   QUENCH IN OIL FROM 1500°F TO 1550°F. TEMPER AT 625°F TO 675°F FOR ONE HOUR.
5. MIL-W-13855 APPLIES.





Ⓑ

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448501	M4
BH		D9327072	M231
			M16
		D8448501	M16A1
RH	C45-48	NEXT ASSY	USED ON
		APPLICATION	

Ⓐ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 2°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±——

MATERIAL
STEEL ALLOY E4340,
SPEC MIL-S-5000

FINAL PROTECTIVE FINISH
5.3.1.3 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970
PREPARED PAR a.g.H.
CHECKED D.Billist
ENGINEER D.Billist
SUBMITTED F.P. Yellowly
APPROVED R.S. Henry

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
~~ROCK ISLAND, ILLINOIS, 61201~~

PIN, CAM

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448502

SCALE 5/1

C 8448502

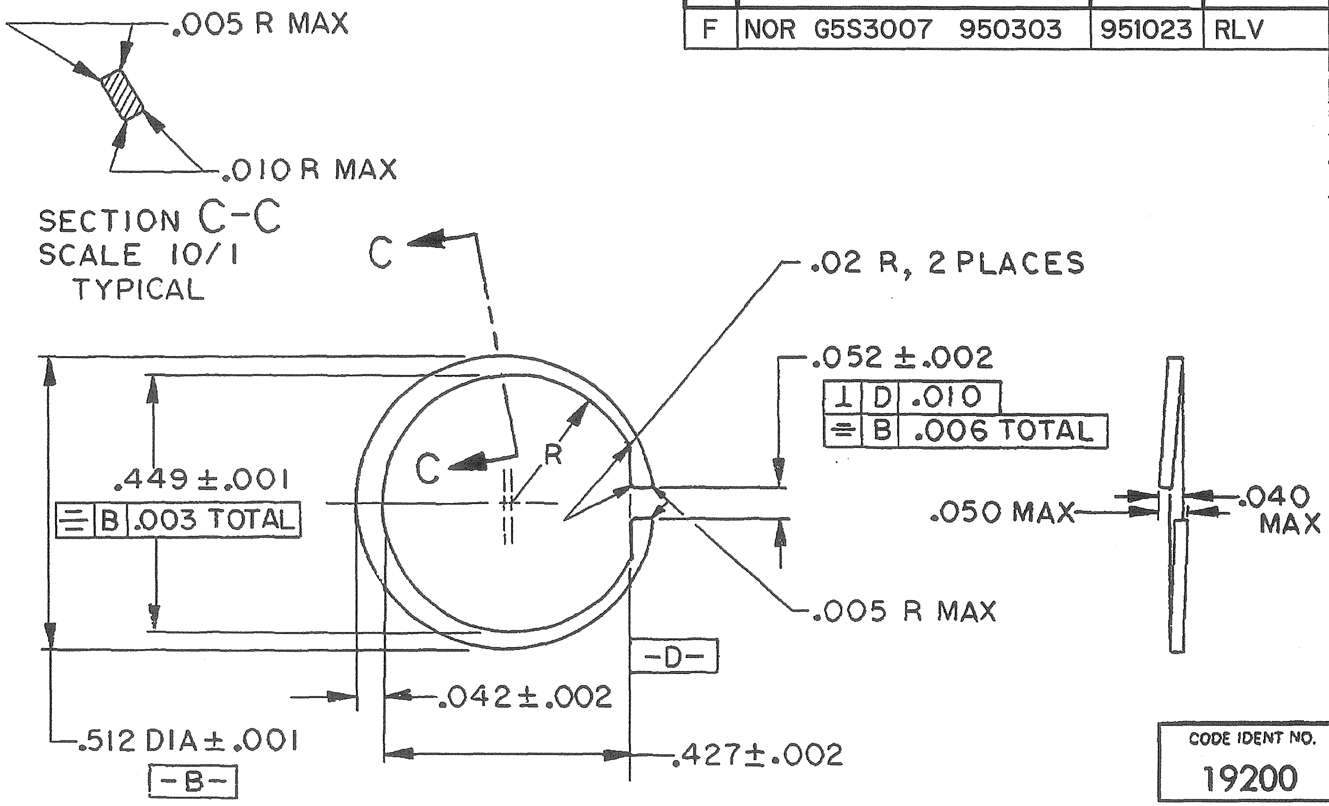
AMSWE Form 403C, 29 Jul 69

tober 18, 2004 7:12 AM

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F	NOR G5S3007 950303	951023	RLV

NOTE:

1. STEEL, CORROSION-RESISTANT, PER AMS 5906 OR 5913, THICKNESS .016±.001.
2. FINISH $\sqrt[125]{}$ EXCEPT AS NOTED IN NOTE 4.
3. EDGES TO BE SHARP TO .005 R MAX.
4. MAX DIE BREAK ON $\boxed{-B-}$ TO BE 50%. FINISH ON SHEARED SURFACE TO BE $\sqrt[63]{}$.
5. FINISH 5.4.1 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



.005 R MAX
.010 R MAX
SECTION C-C
SCALE 10/1
TYPICAL
C
C
R
.02 R, 2 PLACES
.052 ±.002
⊥ D .010
⌯ B .006 TOTAL
.449±.001
⌯ B .003 TOTAL
.050 MAX
.040 MAX
.005 R MAX
-D-
.042±.002
.512 DIA±.001
-B-
.427±.002

B8448511

CODE IDENT NO.
19200

DISTRIBUTION STATEMENT F.
FURTHER DISTRIBUTION ONLY AS
DIRECTED BY ARDEC,AMSTA-AR-CCL-A
950610

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN		8448509	M4
YS MAX		C9327073	M231
EL 2			M16
RA		C8448509	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .01
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO:
DATE 27 APR 1970
PREP P.E.H. 9.9.
CHK H.H.H. V. Ledham
ENGR Edmart D. Billert
SUBMITTED F. P. Gilleody
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RING, BOLT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448511

SCALE 5/1 SHEET 1 OF 1

CD1

AMSWE Form 403B, 29 Jul 69

tober 18, 2004 10:56 AM

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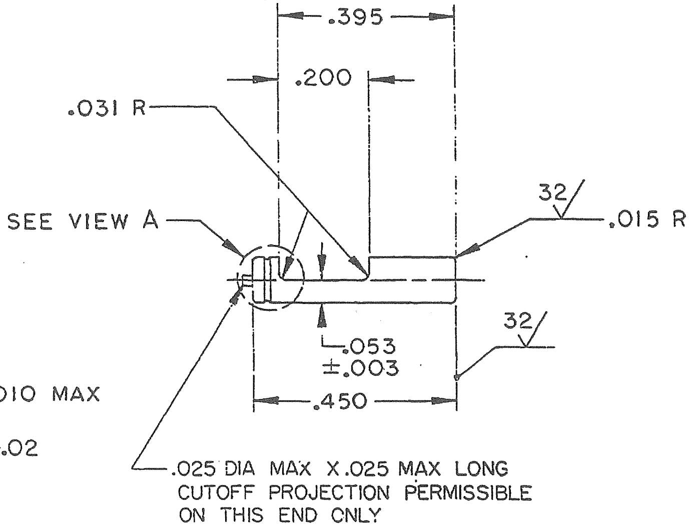
REVISIONS

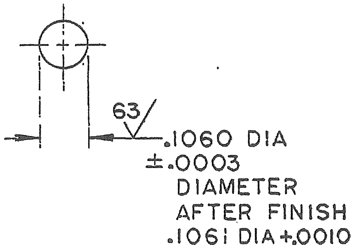
MF.	ZONE	LTR	DESCRIPTION	DATE	APPROVED
LM			REDRAWN FROM COLT'S DRAWING C61564 REVISION B	27 APR 70	
M		A	(3)SEE EO HRD 02255	15 OCT 70	F.P. Fillinoly
M		B	(2)SEE ERR HQR 20778	6 OCT 72	
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	ERR Z9Z1251W (ECP G9S2036/890721)	900403	
		E	NOR G1S2018 91-07-08	91-10-11	RB
		F	NOR G2S3025 920330	920427	

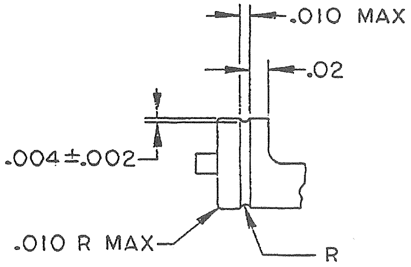
NOTE:

1. FINISH 125√ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 R MAX.
3. OIL QUENCH FROM 1600° F. TEMPER AT 275° F TO 400° F.
4. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005-.007-A2 ALMEN, 150 % COVERAGE.
5. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



.395
.200
.031 R
SEE VIEW A
32/
.015 R
.053 ±.003
32/
.450
.025 DIA MAX X .025 MAX LONG CUTOFF PROJECTION PERMISSIBLE ON THIS END ONLY





VIEW A
SCALE 10/1

C8448515

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 88.5 -90.5

NEXT ASSY	USED ON
8448509	M4
C9327073	M231
	M16
C8448509	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
TOOL STEEL, TYPE S2, ASTM-A681

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO:

DATE 27 APR 1970

PREPARED	RGA	
CHECKED		H.L.
ENGINEER	D.S.	D.B.

SUBMITTED F. P. FILLINOLY

APPROVED R.S. HENRY

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

EJECTOR

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448515

SCALE 5/1 SHEET 1 OF 1

DISTRIBUTION STATEMENT E
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL; OR HIGHER DoD AUTHORITY
ASQNC-AR; 920310.

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SCANNED DUPLICATE ORIGINAL CDI

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REVISIONS

ME	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61820 REVISION A	27APR70	
		A	(1) SEE EO HRD 02197-3	15 JUL 70	
		B	(2) SEE ERR HQR 20778	6 OCT 72	R.C.
		C	NORW2S2015 82-08-20	83-02-03	
		D	NORW2S0026 82-05-21	83-09-22	
		E	NOR G1S2018 91 07 08	91-10-11	

B84486E4

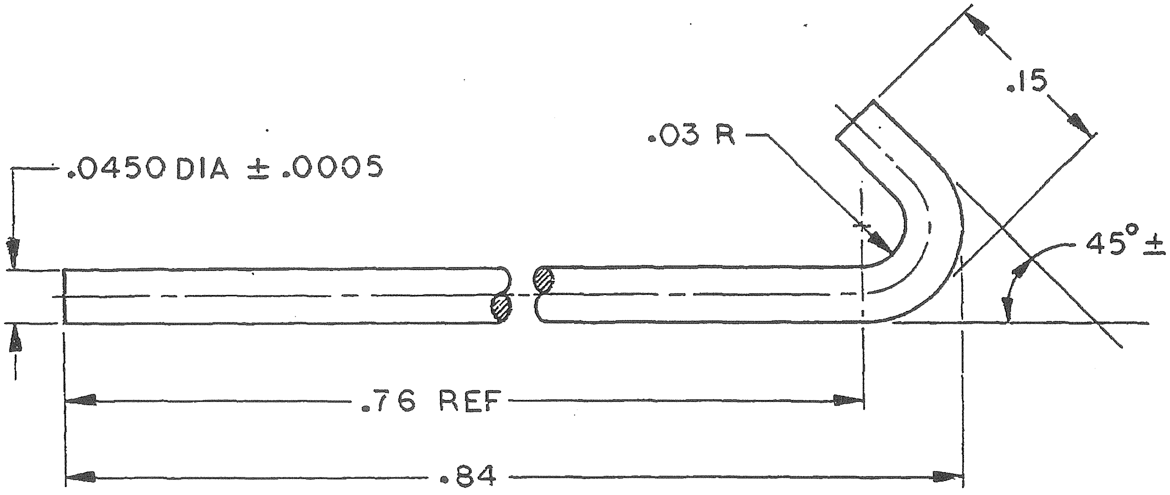
NOTES:

1 WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.

2. PRECIPITATION HEAT TREAT AFTER FORMING. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.

3. FINISH 5.4.1 OF MIL-STD-171.

4. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 84.5 MIN

APPLICATION

NEXT ASSY	USED ON
9349110	M4
	M16
C8448612	M16A1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO:
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RETAINER, HAMMER PIN

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448614

SCALE 10/1 SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

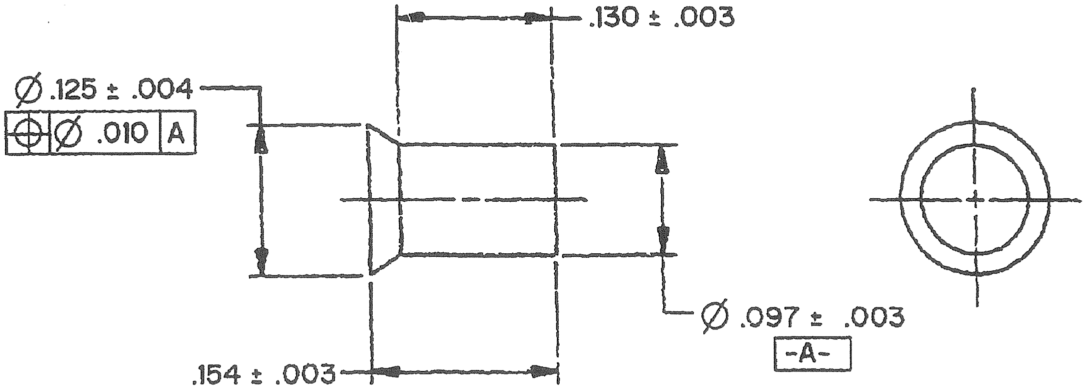
tober 18, 2004 7:13 AM

NOTES:-

1- MATERIAL: CLASS 1, BUNA-N, SHORE HARDNESS 80 ± 5 DUROMETER PER MIL-R-6855, EXCEPT LOW-TEMP. TEST PER PARA 4.6.4 OF MIL-R-6855 SHALL UTILZE MIL-L-46000 OR MIL-L-63460 LUBRICATE IN LIEU OF TEST FLUIDS TYPE I AND III PER TT-S-735. MUST ALSO MEET OZONE REQUIREMENT OF CLASS 2, TYPE A.
2- ALL CORNERS AND FILLETS TO BE .005 R MAX.
3- MIL-W-13855 APPLIES.
4- COLOR SHALL BE APPROXIMATELY WHITE, NO. 37722 TO 37925 OF FED-STD-595.

REVISIONS

ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	–	PRODUCT BASELINE ERR G5S3081 (ECP G5S3101 950915)	951211	HJS
	A	NOR G6S3117 / 960719 (ECP G6S3011 / 960227)	961204	FET
	B	NOR L8S3046/990524	990712	FET
	C	NOR L9S3041 000113	000214	RLV



DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

PART NO. 12972693

PMIC			
MECHANICAL PROPERTIES			
YP			
TS			
EL2			
RA		12972692	M4
BH		NEXT ASSY	USED ON
RH		APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ±
THIRD ANGLE PROJECTION
MATL ENGR

CONTRACT NUMBER
CONTRACTOR
DRAWN BY HJS
DATE(YR-MO-DAY) 951211
CHECKER
ENGINEER
DRAWING APPROVAL
DESIGN APPROVAL

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

BUFFER, EXTRACTOR

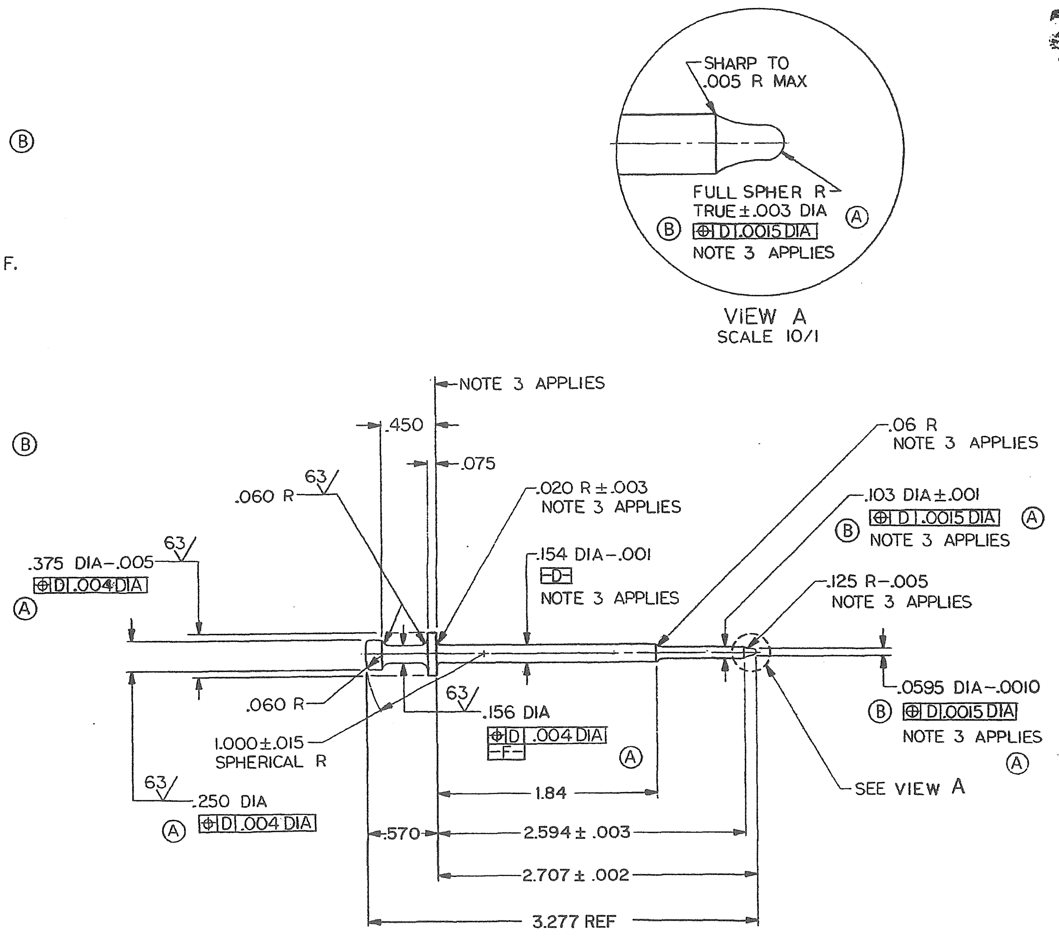
SIZE B
CAGE CODE 19200
12972693
SCALE 10/1
UNIT WT.
SHEET

SMCAR FORM 66, 1 MAR 88(TEMP) REPLACES SMCAR FORM 65, 1 JUL 87(TEMP)
WHICH MAY BE USED UNTIL EXHAUSTED

ctober 18, 2004 7:12 AM

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D62294 REVISION B	27 APR 70	
M		A	(7)SEE ERR HQR 20778	6 OCT 72	R.E.
		B	(6) SEE ERR HQR 30816	12 MAR 74	R.E.
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	ERR ~~Z9Z~~1285AU (ECP G0S3111, 90-07-06)	90-09-25	
		E	NOR G1S2018/910708	911011	RR
		F	NOR G3S3029 930413	930518	RR
		G	NOR G6S3018 / 960329	960717	FET

NOTE:
1. STEEL, AISI 8640 OR AISI 8740. MATERIAL SHALL BE ANNEALED TO A BRINNEL RANGE OF 187 TO 229. MEAN BRINNEL RANGE 210. Ⓑ
2. SUGGESTED HEAT TREAT PROCEDURE FOR AISI 8640 AND AISI 8740.
   HEAT IN NEUTRAL SALT BATH AT 1525°F ± 10°F. QUENCH IN SALT BATH AT 585°F ± 5°F HOLD AT HEAT 18 TO 20 MINUTES. AIR COOL.
3. SURFACES INDICATED MAY BE GROUND AFTER HEAT TREAT. FINISH REQUIRED ON INDICATED SURFACE IS 32√.
4. FINISH 1.2.2.4 OF MIL-STD-171. FILM THICKNESS .0002 / .0003. CLAMP ELECTRODES ON DIA -F-. UNPLATED CONTACT AREA NOT TO EXCEED .06 DIA. Ⓑ
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010.
7. MIL-W-13855 APPLIES. Ⓐ



SHARP TO .005 R MAX
FULL SPHER R TRUE ± .003 DIA Ⓐ
Ⓑ ⊕ D .0015 DIA
NOTE 3 APPLIES
VIEW A
SCALE 10/1
NOTE 3 APPLIES
.450
.075
63√
.060 R
.020 R ± .003
NOTE 3 APPLIES
.06 R
NOTE 3 APPLIES
.103 DIA ± .001
⊕ D .0015 DIA Ⓐ
Ⓑ NOTE 3 APPLIES
63√
.375 DIA -.005
⊕ D .004 DIA
Ⓐ
.154 DIA -.001
-D-
NOTE 3 APPLIES
.125 R -.005
NOTE 3 APPLIES
.0595 DIA -.0010
Ⓑ ⊕ D .0015 DIA
NOTE 3 APPLIES
Ⓐ
.060 R
63√
.156 DIA
⊕ D .004 DIA
-F-
Ⓐ
1.000 ± .015
SPHERICAL R
SEE VIEW A
63√
.250 DIA
Ⓐ ⊕ D .004 DIA
1.84
.570
2.594 ± .003
2.707 ± .002
3.277 REF

D8448503

CURRENT DESIGN ACTIVITY CAGE CODE 19200
ARMAMENT RESEARCH, DEVELOPNEMT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448501	M4
		D9327072	~~M231~~
BH			M16
		D8448501	M16A1, M16A2
RH	C45-49	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO:
DATE 27 APR 1970
PREPARED TC a.J. St.
CHECKED
ENGINEER
SUBMITTED H.P. Willhooly
APPROVED R.S. Kenny

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, FIRING

SIZE D
CODE IDENT NO. 19204
DRAWING NO. 8448503
SCALE 2/1
SHEET 1 OF 1

tober 18, 2004 7:12 AM

AMSWE Form 403D, 29 Jul 69

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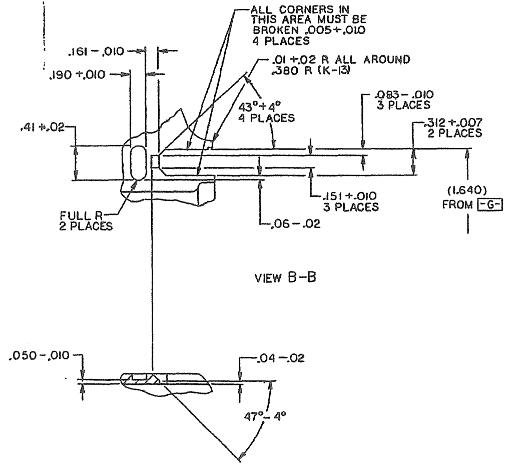
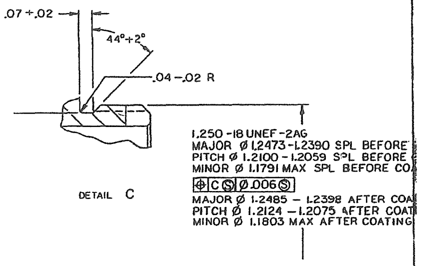
NOTES:-

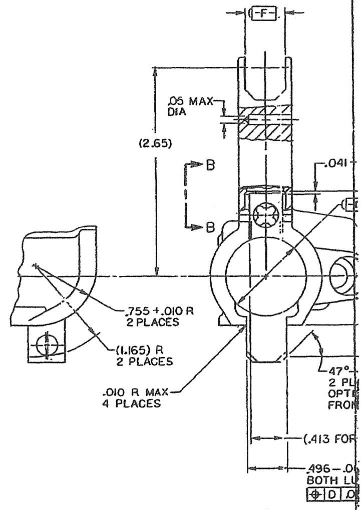
1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL:-MAKE FROM FORGING, UPPER RECEIVER-12576279.
3- CENTER LINE [-D-] (H-7) AND [-J-] (E-7) ARE ESTABLISHED WHEN LOCATING ON Ø [-C-], AND SLOT [-F-] AT AREA [-T-] (G-12).
4- WITNESS MARK (K-11) TO DETERMINE STARTING POINT FOR MACHINING.
5- ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
6- BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE NOTED.
7- FILLET RADII .015-.012 UNLESS OTHERWISE NOTED.
8- EVERLUBE 626 OR 626S CURED AT 275° F ± 25° F FOR 1 HOUR OR MIL-L-46010 CURED 300°F TO 325°F FOR 2 HOURS, TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .875 TO 1.25 LENGTH (B-19). FILM THICKNESS .0002+.0001.
9- FINISH 125√ ALL MACHINED SURFACES, EXCEPT AS NOTED.
10- PROTECTIVE FINISH:-MIL-A-8625. TYPE III CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, BUT NOT LIGHTER THAN GRAY, NO. 36076, OF FED-STD-595, AND SEAL. GRIT BLAST PRIOR TO FINISH TO PROVIDE NON REFLECTIVE MATTE SURFACE AFTER FINISH.
11- LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND 1.06 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT [-F-]

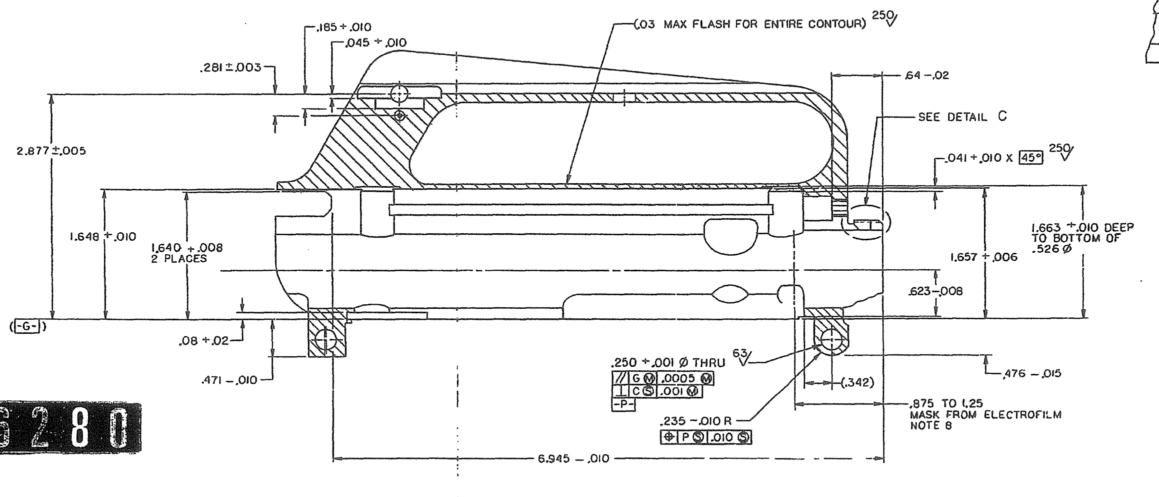

ALL CORNERS IN THIS AREA MUST BE BROKEN .005+.010 4 PLACES
.161-.010
.190+.010
.01+.02 R ALL AROUND .380 R (K-13)
43°+4° 4 PLACES
.083-.010 3 PLACES
.312+.007 2 PLACES
.41+.02
.151+.010 3 PLACES
(1.640) FROM -G-
FULL R 2 PLACES
.06-.02
.050-.010
.04-.02
47°-4°

VIEW B-B


.07+.02
44°+2°
.04-.02 R
1.250-18 UNEF-2AG
MAJOR Ø 1.2473-1.2390 SPL BEFORE
PITCH Ø 1.2100-1.2059 SPL BEFORE
MINOR Ø 1.1791 MAX SPL BEFORE CO
⊕ C Ⓢ Ø .006 Ⓢ
MAJOR Ø 1.2485 - 1.2398 AFTER COA
PITCH Ø 1.2124 - 1.2075 AFTER COAT
MINOR Ø 1.1803 MAX AFTER COATING

DETAIL C

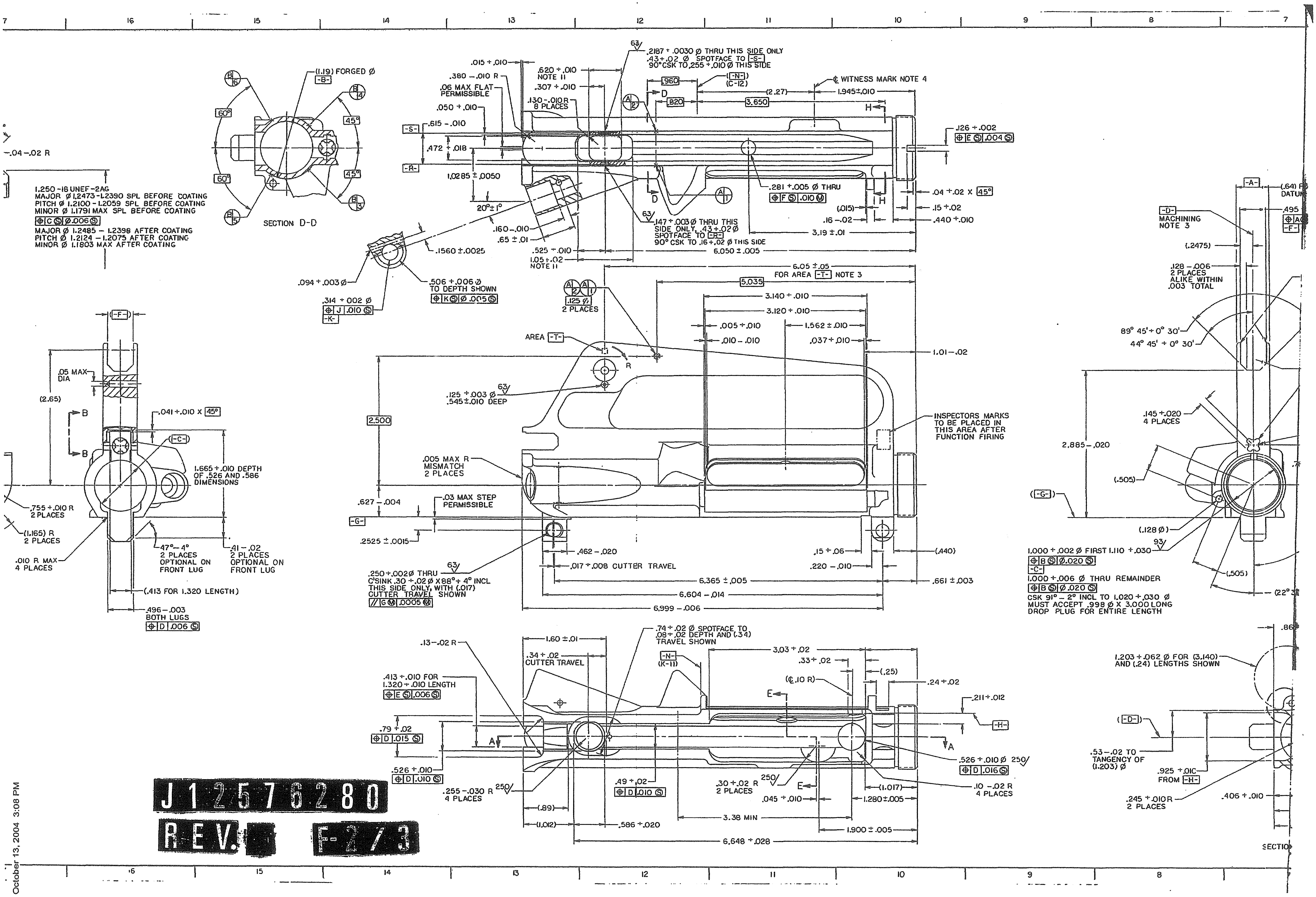

-F-
.05 MAX DIA
(2.65)
B
B
.041
.755+.010 R 2 PLACES
(1.165) R 2 PLACES
.010 R MAX 4 PLACES
47°- 2 PL OPT FRO
(.413 FOR
.496-.0 BOTH LU
⊕ D


.185+.010
.045+.010
.281±.003
(.03 MAX FLASH FOR ENTIRE CONTOUR) 250√
.64-.02
SEE DETAIL C
.041+.010 X 45° 250√
2.877±.005
1.648+.010
1.640+.008 2 PLACES
1.663+.010 DEEP TO BOTTOM OF .526 Ø
1.657+.006
.623-.008
-G-
.08+.02
.471-.010
.250+.001 Ø THRU 63√
// G Ⓜ .0005 Ⓜ
⊥ C Ⓢ .001 Ⓜ
-P-
(.342)
.476-.015
.235-.010 R
⊕ P Ⓢ .010 Ⓢ
.875 TO 1.25 MASK FROM ELECTROFILM NOTE 8
6.945-.010

SECTION A-A

J12576280
REV.
F-1/3

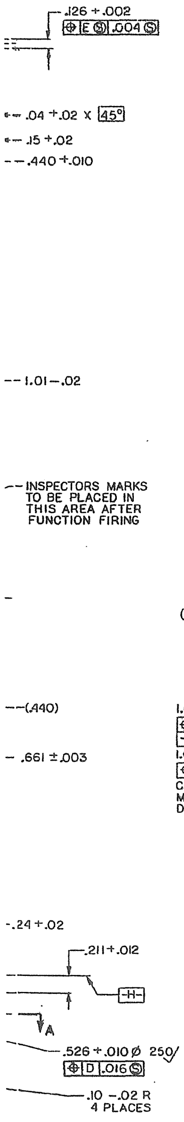
October 13, 2004 3:08 PM



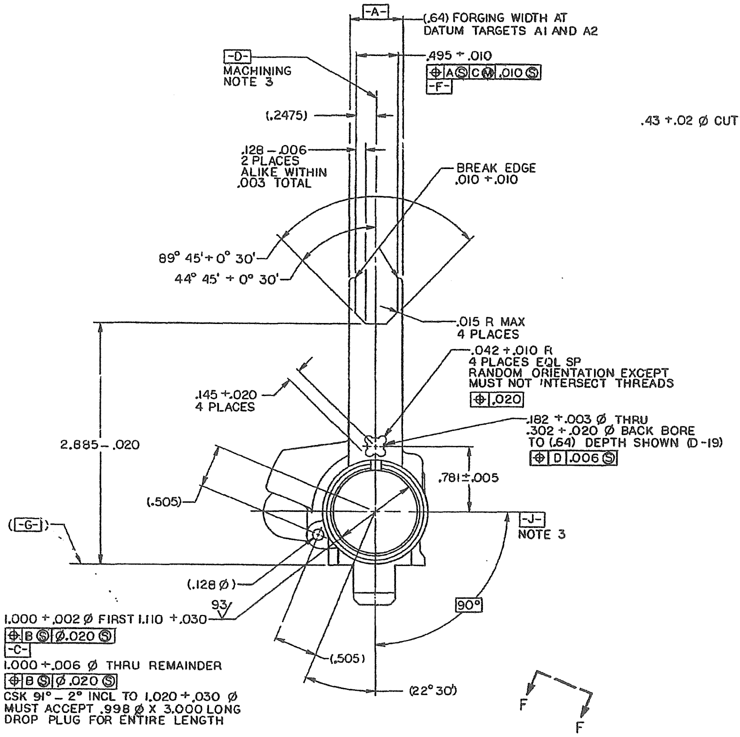
J12576280
REV.
F-2/3
SECTION D-D
(1.19) FORGED Ø
-B-
60°
45°
1.250-18 UNEF-2AG
MAJOR Ø 1.2473-1.2390 SPL BEFORE COATING
PITCH Ø 1.2100-1.2059 SPL BEFORE COATING
MINOR Ø 1.1791 MAX SPL BEFORE COATING
⊕ C Ⓢ Ø.006 Ⓢ
MAJOR Ø 1.2485 - 1.2398 AFTER COATING
PITCH Ø 1.2124 - 1.2075 AFTER COATING
MINOR Ø 1.1803 MAX AFTER COATING
-.04-.02 R
.015 + .010
.380 - .010 R
.06 MAX FLAT PERMISSIBLE
.050 + .010
-S-
.615 - .010
.472 + .018
-R-
1.0285 ± .0050
20° ± 1°
.620 + .010 NOTE 11
.307 + .010
.130 - .010 R 8 PLACES
.2187 + .0030 Ø THRU THIS SIDE ONLY
.43 + .02 Ø SPOTFACE TO -S-
90° CSK TO .255 + .010 Ø THIS SIDE
.960
.820
-N- (C-12)
(2.27)
3.650
℄ WITNESS MARK NOTE 4
1.945 ± .010
.126 + .002
⊕ E Ⓢ .004 Ⓢ
.281 + .005 Ø THRU
⊕ F Ⓢ .010 Ⓜ
.04 + .02 X 45°
.15 + .02
.440 + .010
(.015)
.16 - .02
3.19 ± .01
.147 + .003 Ø THRU THIS SIDE ONLY, .43 + .02 Ø SPOTFACE TO -R-
90° CSK TO .16 + .02 Ø THIS SIDE
6.050 ± .005
.160 - .010
.65 ± .01
.525 + .010
1.05 + .02 NOTE 11
.1560 ± .0025
.094 + .003 Ø
.506 + .006 Ø TO DEPTH SHOWN
⊕ K Ⓢ Ø .005 Ⓢ
.314 + .002 Ø
⊕ J .010 Ⓢ
-K-
.125 Ø 2 PLACES
6.05 ± .05 FOR AREA -T- NOTE 3
5.035
3.140 + .010
3.120 + .010
.005 + .010
1.562 ± .010
.010 - .010
.037 + .010
1.01 - .02
AREA -T-
.125 + .003 Ø
.545 ± .010 DEEP
2.500
INSPECTORS MARKS TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
.005 MAX R MISMATCH 2 PLACES
.627 - .004
.03 MAX STEP PERMISSIBLE
-G-
.2525 ± .0015
.462 - .020
.017 + .008 CUTTER TRAVEL
.15 + .06
.220 - .010
(.440)
.250 + .002 Ø THRU
C'SINK .30 + .02 Ø X 88° + 4° INCL
THIS SIDE ONLY, WITH (.017) CUTTER TRAVEL SHOWN
// G Ⓜ .0005 Ⓜ
6.365 ± .005
.661 ± .003
6.604 - .014
6.999 - .006
-F-
.05 MAX DIA
(2.65)
.041 + .010 X 45°
-C-
1.665 + .010 DEPTH OF .526 AND .586 DIMENSIONS
.755 + .010 R 2 PLACES
(1.165) R 2 PLACES
.010 R MAX 4 PLACES
47° - 4° 2 PLACES OPTIONAL ON FRONT LUG
.41 - .02 2 PLACES OPTIONAL ON FRONT LUG
(.413 FOR 1.320 LENGTH)
.496 - .003 BOTH LUGS
⊕ D .006 Ⓢ
.13 - .02 R
1.60 ± .01
.34 + .02 CUTTER TRAVEL
.74 + .02 Ø SPOTFACE TO .08 + .02 DEPTH AND (.34) TRAVEL SHOWN
-N- (K-11)
3.03 + .02
.33 + .02
(.25)
(℄ .10 R)
.24 + .02
.211 + .012
-H-
.413 + .010 FOR 1.320 + .010 LENGTH
⊕ E Ⓢ .006 Ⓢ
.79 + .02
⊕ D .015 Ⓢ
.526 + .010
⊕ D .010 Ⓢ
.255 - .030 R 4 PLACES
.49 + .02
⊕ D .010 Ⓢ
.30 + .02 R 2 PLACES
.045 + .010
.526 + .010 Ø
⊕ D .016 Ⓢ
.10 - .02 R 4 PLACES
(1.017)
1.280 ± .005
(.89)
(1.012)
.586 + .020
3.38 MIN
1.900 ± .005
6.648 + .028
-A-
(.64)
.495
-D- MACHINING NOTE 3
(.2475)
.128 - .006 2 PLACES ALIKE WITHIN .003 TOTAL
89° 45' + 0° 30'
44° 45' + 0° 30'
.145 + .020 4 PLACES
2.885 - .020
(.505)
(-G-)
(.128 Ø)
1.000 + .002 Ø FIRST 1.110 + .030
⊕ B Ⓢ Ø .020 Ⓢ
-C-
1.000 + .006 Ø THRU REMAINDER
⊕ B Ⓢ Ø .020 Ⓢ
CSK 91° - 2° INCL TO 1.020 + .030 Ø
MUST ACCEPT .998 Ø X 3.000 LONG DROP PLUG FOR ENTIRE LENGTH
(.505)
(22°
.86
1.203 + .062 Ø FOR (3.140) AND (.24) LENGTHS SHOWN
(-D-)
.53 - .02 TO TANGENCY OF (1.203) Ø
.925 + .010 FROM -H-
.245 + .010 R 2 PLACES
.406 + .010
SECTIO

October 13, 2004 3:08 PM

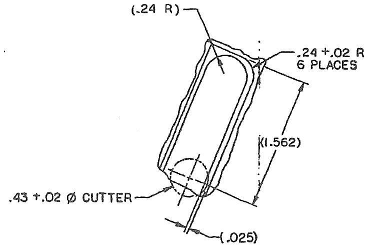
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERR W6S0010	861105	



.126 +.002
⊕ E Ⓢ .004 Ⓢ
.04 +.02 X 45°
.15 +.02
.440 +.010
1.01 –.02
INSPECTORS MARKS TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
(.440)
.661 ±.003
.24 +.02
.211 +.012
-H-
A
.526 +.010 Ø 250
⊕ D .016 Ⓢ
.10 –.02 R 4 PLACES

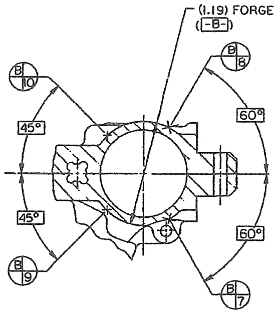


-A-
(.64) FORGING WIDTH AT DATUM TARGETS A1 AND A2
-D- MACHINING NOTE 3
.495 +.010
⊕ A Ⓢ C Ⓜ .010 Ⓢ
-F-
(.2475)
.128 –.006 2 PLACES ALIKE WITHIN .003 TOTAL
BREAK EDGE .010 +.010
89° 45' + 0° 30'
44° 45' + 0° 30'
.015 R MAX 4 PLACES
.042 +.010 R 4 PLACES EQL SP RANDOM ORIENTATION EXCEPT MUST NOT INTERSECT THREADS
⊕ .020
.145 +.020 4 PLACES
.182 +.003 Ø THRU .302 +.020 Ø BACK BORE TO (.64) DEPTH SHOWN (D-19)
⊕ D .006 Ⓢ
2.885 –.020
.781 ±.005
(.505)
-J- NOTE 3
(-G-)
(.128 Ø)
93
1.000 +.002 Ø FIRST 1.110 +.030
⊕ B Ⓢ Ø.020 Ⓢ
-C-
1.000 +.006 Ø THRU REMAINDER
⊕ B Ⓢ Ø.020 Ⓢ
CSK 91° – 2° INCL TO 1.020 +.030 Ø MUST ACCEPT .998 Ø X 3.000 LONG DROP PLUG FOR ENTIRE LENGTH
90°
(.505)
(22° 30')
F
F



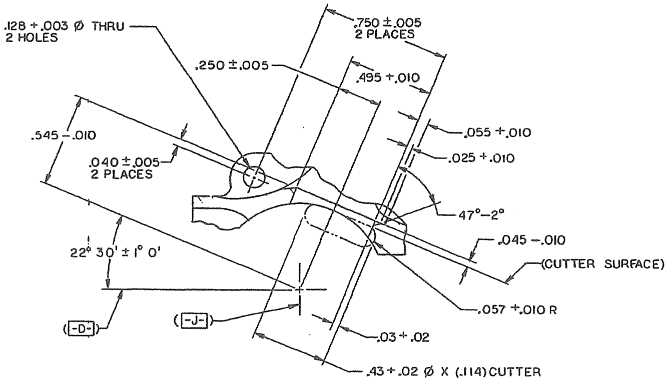
(.24 R)
.24 +.02 R 6 PLACES
(1.562)
.43 +.02 Ø CUTTER
(.025)

VIEW F–F



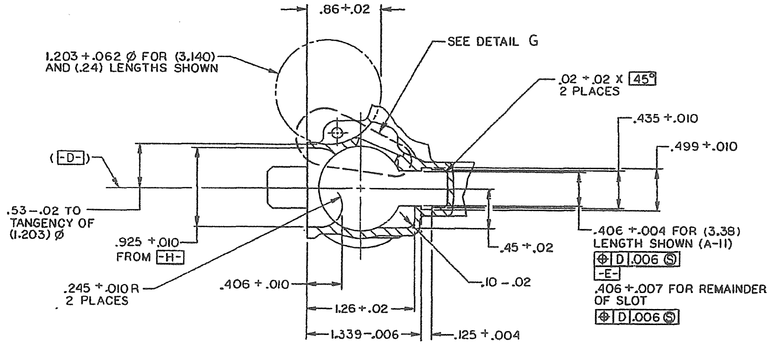
(1.19) FORGED Ø
(-B-)
B 10
B 8
45°
60°
45°
60°
B 9
B 7

SECTION H–H



.128 +.003 Ø THRU 2 HOLES
.750 ±.005 2 PLACES
.250 ±.005
.495 +.010
.545 –.010
.055 +.010
.040 ±.005 2 PLACES
.025 +.010
47° –2°
22° 30' ± 1° 0'
.045 –.010
(CUTTER SURFACE)
(-D-)
(-J-)
.057 +.010 R
.03 +.02
.43 +.02 Ø X (.114) CUTTER

DETAIL G
SCALE: 4/1



.86 +.02
SEE DETAIL G
1.203 +.062 Ø FOR (3.140) AND (.24) LENGTHS SHOWN
.02 +.02 X 45° 2 PLACES
.435 +.010
.499 +.010
(-D-)
.53 –.02 TO TANGENCY OF (1.203) Ø
.925 +.010 FROM -H-
.406 +.004 FOR (3.38) LENGTH SHOWN (A-11)
⊕ D .006 Ⓢ
-E-
.406 +.007 FOR REMAINDER OF SLOT
⊕ D .006 Ⓢ
.45 +.02
.245 +.010 R 2 PLACES
.406 +.010
.10 –.02
1.26 +.02
1.339 –.006
.125 +.004

SECTION E–E

F-3/3

PART NO. 12576280

MECHANICAL PROPERTIES YP TS EL2 RA BH RH	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±	ORIGINAL DATE OF DRAWING 86-11-05 DRAFTSMAN ENGR U.S. ENGR Emil [illegible]	US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER NEW JERSEY 07801
		CHECKER ENGR ENGR	RECEIVER, UPPER
			SIZE J CODE IDENT NO. 19200 12576280
			SCALE 2/1 UNIT WT SHEET

D8448523	M16A1
NEXT ASSY	USED ON
APPLICATION	

12576280

October 13, 2004 3:08 PM

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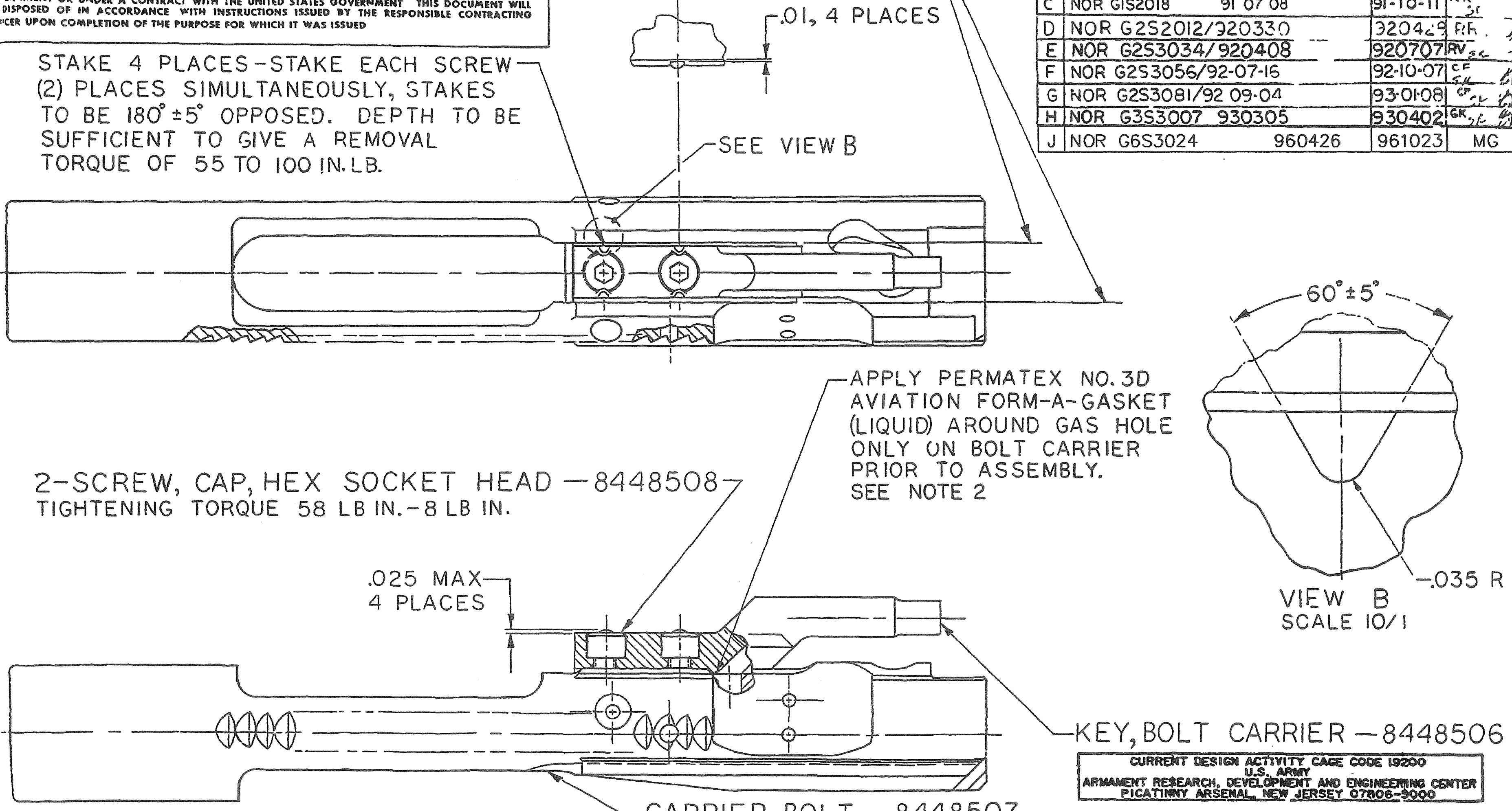
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62286 REVISION C	27APR70	
		A	SEE ERR HQR 20778	6 OCT 72	R.C.
		B	NORW2S0026 82-05-21	83-02-03	
		C	NOR G1S2018 91 07 08	91-10-11	RR
		D	NOR G2S2012/920330	920429	RR
		E	NOR G2S3034/920408	920707	RV
		F	NOR G2S3056/92-07-16	92-10-07	CF
		G	NOR G2S3081/92 09-04	93-01-08	CF
		H	NOR G3S3007 930305	930402	GK
		J	NOR G6S3024 960426	961023	MG


NO DISTORTION PERMISSIBLE ON THESE SURFACES

STAKE 4 PLACES-STAKE EACH SCREW (2) PLACES SIMULTANEOUSLY, STAKES TO BE 180° ±5° OPPOSED. DEPTH TO BE SUFFICIENT TO GIVE A REMOVAL TORQUE OF 55 TO 100 IN.LB.

2-SCREW, CAP, HEX SOCKET HEAD — 8448508
TIGHTENING TORQUE 58 LB IN.-8 LB IN.

APPLY PERMATEX NO. 3D AVIATION FORM-A-GASKET (LIQUID) AROUND GAS HOLE ONLY ON BOLT CARRIER PRIOR TO ASSEMBLY. SEE NOTE 2

KEY, BOLT CARRIER — 8448506

CARRIER, BOLT — 8448507

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SEE PL—8448505

NOTE:

1. MIL-W-13855 APPLIES. Ⓐ
2. ALTERNATIVE MATERIAL: MIL-S-45180 TYPE III

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		8448501	M4
			M16
		D8448501	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO

DATE 27 APR 1970

PREPARED	REB	a. J. St.
CHECKED		
ENGINEER		D. Belliet
SUBMITTED	F. P. Gilhooly	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

KEY AND BOLT CARRIER ASSEMBLY

SIZE	CODE IDENT NO	DRAWING NO.
C	19204	8448505

SCALE 2/1 SHEET OF

CDI

DISTRIBUTION STATEMENT F
FURTHER DISSEMINATION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL ASQNC-AR OR HIGHER DoD AUTHORITY 920323.

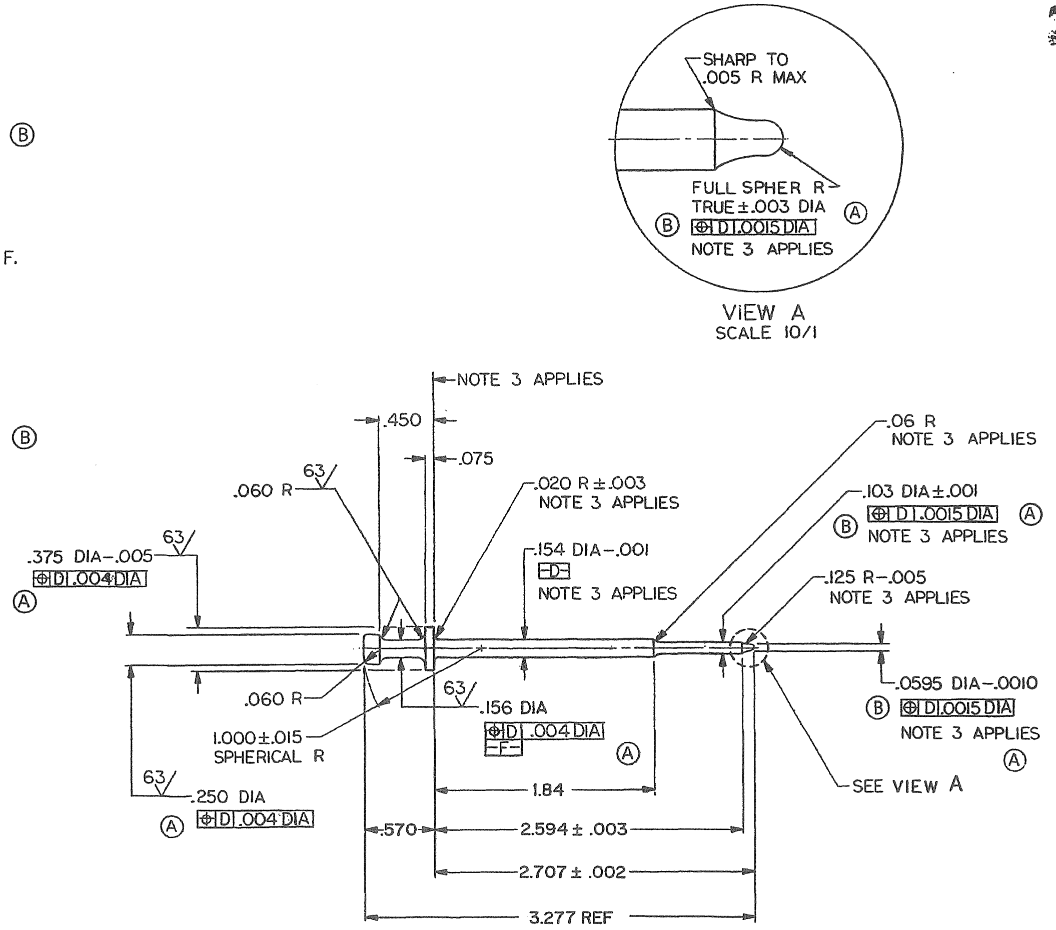
AMSWE Form 403C, 29 Jul 69

October 13, 2004 3:00 PM

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62294 REVISION B	27 APR 70	
		A	(7)SEE ERR HQR 20778	6 OCT 72	R.E.
		B	(6) SEE ERR HQR 30816	12 MAR 74	R.E.
		C	NOR W9S2009 80-02-13	80-05-16	
		D	ERR ~~Z9Z~~1285AU (ECP G05311, 90-07-06)	90-09-25	
		E	NOR G1S2018/910708	911011	RR
		F	NOR G3S3029 930413	930518	RR
		G	NOR G6S3018 / 960329	960717	FET

NOTE:

1. STEEL, AISI 8640 OR AISI 8740. MATERIAL SHALL BE ANNEALED TO A BRINNEL RANGE OF 187 TO 229. MEAN BRINNEL RANGE 210. Ⓑ
2. SUGGESTED HEAT TREAT PROCEDURE FOR AISI 8640 AND AISI 8740.
   HEAT IN NEUTRAL SALT BATH AT 1525°F ± 10°F. QUENCH IN SALT BATH AT 585°F ± 5°F HOLD AT HEAT 18 TO 20 MINUTES. AIR COOL.
3. SURFACES INDICATED MAY BE GROUND AFTER HEAT TREAT. FINISH REQUIRED ON INDICATED SURFACE IS 32√.
4. FINISH 1.2.2.4 OF MIL-STD-171. FILM THICKNESS .0002 / .0003. CLAMP ELECTRODES ON DIA -F-. UNPLATED CONTACT AREA NOT TO EXCEED .06 DIA. Ⓑ
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010.
7. MIL-W-13855 APPLIES. Ⓐ



SHARP TO .005 R MAX
FULL SPHER R TRUE ± .003 DIA Ⓐ
Ⓑ ⊕ D .0015 DIA
NOTE 3 APPLIES
VIEW A
SCALE 10/1
NOTE 3 APPLIES
.450
.075
63
.060 R
.020 R ± .003
NOTE 3 APPLIES
.06 R
NOTE 3 APPLIES
.103 DIA ± .001
Ⓑ ⊕ D .0015 DIA Ⓐ
NOTE 3 APPLIES
63
.375 DIA -.005
⊕ D .004 DIA
Ⓐ
.154 DIA -.001
-D-
NOTE 3 APPLIES
.125 R -.005
NOTE 3 APPLIES
.0595 DIA -.0010
Ⓑ ⊕ D .0015 DIA
NOTE 3 APPLIES
Ⓐ
.060 R
63
.156 DIA
⊕ D .004 DIA
-F-
Ⓐ
1.000 ± .015
SPHERICAL R
63
.250 DIA
Ⓐ ⊕ D .004 DIA
SEE VIEW A
1.84
.570
2.594 ± .003
2.707 ± .002
3.277 REF

CURRENT DESIGN ACTIVITY CAGE CODE 19200
ARMAMENT RESEARCH, DEVELOPNEMT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	C45-49

NEXT ASSY	USED ON
8448501	M4
D9327072	M231
	M16
D8448501	M16A1, M16A2

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO.:

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, FIRING

SIZE D
CODE IDENT NO. 19204
DRAWING NO. 8448503
SCALE 2/1
SHEET OF 1

D8448503

AMSWE Form 403D, 29 Jul 69

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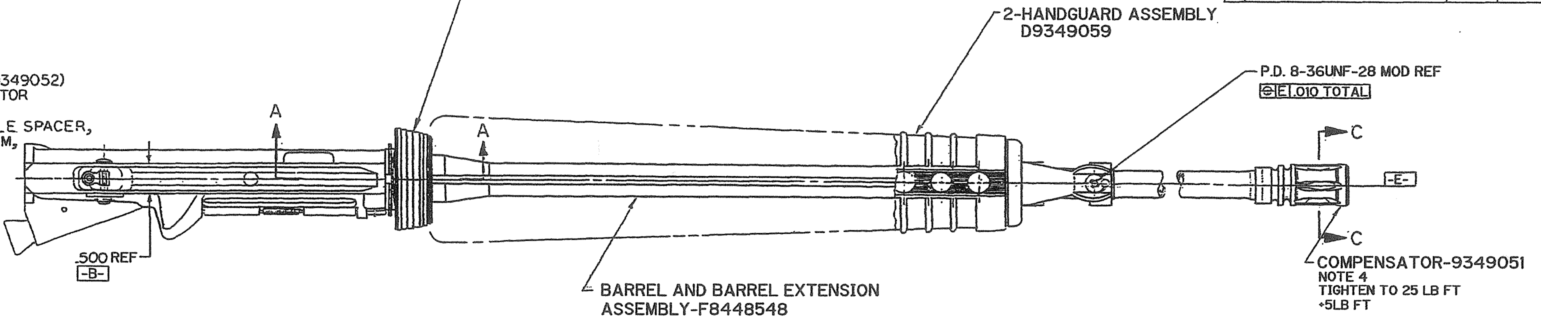
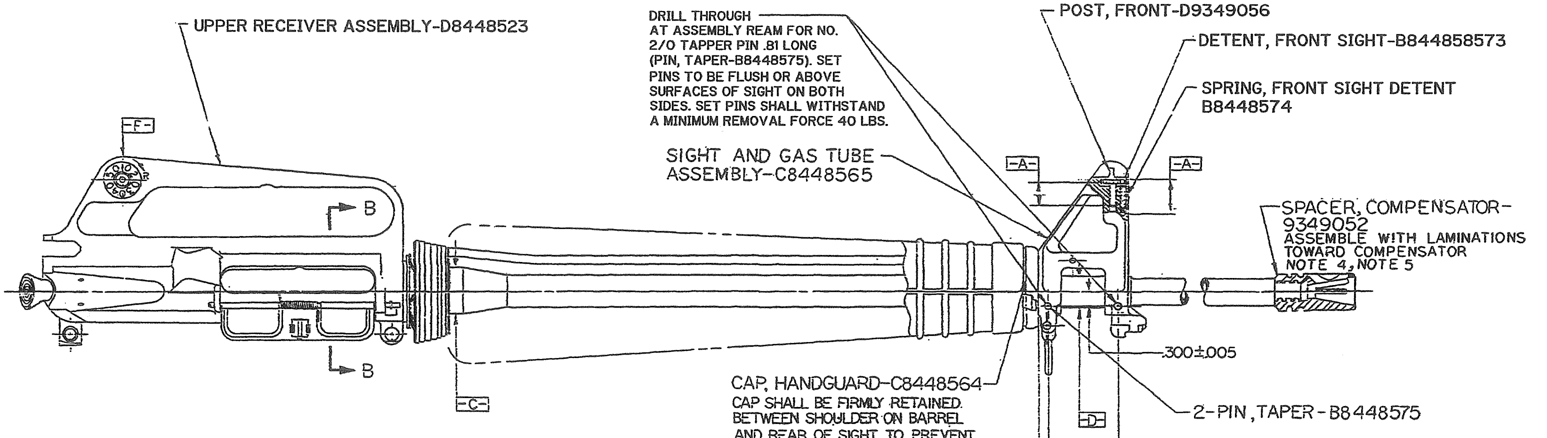
NOTE:

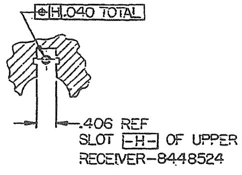
1. APPLY MIL-L-46000 AT ASSEMBLY TO POST, FRONT SIGHT C8448572, DETENT, FRONT SIGHT-B8448573, AND SPRING, FRONT SIGHT DETENT-B8448574 OVER LENGTHS -A-, 2 PLACES.
2. PLANE -E- ESTABLISHED BY ℄ OF BARREL DIA'S -C- AND -D- AND SLOT -B- AT -F-.
3. MIL-W-13855 APPLIES.
4. LAMINATIONS FROM COMPENSATOR SPACER (9349052) MAY BE REMOVED TO ASSEMBLE COMPENSATOR (9349051) WITH SLOT ℄ AS SHOWN.
5. ALTERNATE METHOD OF ASSEMBLY: A SINGLE SPACER, COMPENSATOR-9387099 AND/OR A SINGLE SHIM, COMPENSATOR-9387098 DASH 1 THRU 9 SHALL BE SELECTED TO ASSEMBLE THE COMPENSATOR WITH SLOT ℄ AS SHOWN.

BARREL NUT ASSEMBLY-B8448711
TIGHTEN BARREL NUT TO 30 LB FT, THEN ADVANCE BARREL NUT (IF NECESSARY) TO ALIGN SCALLOP WITH GAS TUBE HOLE IN UPPER RECEIVER. MAX ALLOWABLE TORQUE 80 LB. FT. APPLY MOLYKOTE "G" OR EQUIV TO UPPER RECEIVER THREADS WHEN ASSEMBLING BARREL NUT ASSEMBLY TO UPPER RECEIVER ASSEMBLY. Ⓑ

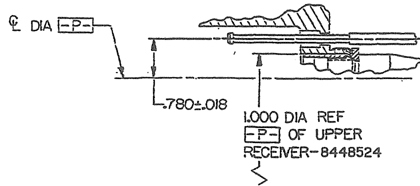
REVISIONS					
	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62276 REV C	27 APR 70	
		A	(3) SEE EO HRD 02197-3	15 JULY 70	
		B	(4) SEE EO HRD 02287	30 DEC 70	
		C	(4) SEE HQR 10721	17 MAY 71	
		D	(3) SEE ERR HQR 10855	13 OCT 71	
		E	(4) SEE ERR HQR 20579	21 JUL 72	R E
		F	NOR W2S 0026 82-05-21	83-02-03	
		G	NOR W5S0010 86-02-24	85-11-05	
		H	NOR S7S3018 /970512	980114	
		J	NOR W5S8004 / 850204	890215	
		K	NOR G2S3057/ 920716 (ECP G2S3058/ 920716)	921030	RR JB SE
		L	NOR G3S3001 930202	930324	
		M	NOR G4S3050/940524	940930	GHS
		N	NOR G4S3094 940808 (ECP G5S3091 950828)	960718	JB


2-HANDGUARD ASSEMBLY D9349059
P.D. 8-36UNF-28 MOD REF
⊕ E .010 TOTAL
C
C
-E-
A
A
.500 REF
-B-
BARREL AND BARREL EXTENSION ASSEMBLY-F8448548
COMPENSATOR-9349051
NOTE 4
TIGHTEN TO 25 LB FT
+5LB FT

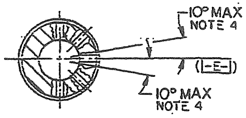

UPPER RECEIVER ASSEMBLY-D8448523
-F-
B
B
-C-
DRILL THROUGH AT ASSEMBLY REAM FOR NO. 2/0 TAPPER PIN .81 LONG (PIN, TAPER-B8448575). SET PINS TO BE FLUSH OR ABOVE SURFACES OF SIGHT ON BOTH SIDES. SET PINS SHALL WITHSTAND A MINIMUM REMOVAL FORCE 40 LBS.
SIGHT AND GAS TUBE ASSEMBLY-C8448565
POST, FRONT-D9349056
DETENT, FRONT SIGHT-B844858573
SPRING, FRONT SIGHT DETENT B8448574
-A-
-A-
SPACER, COMPENSATOR-9349052
ASSEMBLE WITH LAMINATIONS TOWARD COMPENSATOR
NOTE 4, NOTE 5
.300±.005
CAP, HANDGUARD-C8448564
CAP SHALL BE FIRMLY RETAINED BETWEEN SHOULDER ON BARREL AND REAR OF SIGHT TO PREVENT CAP'S FREE ROTATION
-D-
2-PIN, TAPER-B8448575
.195±.015
1.585±.015


⊕ H .040 TOTAL
.406 REF
SLOT -H- OF UPPER RECEIVER-8448524

SECTION B-B


℄ DIA -P-
.780±.018
1.000 DIA REF
-P- OF UPPER RECEIVER-8448524

SECTION A-A


10° MAX
NOTE 4
(-E-)
10° MAX
NOTE 4

SECTION C-C

SEE EPL-8448522

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± —— 3 PLACE DECIMALS ± —— 2 PLACE DECIMALS ± .01
YS MIN				MATERIAL ——
YS MAX				
EL 2				
RA				
BH				
RH		F8448500	M16A1	FINAL PROTECTIVE FINISH ——
		NEXT ASSY	USED ON	
		APPLICATION		

CONTRACT NO:
DATE 27 APR 1970
PREPARED RAR
CHECKED
ENGINEER
SUBMITTED
APPROVED R.S. Henry

DEPT OF THE ARMY.
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

UPPER RECEIVER AND BARREL ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448522

SCALE 1/1 SHEET 1 OF 1

CD1

F 8448522

AMSWE Form 4025

October 13, 2004 2:47 PM

NOTES:-

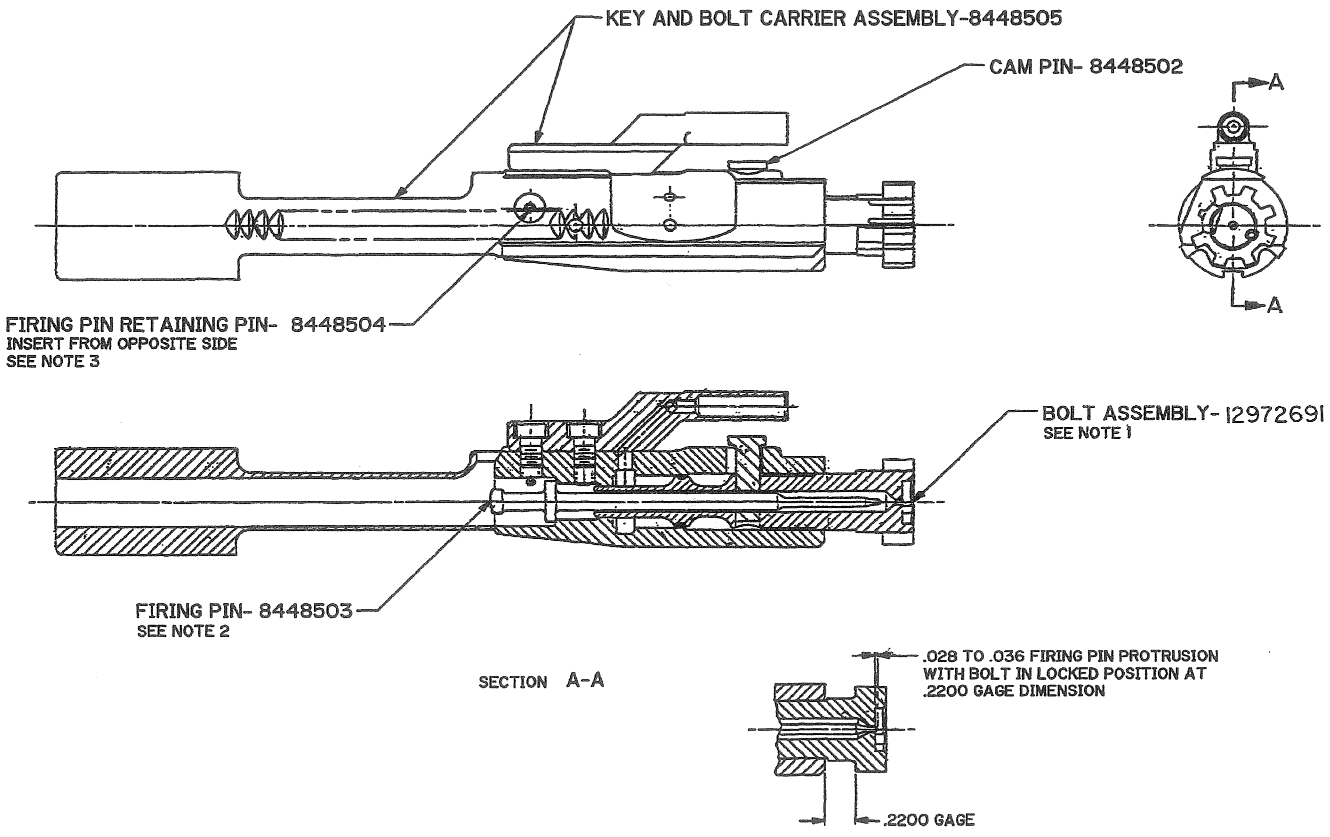
1- BOLT ASSEMBLY- 12972691 MUST CAM FREELY IN KEY AND BOLT CARRIER ASSEMBLY- 8448505.

2- FIRING PIN- 8448503 MUST MOVE FREELY IN BOLT ASSEMBLY- 12972691.

3- FIRING PIN RETAINING PIN- 8448504 MUST BE SECURE AND MUST HOLD FIRING PIN SECURELY.

4- MIL-W-13855 APPLIES.

REVISIONS					
REF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		–	PRODUCT BASELINE ERR G5S3081	951211	HJS
		A	NOR L7S3059 971016 (ECP L8S3000 980126) (ECP L8S3007 980225)	980213	JB


KEY AND BOLT CARRIER ASSEMBLY-8448505
CAM PIN- 8448502
A
A
FIRING PIN RETAINING PIN- 8448504
INSERT FROM OPPOSITE SIDE
SEE NOTE 3
BOLT ASSEMBLY- 12972691
SEE NOTE 1
FIRING PIN- 8448503
SEE NOTE 2
SECTION A-A
.028 TO .036 FIRING PIN PROTRUSION
WITH BOLT IN LOCKED POSITION AT
.2200 GAGE DIMENSION
.2200 GAGE

SEE PL- 8448501

PART NO. 12011849

PMIC	8448600	M16
	8448500	M16A1
MECHANICAL PROPERTIES	9349000	M16A2
YP	12973001	M16A4
TS	12012000	M16A3
EL2	12972700	M4A1
RA	9390000	M4
BH	NEXT ASSY	USED ON
RH	APPLICATION	

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES ON

DECIMAL FRACTION

2 PL ± ±

3 PL ±

THIRD ANGLE PROJECTION

MATL ENGR

CONTRACT NUMBER	
CONTRACTOR	
DRAWN BY HJS	DATE(YR-MO-DA) 951211
CHECKER	ENGINEER
DRAWING APPROVAL	
DESIGN APPROVAL	

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

BOLT CARRIER
ASSEMBLY

SIZE	CAGE CODE	
D	19200	12011849
SCALE 2/1	UNIT WT.	SHEET

DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

AMSWE Form 403D, 29 Jul 69

October 13, 2004 2:46 PM

5 4 3 2 1

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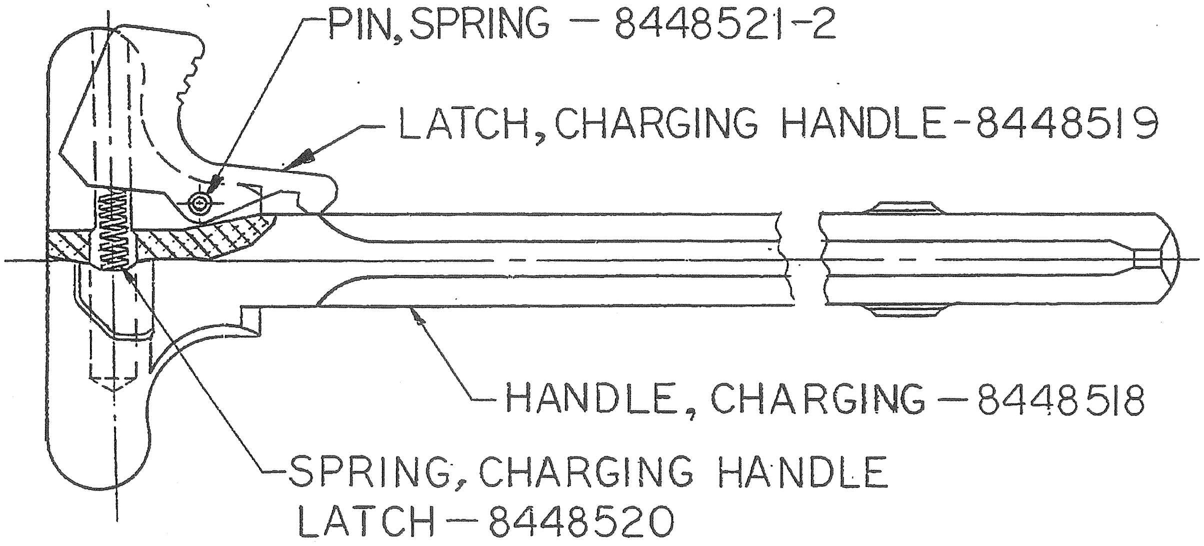
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B 62290 REV A	27APR70	
M		A	SEE ERR HQR 20778	6 OCT 72	R.E.
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	NORW2S0020 82-06-09	83-02-03	
		D	NOR W4S3048 / 84-10-09	85-02-14	
		E	NOR GIS2018 91 07 08	91-10-11	RR

B8448517

NOTES: Ⓐ

1. MIL-W-13855 APPLIES.


PIN, SPRING — 8448521-2
LATCH, CHARGING HANDLE-8448519
HANDLE, CHARGING — 8448518
SPRING, CHARGING HANDLE LATCH — 8448520

CURRENT FSCM NO. 19200

SEE PL-8448517

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
9390000	M4
F9327227	M 231
F8448600	M16
F8448500	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO
DATE 27 APR 1970
PREP WP A. J. A.
CHK
ENGR D. Billiet
SUBMITTED F. P. Tillwoly
APPROVED R. S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

CHARGING HANDLE ASSY

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448517

SCALE 2/1 | SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

October 13, 2004 2:45 PM

PICATINNY ARSENAL, NEW JERSEY 07806-5000

PARTS LIST : PL-19204-8448500
DOCUMENT NUMBER : F 19204-8448500
NOMENCLATURE : RIFLE ASSEMBLY M16A1
CHANGE CONTROL NO.: L7S3059

REVISION SYMBOL: E
REVISION DATE : 03/13/98
ORIGINAL DATE : 01/24/86

AUTHENTICATION-

FIND NUMBER	QTY REQD	CAGE	PART/IDENTIFYING NUMBER	DRAWING SIZE	DRAWING/DOCUMENT NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP LIST
	0001	19200	12011849	D	12011849	BOLT CARRIER ASSEMBLY	X
	0001	19200	12624561	C	12624561	SLING, ADJUSTABLE, SMALL ARMS	X
	0001	19204	8448517	B	8448517	CHARGING HANDLE ASSY	X
	0001	19204	8448522	F	8448522	UPPER RECEIVER AND BARREL ASSEMBLY	X
	0001	19204	8448578	F	8448578	LOWER RECEIVER AND BUTTSTOCK ASSY	X
	0001	19204	8448670	D	8448670	MAGAZINE ASSY, 30 ROUND	X

TOTAL PAGES TO PARTS LIST: 1

QTY REQD: AR - AS REQUIRED ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

October 13, 2004 3:07 PM

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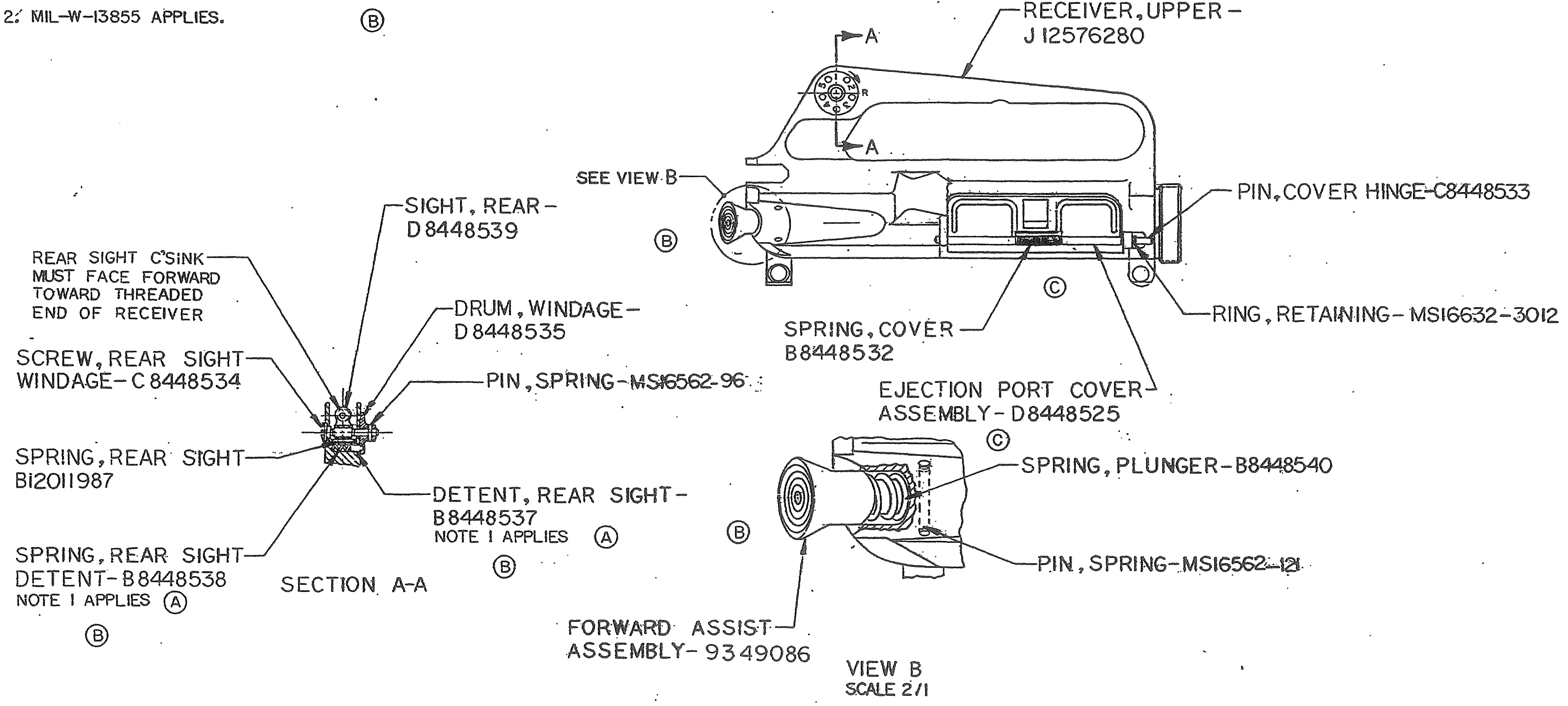
			REVISIONS		
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D 62277 REV A	27 APR 70	
		A	(3) SEE EO HRD 02197-3	15 JULY 70	
		B	(5) SEE ERR HQR 10865	13 OCT 71	YB
		C	(2) SEE ERR HQR 20748	15 SEPT 72	YB
		D	NORW2S0020 82-06-09	83-02-03	
		E	NORW3S0011 83-03-09	83-11-08	
		F	NOR W6S0010 86-02-24	86-11-05	
		G	NOR G7S3018 /870312	880114	
		H	NOR G1S3139/911004	911129	GK
		J	NOR G1S2054/920219	920415	RR

NOTE:

1. APPLY MIL-L-46000 AT ASSEMBLY OF B8448537 DETENT AND B8448538 SPRING. Ⓐ
2. MIL-W-13855 APPLIES. Ⓑ


RECEIVER, UPPER - J 12576280
A
A
SEE VIEW B
Ⓑ
PIN, COVER HINGE-C8448533
Ⓒ
RING, RETAINING- MS16632-3012
SPRING, COVER B8448532
EJECTION PORT COVER ASSEMBLY- D8448525
Ⓒ
SIGHT, REAR- D8448539
REAR SIGHT C'SINK MUST FACE FORWARD TOWARD THREADED END OF RECEIVER
DRUM, WINDAGE- D8448535
SCREW, REAR SIGHT WINDAGE- C8448534
PIN, SPRING-MS16562-96
SPRING, REAR SIGHT B12011987
DETENT, REAR SIGHT- B8448537
NOTE 1 APPLIES Ⓐ
Ⓑ
SPRING, REAR SIGHT DETENT- B8448538
NOTE 1 APPLIES Ⓐ
Ⓑ
SECTION A-A
SPRING, PLUNGER-B8448540
Ⓑ
PIN, SPRING-MS16562-121
FORWARD ASSIST ASSEMBLY- 9349086
VIEW B
SCALE 2/1

SEE SEPARATE PARTS LIST: 8448523

CURRENT

FSCM NO. 19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		F8448522	M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO:

DATE 27 APR 1970		
PREPARED		A. J. St.
CHECKED		
ENGINEER		B. Elliott
SUBMITTED	F. R. Yellowly	
APPROVED	R. S. Henry	

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

UPPER RECEIVER ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448523

SCALE 1/1 SHEET 1 OF

CDI

D8448523

DISTRIBUTION STATEMENT F.
FURTHER DISSEMINATION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL
ASQNC-AREC-T, 910725 OR HIGHER DoD AUTHORITY.

WE Form 403D, 29 Jul 69

DRAWING SIZE C 4 3 2 1

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	G	NOR G3S3076 930817	931102	RLV SR

NOTES:

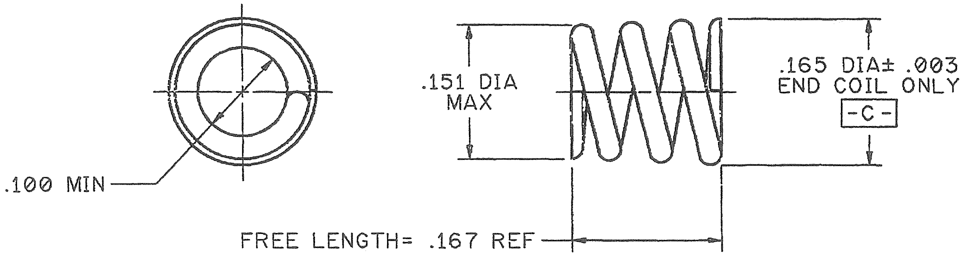
1. WIRE, STEEL, MUSIC SPRING QUALITY PER ASTM-A228 .022 SIZE EXCEPT TENSILE STRENGTH TO BE 363,000 TO 393,000 PSI.
2. STRESS RELIEVE- HOLD AT 450°F± 25°F FOR 30 MIN.
3. SUGGESTED SOURCE OF SUPPLY:

   NATIONAL STANDARD
   NILES, MICHIGAN 49120;

   MAPES PIANO STRING CO.
   ELIZABETHAN, TENN 37644;

   JOHNSON WIRE & STEEL
   WORCESTER, MASS.
4. MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572.
5. MIL-W-13855 APPLIES.
6. BREAK SHARP EDGES .003± .012

*7. PRESET- COMPRESS TO SOLID HEIGHT 3 TIMES PRIOR TO CHECKING LOADS.



SPRING DATA	
WIRE DIA	.0220
TOTAL COILS	4 REF
DIRECTION OF HELIX	OPTIONAL
* LOAD AT COMPRESSED LENGTH OF	.140 IN= 2.0 LB± 0.2 LB
* LOAD AT COMPRESSED LENGTH OF	.112 IN= 4.2 LB± 0.4 LB
ONE END EXPANDED TO DIM.	-C-
TYPE OF ENDS	CLOSED AND GROUND
SOLID LENGTH	.090 MAX

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

THIS DRAWING HAS BEEN GENERATED ON A CAD SYSTEM LOCATED AT ARDEC, BLDG. 6, PICATINNY ARSENAL, N.J. CHANGES MUST BE INCORPORATED VIA THIS SYSTEM.

PART NO. 8448753

DISTRIBUTION STATEMENT F.
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-ARI OR HIGHER DOD AUTHORITY:
DATE OF DERTERMINATION:

PMIC			
MECHANICAL PROPERTIES			
YP		8448755	M4
TS		B11828591	M231
EL2		B8448755	M16
RA			M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ± ±
3 PL ±.005
THIRD ANGLE PROJECTION
MATL ENGR
CADDS REV C 729

CONTRACT NUMBER
CONTRACTOR
DRAWN BY T.A. WILSON D KROLAK
DATE(YR-MO-DA) 71-11-04
CHECKER S. FRUTIGER G DRESSELHAUS
ENGINEER R. ELBE L. BRUNTON
DRAWING APPROVAL A. A. COLE
DESIGN APPROVAL R. S. HENRY

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

SPRING, EXTRACTOR

SIZE C
CODE IDENT NO. 19204
8448753
SCALE 10/1
UNIT WT.
SHEET

SMCAR FORM 67, 1 DEC 87(TEMP), REPLACES SMCAR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

October 18, 2004 7:14 AM

5 4 3 2 1

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REVISIONS

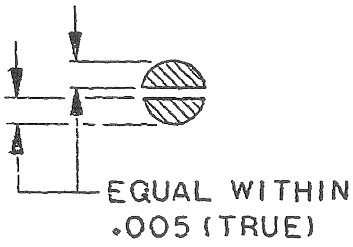
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C62335 REVISION B	27APR70	
		A	(2) SEE EO HRD 02197-3	15 JUL 70	
		B	(4) SEE ERR HQR 20778	5OCT 72	RC
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W2S3258/82-12-30	84-09 04	
		E	NOR G1S2018 91-07-08	91-10-11	
		F	NOR G3S2019/930701	930301	CHS

B8448504

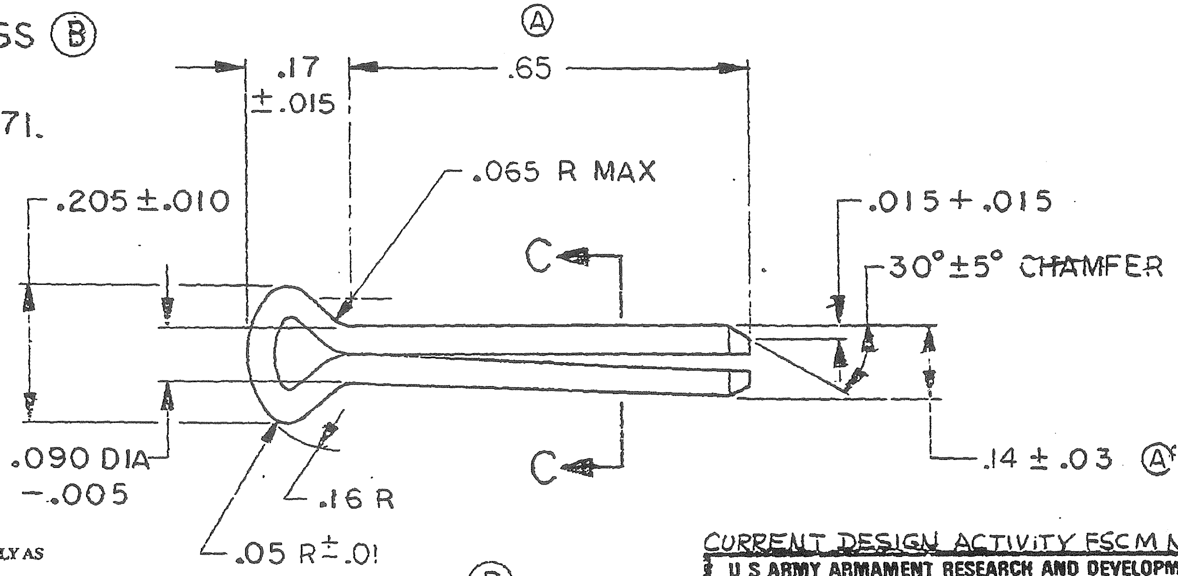
NOTES

1. FINISH 125/√
2. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS Ⓑ SPECIFIED.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.

Ⓑ



SECTION C-C



"DISTRIBUTION STATEMENT E. FURTHER DISSEMINATION ONLY AS DIRECTED BY ASQNC-AR, 911025, OR HIGHER DoD AUTHORITY."

Ⓑ

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO DATE 27APR 1970	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS
YS MIN	8448501	M4		PREP	
YS MAX	D9327072	M231		CHK	PIN, RETAINING, FIRING PIN
EL 2		M16	MATERIAL WIRE, STEEL, CMPSN 1038, ASTM A510	ENGR	
RA				SUBMITTED	
BH	D8448501	M16A2			SIZE B · CODE IDENT NO 19204 · DRAWING NO. 8448504
	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED R. S. Henry	
RH 15N-30.5-835	APPLICATION		SEE NOTE 3		SCALE 5/1 · SHEET 1 OF 1

Ⓑ

AMSWE Form 403B, 29 Jul 69

CDI

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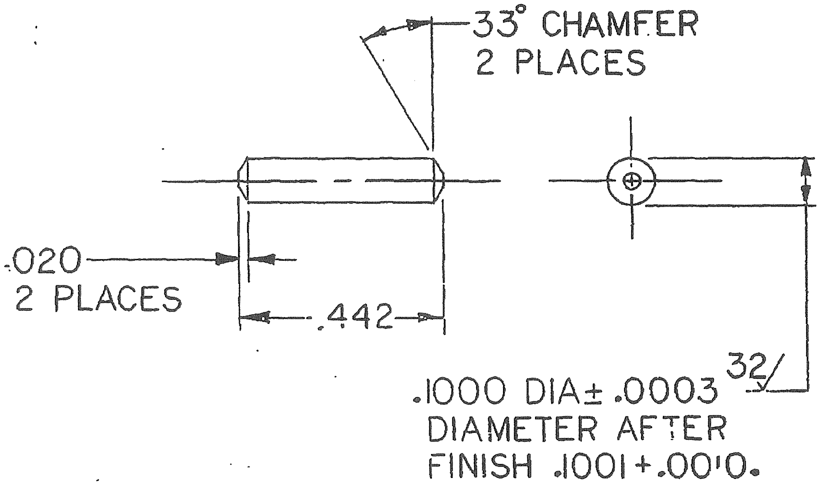
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61563 REV C	27 APR70	
M		A	(3)SEE ERR HQR 20778	6 OCT 72	R.C.
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	ERR ~~Z9Z1251Y~~ (ECP G8S2073/890110	900622	ORFI-CAE
		D	NOR G1S2018 91 07 08	91-10-11	RR SR
		E	NOR G2S3025 920330	920427	TT SR

B8448513

NOTE:

1. FINISH 125√ EXCEPT AS NOTED.
2. OIL QUENCH FROM 1600°F, TEMPER AT 275°F TO 400°F.
3. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005+.002-A2 ALMEN, 150% COVERAGE.
4. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.



DISTRIBUTION STATEMENT E.
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL; OR HIGHER DoD AUTHORITY
ASQNC-AR: 920310.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	15N 88.5—90.5

NEXT ASSY	USED ON
8448509	M4
C9327073	M231
	M16
C8448509	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± ——

MATERIAL
TOOL STEEL CLASS S2
ASTM-A681

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO:		
DATE	27 APR 1970	
PREP	B.R.S.	A.J.S.
CHK	D.H.W.	H.L.
ENGR	D.S.	D.B.
SUBMITTED	F. P. GILHOOLY	
APPROVED	K.S. HENRY	

ROCK ISLAND ARSENAL,
ROCK ISLAND, ILL 61201

PIN, EXTRACTOR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448513
SCALE 4/1		SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

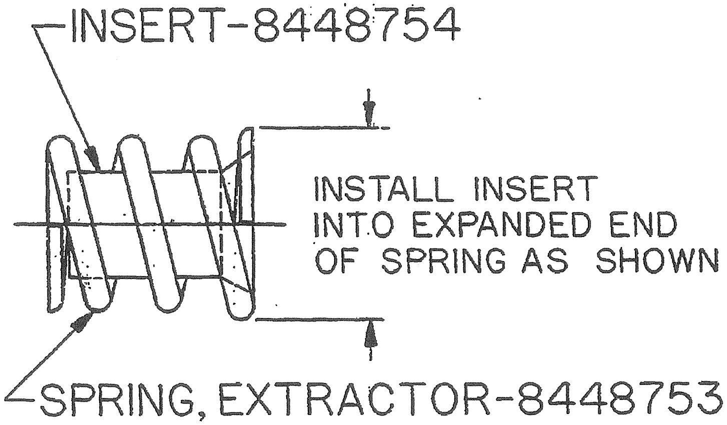
CDI SCANNED DUPLICATE ORIGINAL

October 18, 2004 10:55 AM

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	NORM2S0025 82-05-21	83-02-03	
		B	NOR GIS2018 91 07 08	91-10-11	RR

NOTE:
MIL-W-13855 APPLIES.



INSTALL INSERT INTO EXPANDED END OF SPRING AS SHOWN

B8448755

~~CURRENT DESIGN ACTIVITY FSCM NO. 19200~~

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL 8448755

PART NO. 8448755

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± — 3 PLACE DECIMALS ± — 2 PLACE DECIMALS ± —	CONTRACT NO:
YS MIN					DATE 14 NOV 71
YS MAX		8448509	M4	MATERIAL —	PREP T.H. Wilson D. Krolak
EL 2		C8448509	M16		CHK S. Fontana J. Dreselhaus
RA			M16A1		ENGR R. Elbe L. Brunton
BH		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH —	SUBMITTED A. A. Cole
RH		APPLICATION			APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING ASSY, EXTRACTOR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448755

SCALE 10/1 SHEET 1 OF 1

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

October 18, 2004 10:55 AM

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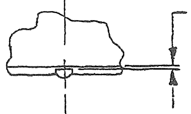
REVISIONS

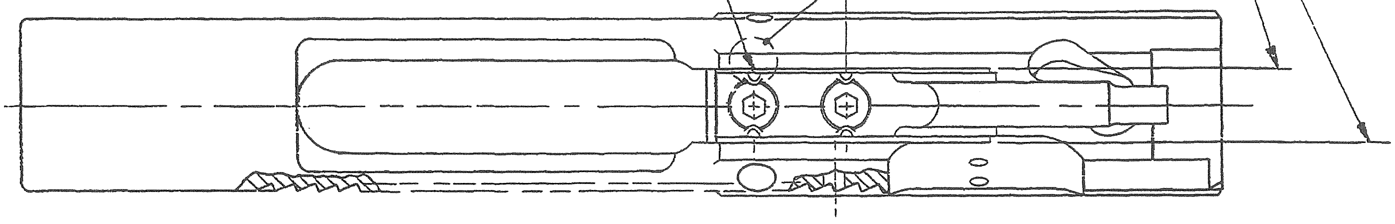
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVAL
M			REDRAWN FROM COLT'S DRAWING C62286 REVISION C	27APR70	
-PA		A	SEE ERR HQR 20778	6 OCT 72	O.R.C.
		B	NORW2S0026 82-05-21	83-02-03	[illegible]
		C	NOR G1S2018 91 07 08	91-10-11	RF
		D	NOR G2S2012/920330	920429	RF
		E	NOR G2S3034/920408	920707	RV
		F	NOR G2S3056/92-07-16	92-10-07	CF
		G	NOR G2S3081/92 09-04	93-01-08	CF
		H	NOR G3S3007 930305	930402	GK
		J	NOR G6S3024 960426	961023	MG

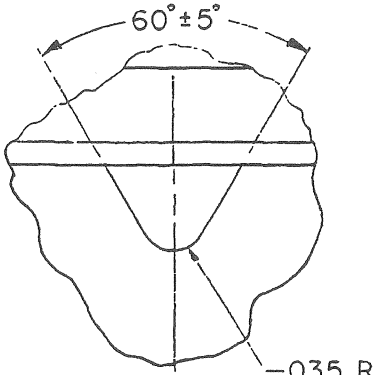
NO DISTORTION PERMISSIBLE ON THESE SURFACES



STAKE 4 PLACES-STAKE EACH SCREW (2) PLACES SIMULTANEOUSLY, STAKES TO BE 180° ±5° OPPOSED. DEPTH TO BE SUFFICIENT TO GIVE A REMOVAL TORQUE OF 55 TO 100 IN.LB.

SEE VIEW B



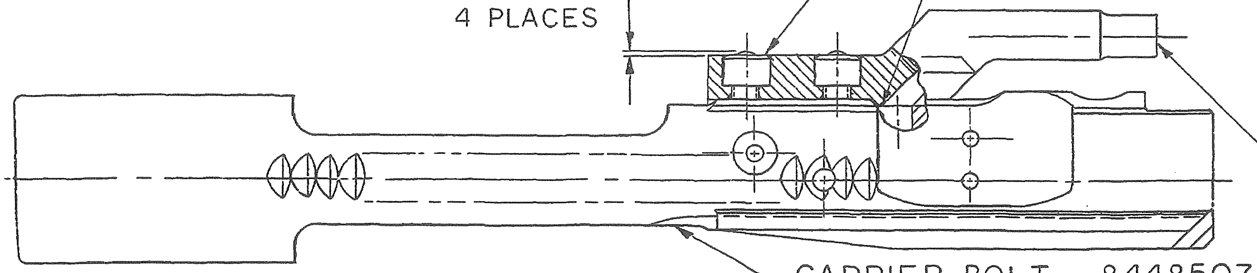


VIEW B
SCALE 10/1

APPLY PERMATEX NO. 3D AVIATION FORM-A-GASKET (LIQUID) AROUND GAS HOLE ONLY ON BOLT CARRIER PRIOR TO ASSEMBLY. SEE NOTE 2

2-SCREW, CAP, HEX SOCKET HEAD — 8448508
TIGHTENING TORQUE 58 LB IN.-8 LB IN.

.025 MAX
4 PLACES



KEY, BOLT CARRIER — 8448506

CARRIER, BOLT — 8448507

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SEE PL — 8448505

NOTE:

1. MIL-W-13855 APPLIES. Ⓐ
2. ALTERNATIVE MATERIAL: MIL-S-45180 TYPE III

MECHANICAL PROPERTIES		
YS MIN		
YS MAX		
EL 2		
RA		
BH		
RH		

NEXT ASSY	USED ON
8448501	M4
	M16
D8448501	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO

DATE 27 APR 1970

PREPARED	REB	a. J. St.
CHECKED	D.P.W.	V. Ludlum
ENGINEER	L. Smart	D. Elliot
SUBMITTED	F. P. Gilhooly	
APPROVED	R. S. Henry	

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

KEY AND BOLT CARRIER ASSEMBLY

SIZE	CODE IDENT NO	DRAWING NO.
C	19204	8448505

SCALE 2/1 SHEET OF

CDI

DISTRIBUTION STATEMENT F
FURTHER DISSEMINATION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL ASQNC-AR OR HIGHER DoD AUTHORITY 920323.

AMSWE Form 403C, 29 Jul 69

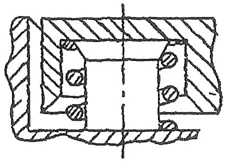
October 18, 2004 7:14 AM

DRAWING SIZE C

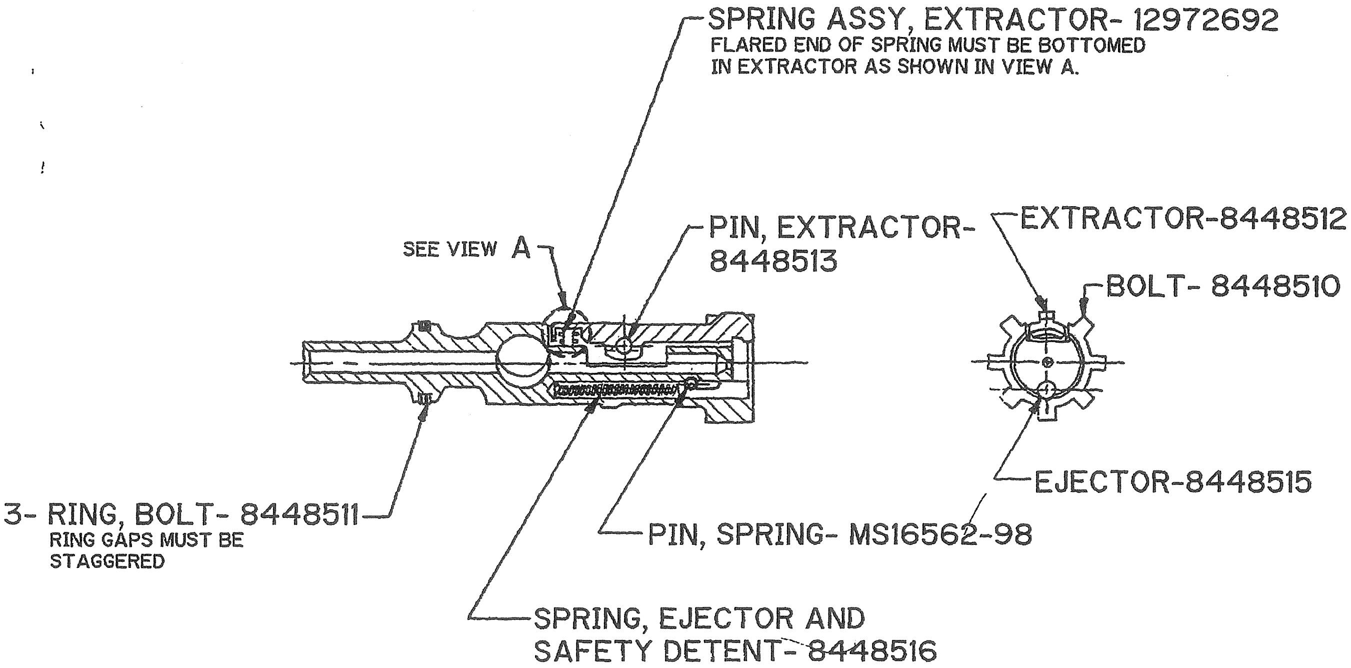
REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	—	PRODUCT BASELINE ERR G5S3081	951211	HJS

NOTES:-

1- MIL-W-13855 APPLIES.



VIEW A
SCALE 10/1


SPRING ASSY, EXTRACTOR- 12972692
FLARED END OF SPRING MUST BE BOTTOMED IN EXTRACTOR AS SHOWN IN VIEW A.
SEE VIEW A
PIN, EXTRACTOR- 8448513
EXTRACTOR-8448512
BOLT- 8448510
EJECTOR-8448515
3- RING, BOLT- 8448511
RING GAPS MUST BE STAGGERED
PIN, SPRING- MS16562-98
SPRING, EJECTOR AND SAFETY DETENT- 8448516

PART NO. 12972691

DISTRIBUTION STATEMENT F:
FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASQNC-AR OR
HIGHER DoD AUTHORITY: 92-06-22.

PMIC		
MECHANICAL PROPERTIES		
YP		
TS		
EL2		
RA	12011849	M4/M4A1
BH	NEXT ASSY	USED ON
RH	APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION
2 PL ±
3 PL ± ±
THIRD ANGLE PROJECTION
MATL ENGR

CONTRACT NUMBER
CONTRACTOR
DRAWN BY HJS DATE(YR-MO-DA) 951211
CHECKER ENGINEER
DRAWING APPROVAL
DESIGN APPROVAL

DESIGN ACTIVITY U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

BOLT ASSEMBLY

SIZE	CAGE CODE	
C	19200	12972691
SCALE 2/1	UNIT WT.	SHEET

SMCAR FORM 67, 1 DEC 87(TEMP). REPLACES SMCAR FORM 67, 1 MAR 87(TEMP),
WHICH MAY BE USED UNTIL EXHAUSTED

October 13, 2004 2:50 PM

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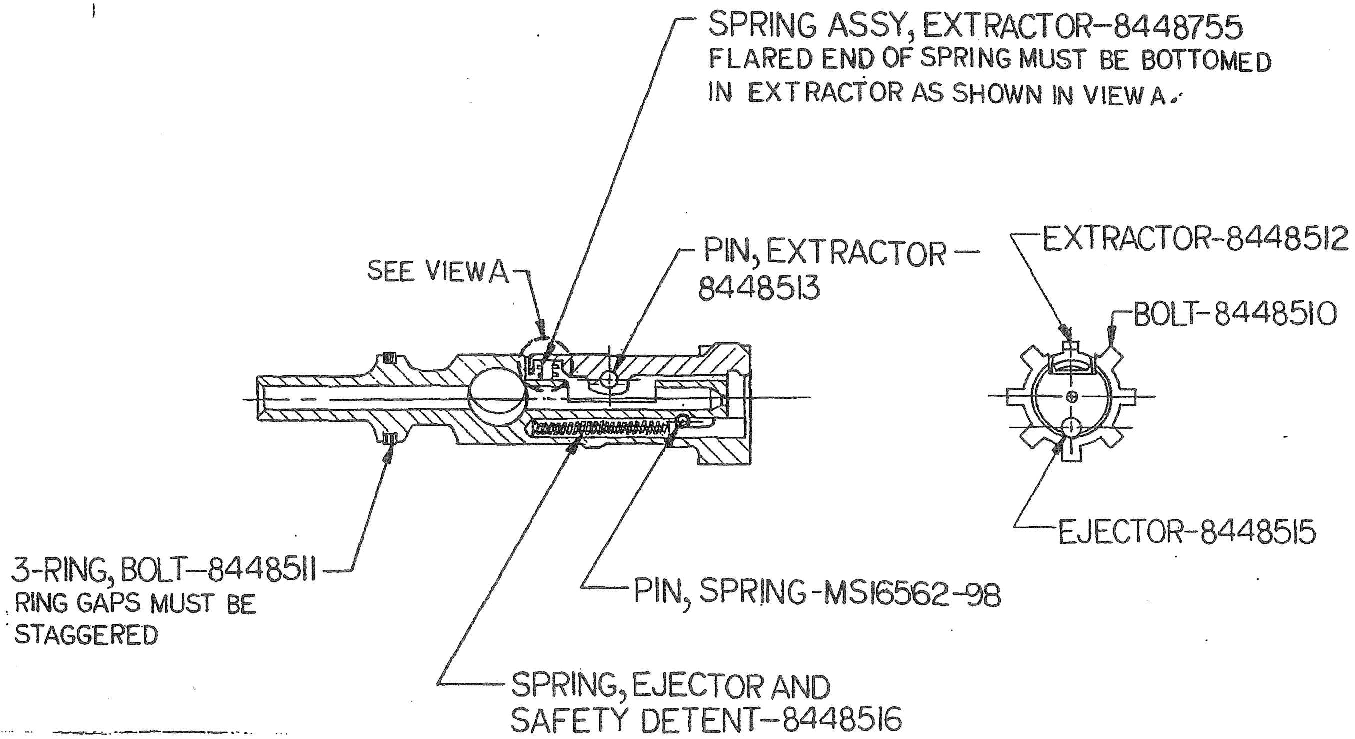
REVISIONS

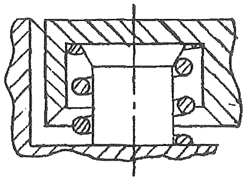
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M	-	D	REPLACES REV C W/CHANGE ~~SEE ERR NOR 28778~~	6 OCT 72	RE
		E	NORW2S0020 82-06-09	83-02-03	LAH
		F	NOR W2S 0026 / 82-05-21	83-09-22	
		G	NOR G1S2018 91-07-08	91-10-11	RR SL
		H	NOR G2S3059/920716 (ECP G2S3060/920630)	92-08-11	AJL SL

NOTES:

1. MIL-W-13855 APPLIES.



SPRING ASSY, EXTRACTOR-8448755
FLARED END OF SPRING MUST BE BOTTOMED IN EXTRACTOR AS SHOWN IN VIEW A.
SEE VIEW A
PIN, EXTRACTOR-8448513
EXTRACTOR-8448512
BOLT-8448510
EJECTOR-8448515
3-RING, BOLT-8448511
RING GAPS MUST BE STAGGERED
PIN, SPRING-MS16562-98
SPRING, EJECTOR AND SAFETY DETENT-8448516



VIEW A
SCALE 10/1

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

SEE PL-8448509

PART NO. 8448509

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448501	M4
BH			M16
		D8448501	M16 A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970

PREPARED
CHECKED
ENGINEER
SUBMITTED D. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BOLT ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448509

SCALE 2/1 SHEET 1 OF 1

C8448509

AMSWE Form 403C, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

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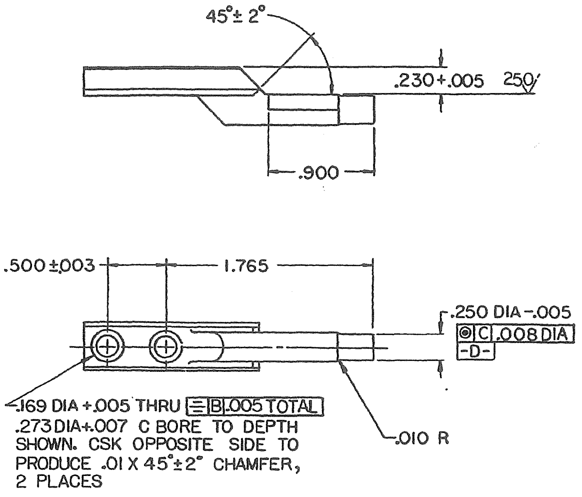
NOTE:

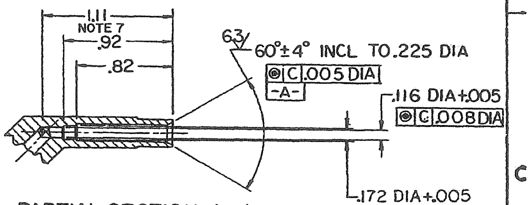
1. FINISH 125/ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT PROCEDURE: OIL QUENCH FROM 1575°F. TEMPER AT 1100°F FOR 1 HOUR.
3. FINISH 1.2.2.2 OF MIL-STD-171 ON DIA -A- AND -C-. FILM THICKNESS .0002/.0003.
4. ALL OTHER SURFACES TO RECEIVE FINISH 5.3.1.2 OF MIL-STD-171.
5. BREAK SHARP EDGES .005+.010.
6. MIL-W-13855 APPLIES.
7. FOR GAGING PURPOSED ONLY. THE DEPTH OF PENETRATION OF A .1158 -.0002 GAGE PIN SHALL BE 1.100 MIN TO 1.135 MAX.

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D61547 REV D	27APR70	
		A	(8) SEE EO HQR 1C631	20 FEB 71	
		B	(7) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	SEE ERR HQR 50604	5 FEB 75	R.C.
		D	NOR W280026 82-05-21	83-02-08	
		E	ERR Z9Z1295F (ECP G0S3110/900709)	901108	VJSI S/ES
		F	NOR G0S3166/901011	910130	PF SR
		G	NOR G1S2018 910708	91-10-11	RE
		H	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL
		J	NOR G6S3142 961024	961215	JB

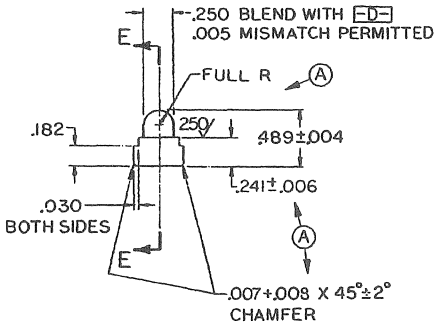


45°± 2°
.230+.005
250/
.900
.500±.003
1.765
.250 DIA -.005
◎ C .008 DIA
-D-
.169 DIA +.005 THRU ⌯ B .005 TOTAL
.273 DIA +.007 C BORE TO DEPTH SHOWN. CSK OPPOSITE SIDE TO PRODUCE .01 X 45°±2° CHAMFER, 2 PLACES
.010 R

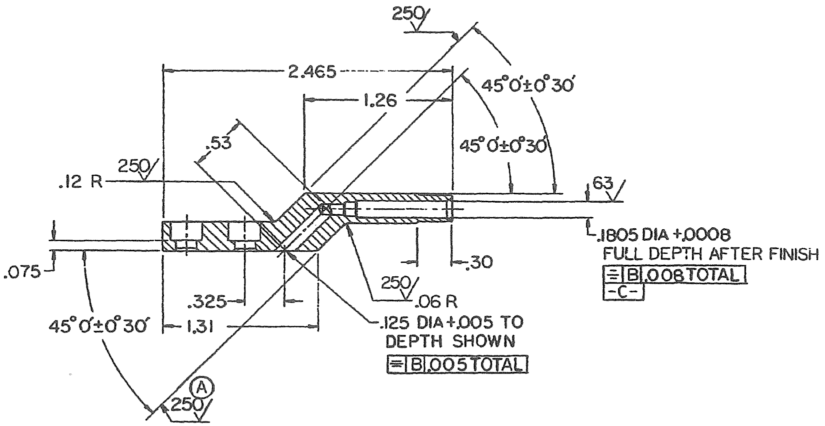


1.11
NOTE 7
.92
.82
63/
60°±4° INCL TO .225 DIA
◎ C .005 DIA
-A-
.116 DIA +.005
◎ C .008 DIA
.172 DIA +.005
◎ C .006 DIA

PARTIAL SECTION J-J

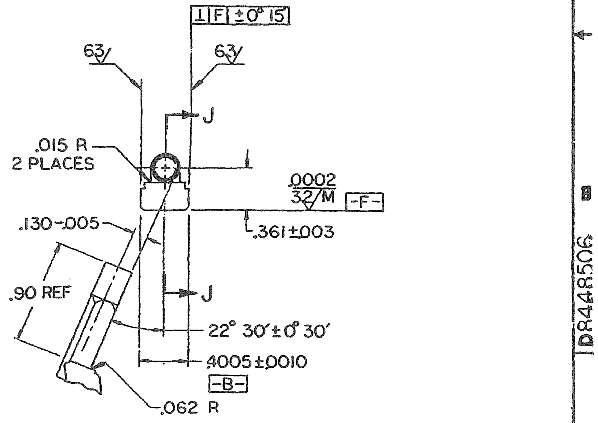


.250 BLEND WITH -D-
.005 MISMATCH PERMITTED
E
FULL R
Ⓐ
.182
250/
.489±.004
.241±.006
.030
BOTH SIDES
Ⓐ
E
.007+.008 X 45°±2°
CHAMFER



250/
2.465
45°0'±0°30'
1.26
.53
45°0'±0°30'
.12 R
250/
63/
.1805 DIA +.0008
FULL DEPTH AFTER FINISH
⌯ B .008 TOTAL
-C-
.075
.30
250/
.06 R
.325
45°0'±0°30'
1.31
.125 DIA +.005 TO DEPTH SHOWN
⌯ B .005 TOTAL
Ⓐ
250/

SECTION E-E



⊥ F ±0° 15'
63/
63/
J
.015 R
2 PLACES
.0002
32/M
-F-
.130-.005
.361±.003
.90 REF
J
22° 30'±0° 30'
.4005±.0010
-B-
.062 R

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448505	M4 M16A2
BH			M16
		C8448505	M16A1
RH	C26-32	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
STEEL, AISI 4130
GUN QUALITY
MAX BHN 229

FINAL PROTECTIVE FINISH
SEE NOTES 3 & 4

CONTRACT NO:
DATE 27 APR 1970
PREPARED MC
CHECKED
ENGINEER B. Billit
SUBMITTED F.P. Yellsworth
APPROVED R.S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

KEY,
BOLT CARRIER

SIZE D | CODE IDENT NO. 19204 | DRAWING NO. 8448506
SCALE 2/1 | SHEET | OF

CDI

D8448506

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

AMSWE Form 403D, 29 Jul 69

October 15, 2004 11:27 AM

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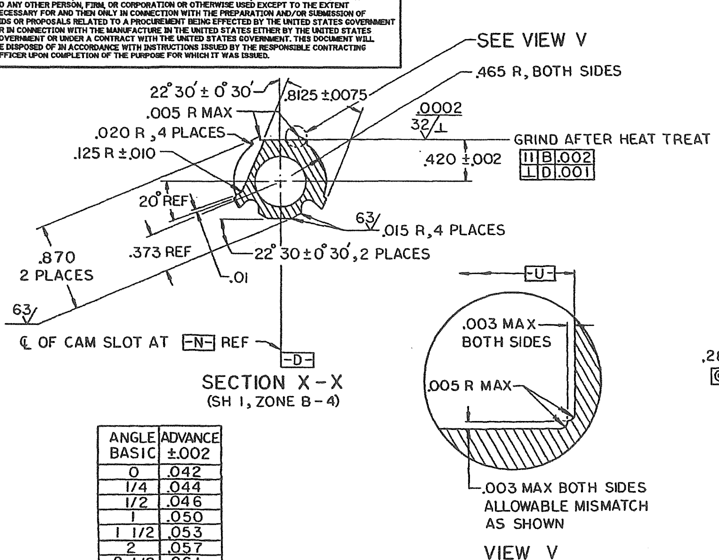
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
MF			REDRAWN FROM COLT'S DRAWING J62274 REV E	27 APR 70	
		A	(2) SEE EO HRD 02197-3	15 JULY 70	
		B	(3) SEE EO HQR 10632	20 FEB 71	
		C	(3) SEE ERR HQR 20778	6 OCT 72	RC
	7	D	NO CHANGE	5 FEB 75	RC
		E	NOR W25 0026 82-05-21	83-02-03	R Hall
		H	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL
		K	NOR L9S3040 000106	000217	RLV

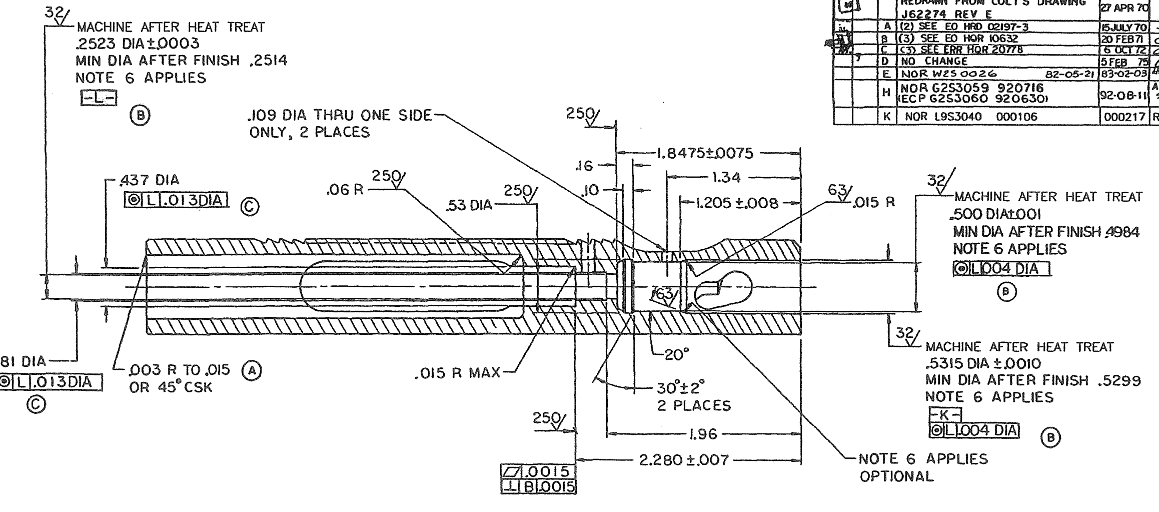


SEE VIEW V
.465 R, BOTH SIDES
22° 30′ ± 0° 30′
.8125 ±.0075
.005 R MAX
.0002
32/⊥
.020 R, 4 PLACES
.125 R ±.010
.420 ±.002
GRIND AFTER HEAT TREAT
∥ B .002
⊥ D .001
20° REF
63/ .015 R, 4 PLACES
.870 2 PLACES
.373 REF
22° 30 ±0° 30′, 2 PLACES
.01
-U-
63/
℄ OF CAM SLOT AT -N- REF
-D-
.003 MAX BOTH SIDES
.005 R MAX
.003 MAX BOTH SIDES ALLOWABLE MISMATCH AS SHOWN

SECTION X - X
(SH 1, ZONE B - 4)

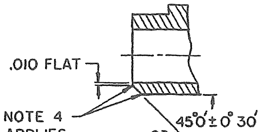
VIEW V
SCALE: 50/1

ANGLE BASIC	ADVANCE ±.002
0	.042
1/4	.044
1/2	.046
1	.050
1 1/2	.053
2	.057
2 1/2	.061
3	.065
3 1/2	.069
4	.073
4 1/2	.076
5	.080
5 1/2	.084
6	.088
6 1/2	.092
7	.096
7 1/2	.099
8	.103
8 1/2	.107
9	.111
9 1/2	.114
10	.118
10 1/2	.122
11	.126
11 1/2	.130
12	.134
12 1/2	.137
13	.141
13 1/2	.145
14	.149
14 1/2	.153
15	.157
15 1/2	.161
16	.164
16 1/2	.168
17	.172
17 1/2	.175
18	.179
18 1/2	.183
19	.187
19 1/2	.190
20	.195
20 1/2	.200
21	.207
21 1/2	.214
22	.226
22 1/4	.235
22 1/2	.255



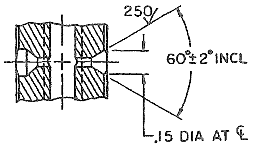
32/ MACHINE AFTER HEAT TREAT
.2523 DIA±.0003
MIN DIA AFTER FINISH .2514
NOTE 6 APPLIES
-L-
Ⓑ
.109 DIA THRU ONE SIDE ONLY, 2 PLACES
250/
.16
1.8475±.0075
.10
1.34
1.205 ±.008
.437 DIA
◎ L .013DIA Ⓒ
.06 R
250/
.53 DIA
250/
63/ .015 R
32/ MACHINE AFTER HEAT TREAT
.500 DIA±.001
MIN DIA AFTER FINISH .4984
NOTE 6 APPLIES
◎ L .004 DIA
Ⓑ
63/
.281 DIA
◎ L .013DIA
Ⓒ
.003 R TO .015 OR 45° CSK Ⓐ
.015 R MAX
20°
30°±2° 2 PLACES
32/ MACHINE AFTER HEAT TREAT
.5315 DIA ±.0010
MIN DIA AFTER FINISH .5299
NOTE 6 APPLIES
-K-
◎ L .004 DIA Ⓑ
250/
1.96
2.280 ±.007
⏥ .0015
⊥ B .0015
NOTE 6 APPLIES OPTIONAL

SECTION W - W
ROTATED 90° CCW



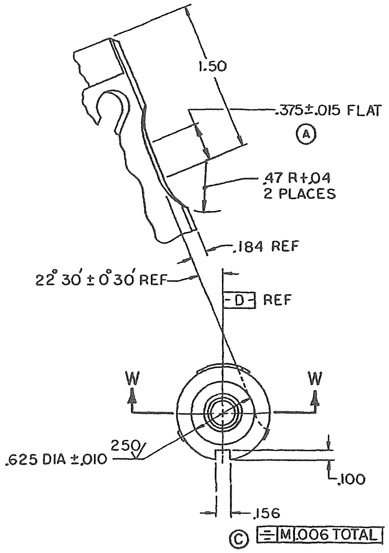
.010 FLAT
NOTE 4 APPLIES
45°0′± 0° 30′
63/

SECTION P - P
(SH 1, ZONE B - 1)



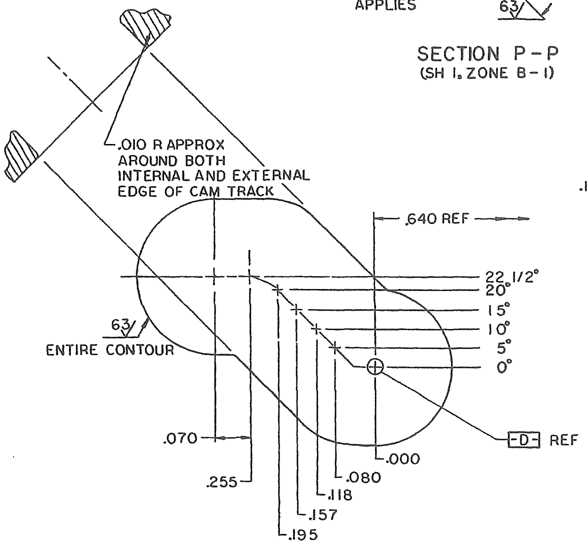
250/
60°±2° INCL
.15 DIA AT ℄

SECTION R - R

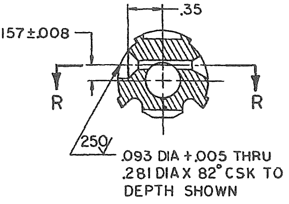


1.50
.375±.015 FLAT
Ⓐ
.47 R±.04 2 PLACES
.184 REF
22° 30′ ± 0° 30′ REF
-D- REF
W
W
250/
.625 DIA ±.010
.100
.156
Ⓒ ⌯ M .006 TOTAL

VIEW N - N
(SH 1, ZONE B - 7)



.010 R APPROX AROUND BOTH INTERNAL AND EXTERNAL EDGE OF CAM TRACK
.640 REF
22 1/2°
20°
15°
10°
5°
0°
63/ ENTIRE CONTOUR
.070
-D- REF
.000
.255
.080
.118
.157
.195



.35
.157±.008
R
R
250/
.093 DIA +.005 THRU
.281 DIA X 82° CSK TO DEPTH SHOWN

SECTION S - S
(SH 1, ZONE B - 5)

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

CURRENT DESIGN ACTIVITY FSCM NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL 2			
RA			
BH			
RH			
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL ———

FINAL PROTECTIVE FINISH ———

CONTRACT NO.

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

CARRIER, BOLT

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448507

SCALE 2/1 SHEET 2 OF 2

CDI

F8448507

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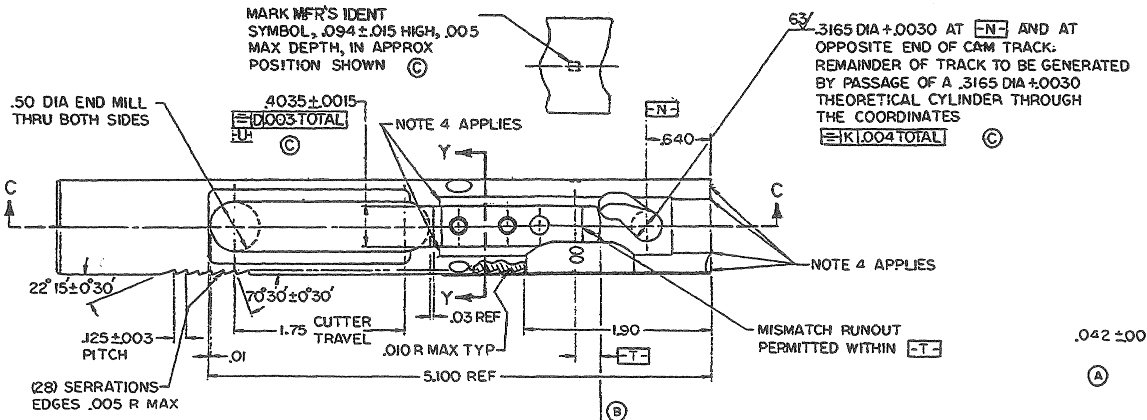
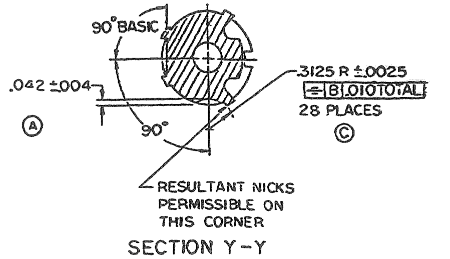
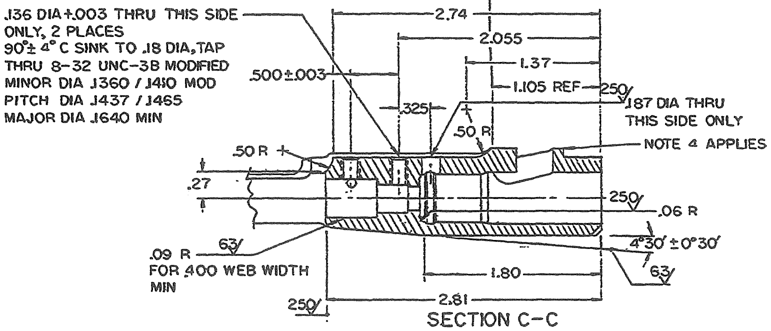
THIS DOCUMENT WILL BE DISPOSED OF IN ACCORDANCE WITH INSTRUCTIONS ISSUED BY THE RESPONSIBLE CONTRACTING OFFICER UPON COMPLETION OF THE PURPOSE FOR WHICH IT WAS ISSUED.

NOTES:
1. STEEL, AISI 8620, GUN QUALITY, COLD DRAWN, STRAIN RELIEVED BAR MAX BRINELL HARDNESS 241 AIM FOR 217/229.
2. FINISH 125 EXCEPT AS NOTED.
3. FILLET RADII .010 EXCEPT AS NOTED. Ⓑ
4. .015 EDGE BREAK AT POINTS INDICATED.
5. SUGGESTED HEAT TREAT PROCEDURE: STRAIN RELIEVE AT 850°F FOR ONE HOUR. LIQUID CARBURIZE AT 1550°F FOR ONE HOUR 20 MIN APPROX. TOTAL CASE DEPTH REALIZED MUST BE .010/.015. OIL QUENCH. SUGGESTED DRAW TEMP 350/375°F AT HEAT FOR ONE HOUR.
6. FINISH 1.2.2.2 OF MIL-STD-171, FILM THICKNESS .0002/.0003 ON SURFACES INDICATED. Ⓒ
7. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT SURFACES WITH 1.2.2.2 FINISH (SEE NOTE 6).
8. ALL DIMENSIONS APPLY BEFORE FINISH.
9. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓐ
10. MIL-W-13855 APPLIES. Ⓑ

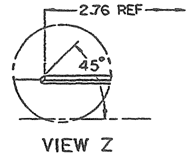

MARK MFR'S IDENT SYMBOL, .094±.015 HIGH, .005 MAX DEPTH, IN APPROX POSITION SHOWN Ⓒ
.50 DIA END MILL THRU BOTH SIDES
.4035±.0015
-U- .003 TOTAL Ⓒ
NOTE 4 APPLIES
-N-
.640
.3165 DIA +.0030 AT -N- AND AT OPPOSITE END OF CAM TRACK: REMAINDER OF TRACK TO BE GENERATED BY PASSAGE OF A .3165 DIA +.0030 THEORETICAL CYLINDER THROUGH THE COORDINATES
K .004 TOTAL Ⓒ
63
C
C
Y
Y
NOTE 4 APPLIES
22°15'±0°30'
7°30'±0°30'
.03 REF
.125±.003 PITCH
.01
1.75 CUTTER TRAVEL
.010 R MAX TYP
1.90
-T-
MISMATCH RUNOUT PERMITTED WITHIN -T-
(28) SERRATIONS EDGES .005 R MAX
5.100 REF
Ⓑ


90° BASIC
.042±.004
Ⓐ
90°
.3125 R ±.0025
B .010 TOTAL
28 PLACES
Ⓒ
RESULTANT NICKS PERMISSIBLE ON THIS CORNER

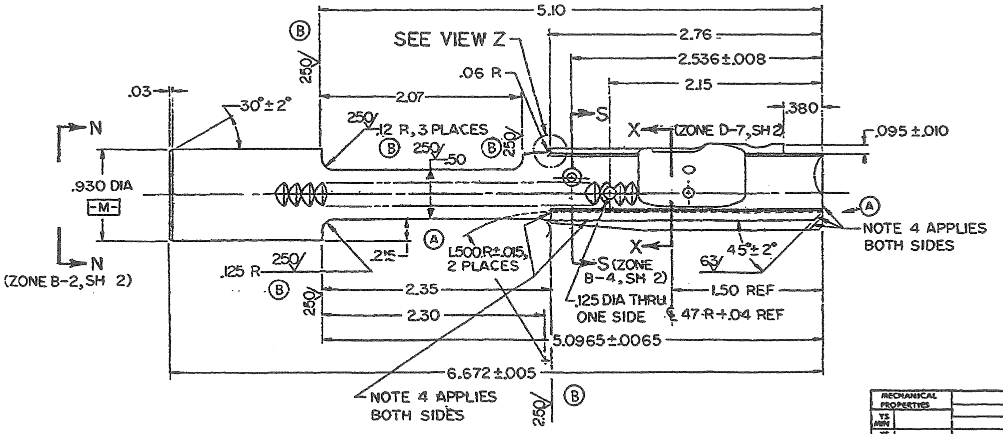
SECTION Y-Y

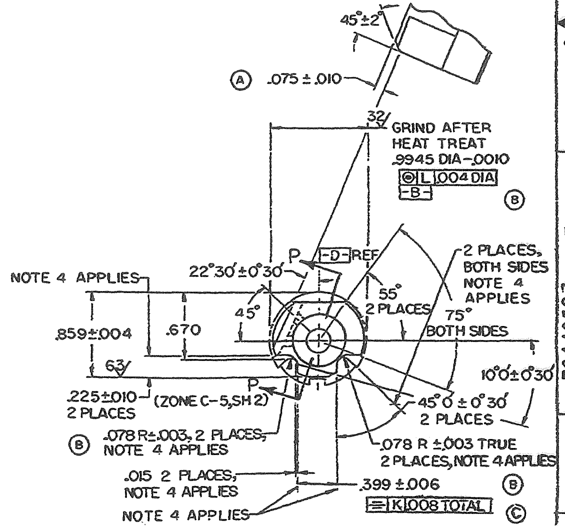

.136 DIA +.003 THRU THIS SIDE ONLY, 2 PLACES 90°±4°C SINK TO .18 DIA, TAP THRU 8-32 UNC-3B MODIFIED MINOR DIA .1360/.1410 MOD PITCH DIA .1437/.1465 MAJOR DIA .1640 MIN
2.74
2.055
1.37
1.105 REF
250
.187 DIA THRU THIS SIDE ONLY
NOTE 4 APPLIES
.500±.003
.325
.50 R
.50 R
.27
250
.06 R
.09 R FOR .400 WEB WIDTH MIN
63
4°30'±0°30'
63
1.80
2.81
250

SECTION C-C



VIEW Z
ALTERNATE METHOD


5.10
Ⓑ
250
SEE VIEW Z
2.76
.06 R
2.536±.008
2.07
2.15
.03
30°±2°
.380
N
N
250
.12 R, 3 PLACES
Ⓑ 250 .50
Ⓑ 250
S
X
(ZONE D-7, SH 2)
.095±.010
.930 DIA
-M-
Ⓐ
NOTE 4 APPLIES BOTH SIDES
(ZONE B-2, SH 2)
.125 R
250
.215
Ⓐ
1.500 R±.015, 2 PLACES
S (ZONE B-4, SH 2)
X
63
45°±2°
Ⓑ
250
2.35
1.50 REF
2.30
.125 DIA THRU ONE SIDE
.47 R±.04 REF
5.0965±.0065
6.672±.005
NOTE 4 APPLIES BOTH SIDES
250 Ⓑ


45°±2°
Ⓐ .075±.010
32
GRIND AFTER HEAT TREAT .9945 DIA -.0010
L .004 DIA
-B-
Ⓑ
P
-D- REF
NOTE 4 APPLIES
22°30'±0°30'
55°
2 PLACES
2 PLACES, BOTH SIDES NOTE 4 APPLIES
45°
75°
BOTH SIDES
.859±.004
.670
63
10°0'±0°30'
P
.225±.010 2 PLACES
(ZONE C-5, SH 2)
45°0'±0°30' 2 PLACES
Ⓑ .078 R±.003, 2 PLACES, NOTE 4 APPLIES
.078 R ±.003 TRUE 2 PLACES, NOTE 4 APPLIES
.015 2 PLACES, NOTE 4 APPLIES
.399±.006
Ⓑ
K .008 TOTAL
Ⓒ
NOTE 4 APPLIES

REVISIONS					
INF	ZONE	LTR	DESCRIPTION	DATE	APPROVAL
			REDRAWN FROM COLT'S DRAWING J62274 REV E	27 APR 70	
		A	(5) SEE EO MPD 02197-3	15 JULY 70	
		B	(11) SEE EO MQR 10632	20 FEB 71	
		C	(5) SEE ERR MQR 20778	6 OCT 72	
		D	SEE ERR MQR 50504	5 FEB 75	
		E	NOR W2S0026 82-05-21	83-02-08	
		F	NOR G0S3109 900705	901106	
		G	NOR G1S2018/910708	911011	RR
		H	NOR G2S3059/920716 (ECR G2S3060/920630)	92-08-11	AJL
		J	NOR G5S3118 / 960117	960229	FET
		K	NOR L9S3040 000106	000217	RLV

CURRENT DESIGN ACTIVITY FSCM NO. 19200

REV STATUS OF SHT'S	
SH 1	SH 2
K	K

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448505	M4
BH			M16
RH	15N 89.5-91.0	8448505	M16A1, M16A2
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTES 6 & 7

CONTRACT NO:
DATE 27 APR 1970
PREPARED GR
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CARRIER, BOLT

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448507

SCALE 2/1 SHEET 1 OF 2

CD1

F8448507

AMSWE Form 403F, 29 Jul 69

October 15, 2004 11:28 AM

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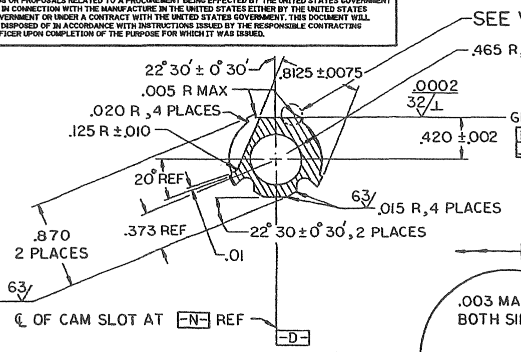
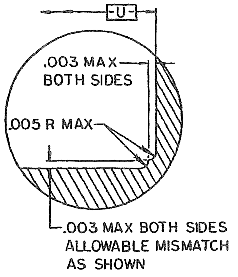
REVISIONS

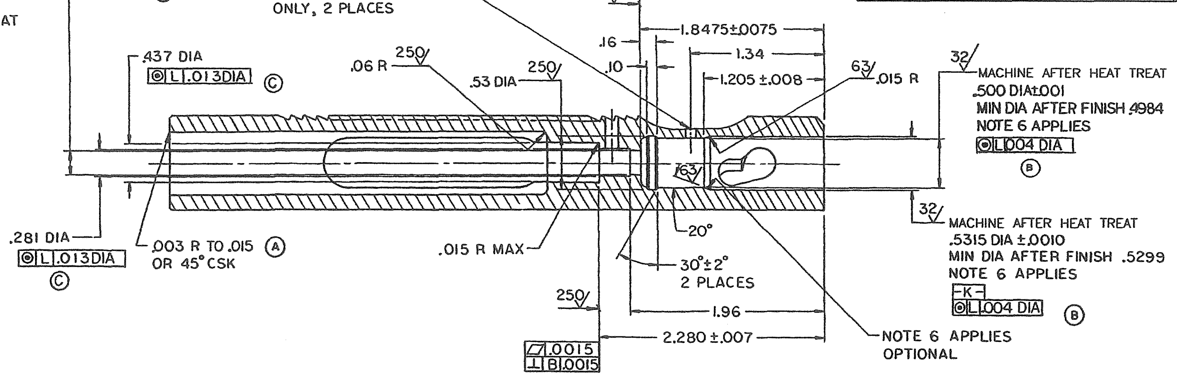
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62274 REV E	27 APR 70	
		A	(2) SEE EO HRD 02197-3	15 JULY 70	
		B	(3) SEE EO HQR 10632	20 FEB 71	
		C	(3) SEE ERR HQR 20778	6 OCT 72	RC
		D	NO CHANGE	5 FEB 75	RC
		E	NOR W2S 0026 82-05-21	83-02-03	R Hull
		H	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL
		K	NOR L9S3040 000106	000217	RLV


SEE VIEW V
.465 R, BOTH SIDES
22° 30' ± 0° 30'
.8125 ±.0075
.005 R MAX
.0002
32/⊥
.020 R, 4 PLACES
GRIND AFTER HEAT TREAT
.125 R ±.010
.420 ±.002
∥ B .002
⊥ D .001
20° REF
63/ .015 R, 4 PLACES
.870
2 PLACES
.373 REF
22° 30 ± 0° 30', 2 PLACES
.01
63/
℄ OF CAM SLOT AT -N- REF
-D-

SECTION X - X
(SH 1, ZONE B - 4)

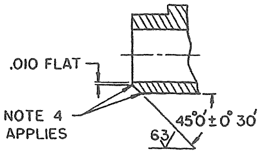

-U-
.003 MAX
BOTH SIDES
.005 R MAX
.003 MAX BOTH SIDES
ALLOWABLE MISMATCH
AS SHOWN

VIEW V
SCALE: 50/1

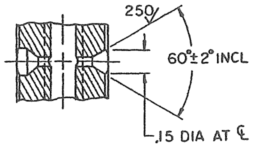

32/
MACHINE AFTER HEAT TREAT
.2523 DIA ±.0003
MIN DIA AFTER FINISH .2514
NOTE 6 APPLIES
-L-
Ⓑ
.109 DIA THRU ONE SIDE ONLY, 2 PLACES
250/
.437 DIA
◎ L .013 DIA Ⓒ
.06 R
250/
.53 DIA
250/
.16
.10
1.8475 ±.0075
1.34
1.205 ±.008
63/ .015 R
32/
MACHINE AFTER HEAT TREAT
.500 DIA ±.001
MIN DIA AFTER FINISH .4984
NOTE 6 APPLIES
◎ L .004 DIA Ⓑ
63/
20°
.281 DIA
◎ L .013 DIA Ⓒ
.003 R TO .015 OR 45° CSK Ⓐ
.015 R MAX
30° ± 2°
2 PLACES
32/
MACHINE AFTER HEAT TREAT
.5315 DIA ±.0010
MIN DIA AFTER FINISH .5299
NOTE 6 APPLIES
-K-
◎ L .004 DIA Ⓑ
250/
1.96
2.280 ±.007
⏥ .0015
⊥ B .0015
NOTE 6 APPLIES
OPTIONAL

SECTION W - W
ROTATED 90° CCW

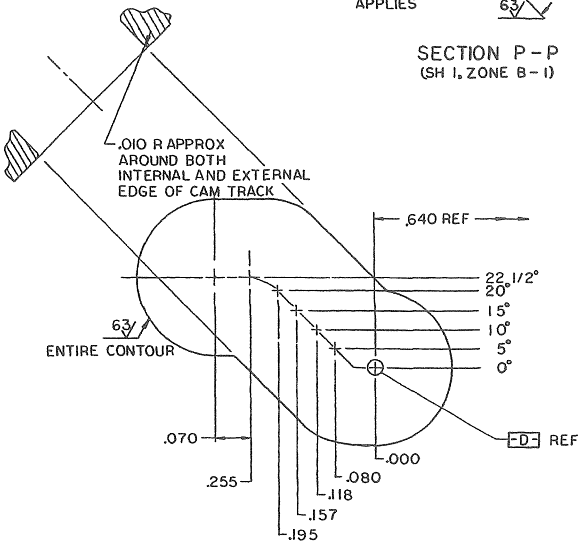
ANGLE BASIC	ADVANCE ±.002
0	.042
1/4	.044
1/2	.046
1	.050
1 1/2	.053
2	.057
2 1/2	.061
3	.065
3 1/2	.069
4	.073
4 1/2	.076
5	.080
5 1/2	.084
6	.088
6 1/2	.092
7	.096
7 1/2	.099
8	.103
8 1/2	.107
9	.111
9 1/2	.114
10	.118
10 1/2	.122
11	.126
11 1/2	.130
12	.134
12 1/2	.137
13	.141
13 1/2	.145
14	.149
14 1/2	.153
15	.157
15 1/2	.161
16	.164
16 1/2	.168
17	.172
17 1/2	.175
18	.179
18 1/2	.183
19	.187
19 1/2	.190
20	.195
20 1/2	.200
21	.207
21 1/2	.214
22	.226
22 1/4	.235
22 1/2	.255

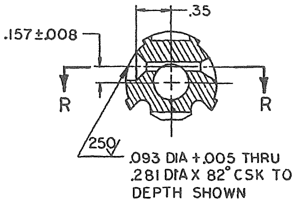

.010 FLAT
NOTE 4 APPLIES
45° 0' ± 0° 30'
63/

SECTION P - P
(SH 1, ZONE B - 1)

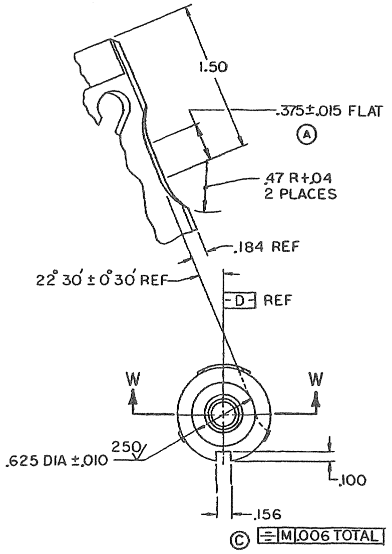

250/
60° ± 2° INCL
.15 DIA AT ℄

SECTION R - R


.010 R APPROX
AROUND BOTH
INTERNAL AND EXTERNAL
EDGE OF CAM TRACK
.640 REF
22 1/2°
20°
15°
10°
5°
0°
63/
ENTIRE CONTOUR
-D- REF
.070
.255
.000
.080
.118
.157
.195


.35
.157 ±.008
R
R
250/
.093 DIA +.005 THRU
.281 DIA X 82° CSK TO
DEPTH SHOWN

SECTION S - S
(SH 1, ZONE B - 5)


1.50
.375 ±.015 FLAT
Ⓐ
.47 R ±.04
2 PLACES
.184 REF
22° 30' ± 0° 30' REF
-D- REF
W
W
250/
.625 DIA ±.010
.100
.156
Ⓒ ⌯ M .006 TOTAL

VIEW N - N
(SH 1, ZONE B - 7)

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

CURRENT DESIGN ACTIVITY FSCM NO. 19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL ———

FINAL PROTECTIVE FINISH ———

CONTRACT NO.

DATE 27 APR 1970
PREPARED G.R.
CHECKED A. J. H. D. Krolak
ENGINEER D. Billet
SUBMITTED
APPROVED R. S. Henry

CARRIER, BOLT

SIZE F
CODE IDENT NO. 19204
DRAWING NO. 8448507
SCALE 2/1
SHEET 2 OF 2
CDI

F8448507

October 18, 2004 10:54 AM

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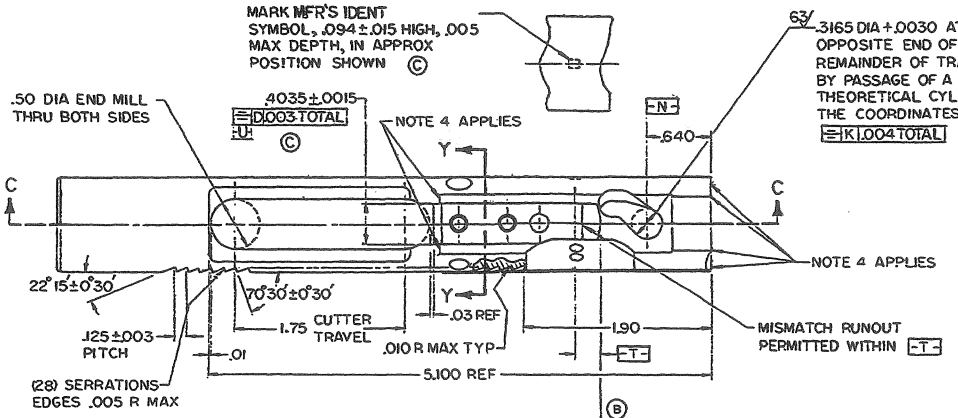
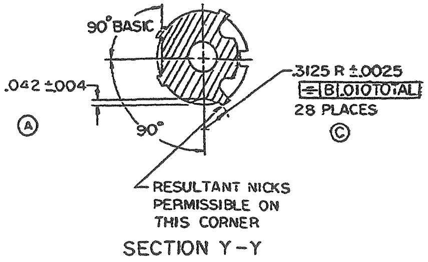
NOTES:

1. STEEL, AISI 8620, GUN QUALITY, COLD DRAWN, STRAIN RELIEVED BAR MAX BRINELL HARDNESS 241. AIM FOR 217/229.
2. FINISH 125/ EXCEPT AS NOTED.
3. FILLET RADII .010 EXCEPT AS NOTED. Ⓑ
4. .015 EDGE BREAK AT POINTS INDICATED.
5. SUGGESTED HEAT TREAT PROCEDURE: STRAIN RELIEVE AT 850°F FOR ONE HOUR. LIQUID CARBURIZE AT 1550°F FOR ONE HOUR 20 MIN APPROX. TOTAL CASE DEPTH REALIZED MUST BE .010/.015. OIL QUENCH. SUGGESTED DRAW TEMP 350/375°F AT HEAT FOR ONE HOUR.
6. FINISH 1.2.2.2 OF MIL-STD-171, FILM THICKNESS .0002/.0003 ON SURFACES INDICATED. Ⓒ
7. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT SURFACES WITH 1.2.2.2 FINISH (SEE NOTE 6).
8. ALL DIMENSIONS APPLY BEFORE FINISH.
9. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓐ
10. MIL-W-13855 APPLIES. Ⓑ

REVISIONS					
INF	ZONE	LTR	DESCRIPTION	DATE	APPROVAL
			REDRAWN FROM COLT'S DRAWING J62274 REV E	27 APR 70	
		A	(5) SEE EO MPD 02197-3	15 JULY 70	
		B	(11) SEE EO HQR 10632	20 FEB 71	
		C	(5) SEE ERR HQR 20778	6 OCT 72	
		D	SEE ERR HQR 50504	5 FEB 75	RC
		E	NOR W2S0026 82-05-21	83-02-03	
		F	NOR G0S3109 900705	901106	
		G	NOR G1S2018/910708	911011	RR 92
		H	NOR G2S3059/920716 (ECR G2S3060/920630)	92-08-11	AJL
		J	NOR G5S3118 / 960117	960229	FET
		K	NOR L9S3040 000106	000217	RLV

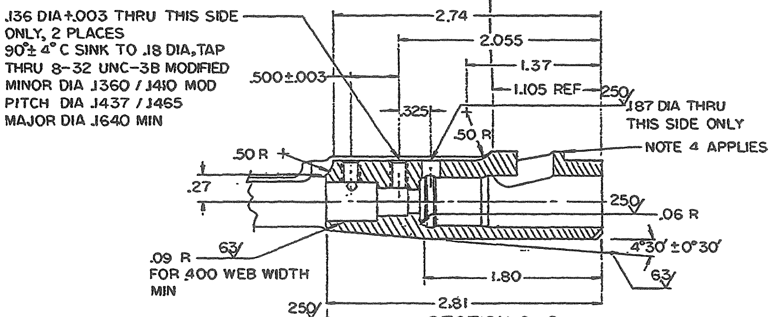


MARK MFR'S IDENT SYMBOL, .094±.015 HIGH, .005 MAX DEPTH, IN APPROX POSITION SHOWN Ⓒ
.50 DIA END MILL THRU BOTH SIDES
.4035±.0015
D .003 TOTAL
U
Ⓒ
NOTE 4 APPLIES
Y
C
N
.640
63/
.3165 DIA+.0030 AT N AND AT OPPOSITE END OF CAM TRACK: REMAINDER OF TRACK TO BE GENERATED BY PASSAGE OF A .3165 DIA+.0030 THEORETICAL CYLINDER THROUGH THE COORDINATES
K .004 TOTAL Ⓒ
NOTE 4 APPLIES
22°15'±0°30'
7°30'±0°30'
.03 REF
1.75 CUTTER TRAVEL
.125±.003 PITCH
.01
.010 R MAX TYP
1.90
T
MISMATCH RUNOUT PERMITTED WITHIN T
(28) SERRATIONS EDGES .005 R MAX
5.100 REF
Ⓑ



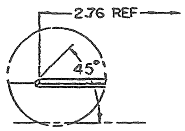
90° BASIC
.042±.004
Ⓐ
90°
.3125 R±.0025
B .010 TOTAL
28 PLACES
Ⓒ
RESULTANT NICKS PERMISSIBLE ON THIS CORNER

SECTION Y-Y

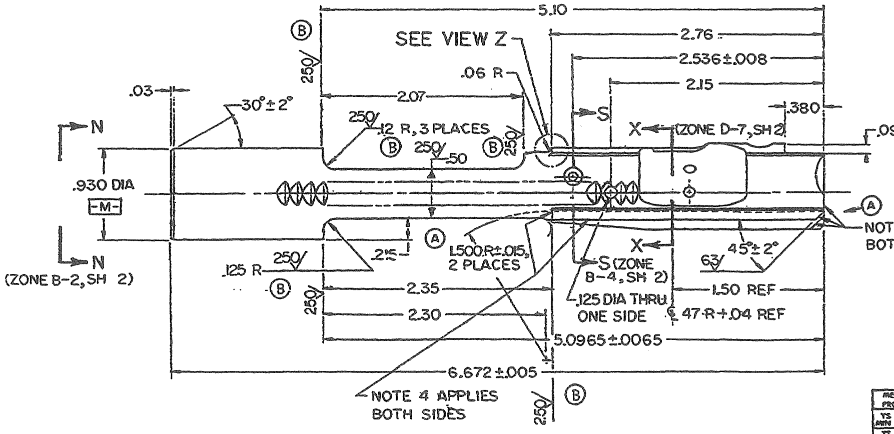


.136 DIA+.003 THRU THIS SIDE ONLY, 2 PLACES 90°±4° C SINK TO .18 DIA, TAP THRU 8-32 UNC-3B MODIFIED MINOR DIA .1360/.1410 MOD PITCH DIA .1437/.1465 MAJOR DIA .1640 MIN
2.74
2.055
1.37
1.105 REF
250/
.187 DIA THRU THIS SIDE ONLY
NOTE 4 APPLIES
.500±.003
.325
.50 R
.50 R
.27
250/
.06 R
4°30'±0°30'
.09 R FOR .400 WEB WIDTH MIN
63/
1.80
63/
2.81
250/

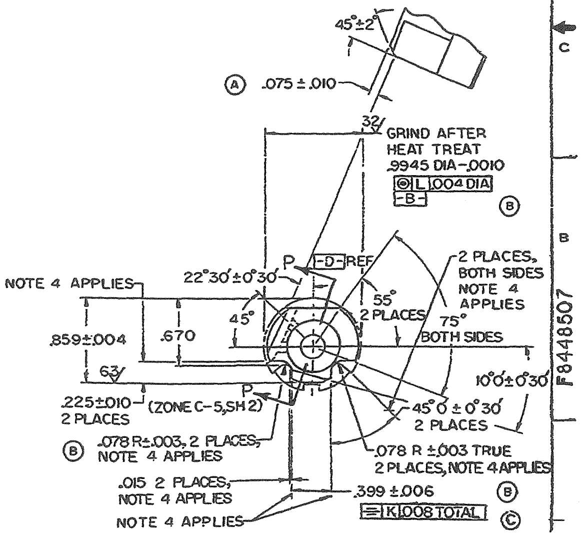
SECTION C-C



VIEW Z
ALTERNATE METHOD



5.10
Ⓑ
250/
SEE VIEW Z
2.76
2.536±.008
.06 R
2.07
2.15
.380
.03
30°±2°
250/
.12 R, 3 PLACES
Ⓑ 250/
Ⓑ
.50
S
X (ZONE D-7, SH 2)
.095±.010
N
.930 DIA
M
Ⓐ
Ⓐ
NOTE 4 APPLIES BOTH SIDES
N
(ZONE B-2, SH 2)
.125 R
Ⓑ
250/
.215
1.500 R±.015, 2 PLACES
S (ZONE B-4, SH 2)
X
63/
45°±2°
2.35
.125 DIA THRU ONE SIDE
1.50 REF
2.30
.47 R+.04 REF
250/
5.0965±.0065
6.672±.005
Ⓑ
NOTE 4 APPLIES BOTH SIDES
250/
Ⓑ



45°±2°
Ⓐ .075±.010
32/
GRIND AFTER HEAT TREAT .9945 DIA-.0010
L .004 DIA
B
Ⓑ
NOTE 4 APPLIES
22°30'±0°30'
P
D REF
2 PLACES, BOTH SIDES NOTE 4 APPLIES
55° 2 PLACES
75° BOTH SIDES
45°
.859±.004
.670
63/
10°0'±0°30'
P
.225±.010 2 PLACES
(ZONE C-5, SH 2)
45°0'±0°30' 2 PLACES
Ⓑ .078 R±.003, 2 PLACES, NOTE 4 APPLIES
.078 R±.003 TRUE 2 PLACES, NOTE 4 APPLIES
.015 2 PLACES, NOTE 4 APPLIES
.399±.006
Ⓑ
K .008 TOTAL
Ⓒ
NOTE 4 APPLIES

CURRENT DESIGN ACTIVITY FSCM NO. 19200

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY 92-06-22.

REV STATUS OF SHTS	
SH 1	SH 2
K	K

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ±1° 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO:
YS MIN					DATE 27 APR 1970
YS MAX				MATERIAL SEE NOTE 1	PREPARED G.R.
EL2					CHECKED D. Kolak
RA		8448505 - M4			ENGINEER D. Elliott
BH			M16		SUBMITTED
BH	15N 89.5-91.0	8448505	M16A1, M16A2	FINAL PROTECTIVE FINISH SEE NOTES 6 & 7	APPROVED R. S. Hennig
		NEXT ASSY	USED ON		
		APPLICATION			

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CARRIER, BOLT

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448507

SCALE 2/1 SHEET 1 OF 2

CDI

F8448507

AMSWE Form 403F, 29 Jul 69

October 18, 2004 10:54 AM

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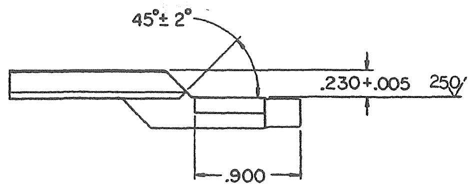
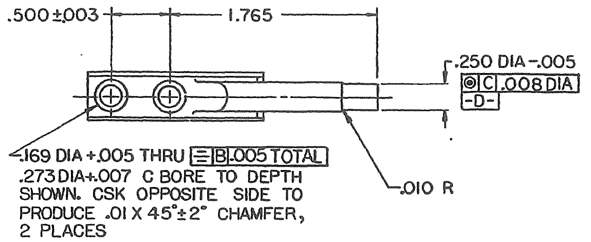
NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT PROCEDURE: OIL QUENCH FROM 1575°F. TEMPER AT 1100°F FOR 1 HOUR.
3. FINISH 1.22.2 OF MIL-STD-171 ON DIA -A- AND -C-. FILM THICKNESS .0002/.0003.
4. ALL OTHER SURFACES TO RECEIVE FINISH 5.3.1.2 OF MIL-STD-171.
5. BREAK SHARP EDGES .005+.010.
6. MIL-W-13855 APPLIES.
7. FOR GAGING PURPOSED ONLY. THE DEPTH OF PENETRATION OF A .1158 -.0002 GAGE PIN SHALL BE 1.100 MIN TO 1.135 MAX.



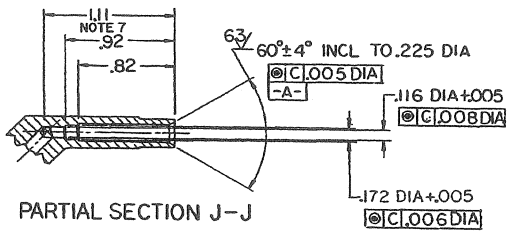
45°± 2°
.230+.005 250/
.900



.500±.003
1.765
.250 DIA-.005
◎ C .008 DIA
-D-
.169 DIA+.005 THRU ⌯ B .005 TOTAL
.273 DIA+.007 C BORE TO DEPTH SHOWN. CSK OPPOSITE SIDE TO PRODUCE .01 X 45°±2° CHAMFER, 2 PLACES
.010 R

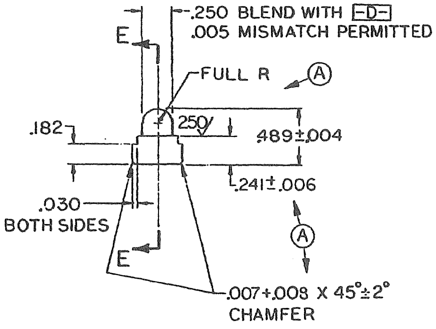
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D61547 REV D	27APR70	
		A	(8) SEE EO HQR 1C631	20 FEB 71	
		B	(7) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	SEE ERR HQR 50604	5 FEB 75	R.E.
		D	NOR W280026 82-05-21	83-02-08	
		E	ERR Z971295F (ECP G0S3110/900709)	901108	VJSI SES
		F	NOR G0S3166/901011	910130	PF SR
		G	NOR G1S2018 910708	91-10-11	RE
		H	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL
		J	NOR G6S3142 961024	961215	JB

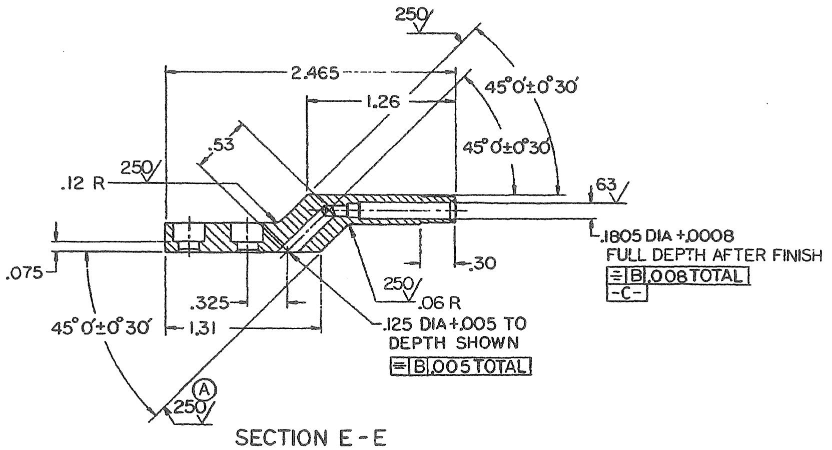


1.11
NOTE 7
.92
.82
63/
60°±4° INCL TO .225 DIA
◎ C .005 DIA
-A-
.116 DIA+.005
◎ C .008 DIA
.172 DIA+.005
◎ C .006 DIA

PARTIAL SECTION J-J

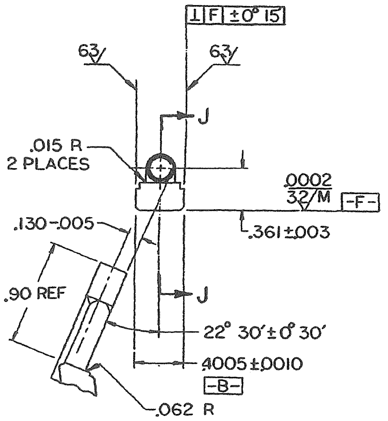


E
.250 BLEND WITH -D-
.005 MISMATCH PERMITTED
FULL R
Ⓐ
.182
250/
.489±.004
.241±.006
.030
BOTH SIDES
Ⓐ
E
.007+.008 X 45°±2°
CHAMFER



250/
2.465
45°0'±0°30'
1.26
.53
45°0'±0°30'
250/
.12 R
63/
.1805 DIA +.0008
FULL DEPTH AFTER FINISH
⌯ B .008 TOTAL
-C-
.075
.30
250/
.06 R
.325
45°0'±0°30'
1.31
.125 DIA+.005 TO DEPTH SHOWN
⌯ B .005 TOTAL
Ⓐ
250/

SECTION E-E



⊥ F ±0° 15'
63/
63/
J
.015 R
2 PLACES
.0002
32/M
-F-
.361±.003
.130-.005
.90 REF
J
22° 30'±0°30'
.4005±.0010
-B-
.062 R

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES					
YS MIN					
YS MAX					
EL 2					
RA		8448505	M4 M16A2		
BH			M16		
RH	C26-32	C8448505	M16A1		
		NEXT ASSY	USED ON		
		APPLICATION			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
STEEL, AISI 4130
GUN QUALITY
MAX BHN 229

FINAL PROTECTIVE FINISH
SEE NOTES 3 & 4

CONTRACT NO:
DATE 27 APR 1970
PREPARED MC
CHECKED
ENGINEER
SUBMITTED F.R.
APPROVED R.S. Kenny

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

KEY,
BOLT CARRIER

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448506

SCALE 2/1 SHEET OF

CD1

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AMSWE Form 403D, 29 Jul 69

October 18, 2004 10:54 AM

D8448506

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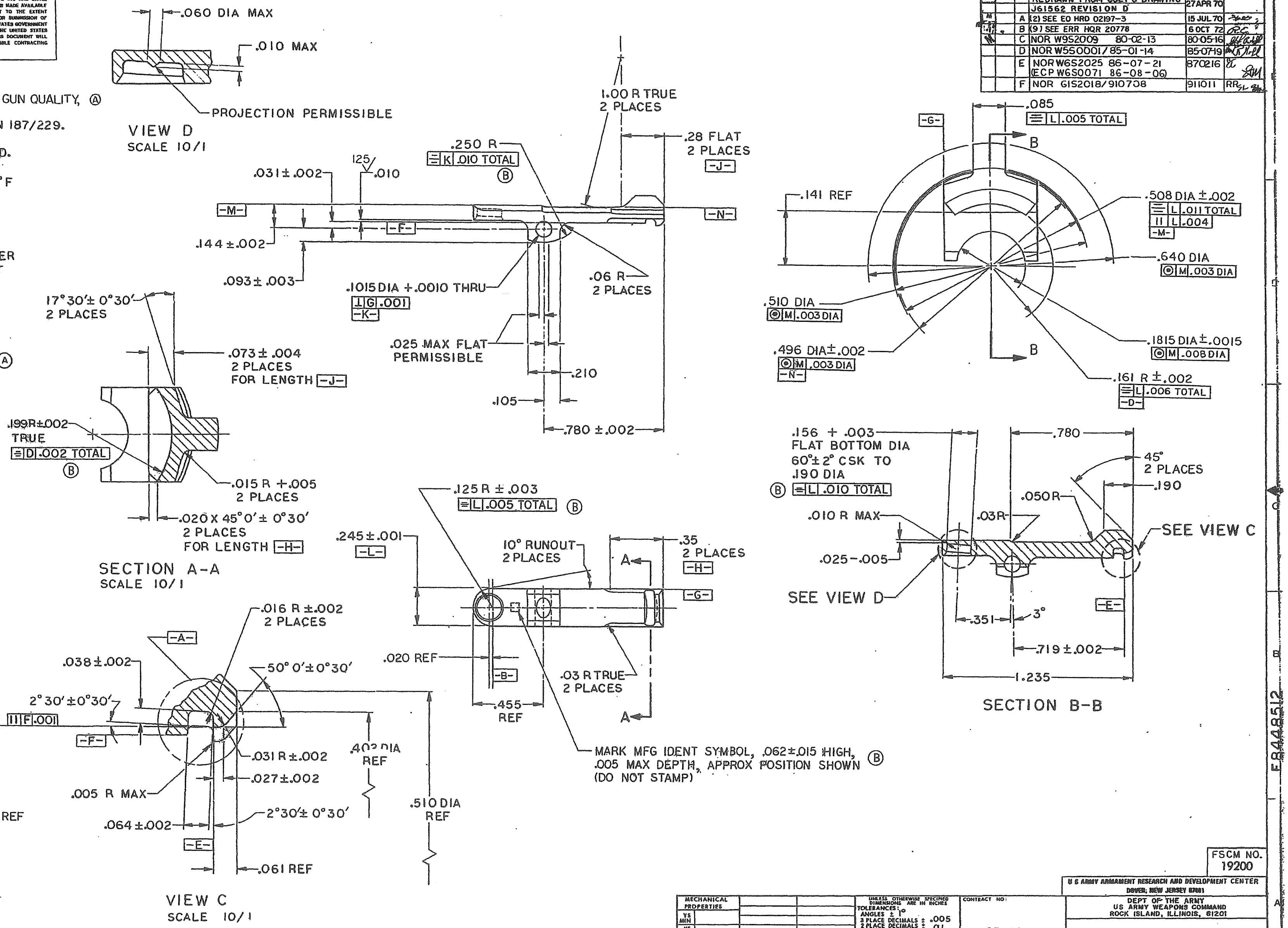
G	NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL SA

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J61562 REVISION D	27APR 70	
		A	(2) SEE EO HRD 02197-3	15 JUL 70	
		B	(9) SEE ERR HQR 20778	6 OCT 72	R.C.
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W5S0001/85-01-14	85-07-19	
		E	NOR W6S2025 86-07-21 (ECP W6S0071 86-08-06)	870216	
		F	NOR G1S2018/910708	911011	RR

NOTES:

1. STEEL, AISI 4140 OR AISI 4340, GUN QUALITY, Ⓐ ANNEALED, COLD DRAWN AND STRESS RELIEVED BHN 187/229.
2. FINISH $\overset{63}{\surd}$ EXCEPT AS NOTED.
3. AUSTEMPER SUGGESTED PROCEDURE: HEAT TO 1550°F IN NEUTRAL SALT BATH. TRANSFER TO 680°F SALT BATH. HOLD 20 TO 25 MIN. AIR COOL.
4. SHOT PEEN AREA -A- AFTER HEAT TREAT WITH S70 SHOT .006 TO .008A2 INTENSITY IN ACCORDANCE WITH MIL-S-13165 (SCATTER PEENING PERMISSIBLE FOR REMAINDER OF PART).
5. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓐ
6. START OF 10° RUNOUT Ⓑ SHALL BE LOCATED BY .125 R(LOCATED ON -B-) INTERSECTION WITH SURFACE -L-.
7. MIL-W-13855 APPLIES.


.060 DIA MAX
.010 MAX
PROJECTION PERMISSIBLE
VIEW D
SCALE 10/1
1.00 R TRUE
2 PLACES
.28 FLAT
2 PLACES
-J-
.250 R
≡ K .010 TOTAL
Ⓑ
125/ .010
.031±.002
-M-
-F-
-N-
.144±.002
.093±.003
.1015 DIA +.0010 THRU
⊥ G .001
-K-
.06 R
2 PLACES
.025 MAX FLAT
PERMISSIBLE
.210
.105
.780±.002
17°30'± 0°30'
2 PLACES
.073±.004
2 PLACES
FOR LENGTH -J-
.199R±.002
TRUE
≡ D .002 TOTAL
Ⓑ
.015 R +.005
2 PLACES
.020 X 45°0'± 0°30'
2 PLACES
FOR LENGTH -H-
SECTION A-A
SCALE 10/1
.125 R ± .003
≡ L .005 TOTAL
Ⓑ
.245±.001
-L-
10° RUNOUT
2 PLACES
.35
2 PLACES
-H-
-G-
A
A
.020 REF
-B-
.455
REF
.03 R TRUE
2 PLACES
MARK MFG IDENT SYMBOL, .062±.015 HIGH, .005 MAX DEPTH, APPROX POSITION SHOWN (DO NOT STAMP) Ⓑ
.016 R ±.002
2 PLACES
-A-
.038±.002
50° 0'±0°30'
2°30'±0°30'
// F .001
-F-
.031 R±.002
.027±.002
.402 DIA
REF
.005 R MAX
.161 R REF
.064±.002
2°30'± 0°30'
.510 DIA
REF
-E-
.061 REF
VIEW C
SCALE 10/1
.085
≡ L .005 TOTAL
-G-
B
B
.141 REF
.508 DIA ±.002
≡ L .011 TOTAL
// L .004
-M-
.640 DIA
◎ M .003 DIA
.510 DIA
◎ M .003 DIA
.1815 DIA ±.0015
◎ M .008 DIA
.496 DIA±.002
◎ M .003 DIA
-N-
.161 R ±.002
≡ L .006 TOTAL
-D-
.156 + .003
FLAT BOTTOM DIA
60°±2° CSK TO
.190 DIA
Ⓑ ≡ L .010 TOTAL
.780
45°
2 PLACES
.190
.050R
.010 R MAX
.03R
SEE VIEW C
.025-.005
SEE VIEW D
-E-
.351
3°
.719±.002
1.235
SECTION B-B

FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		8448509	M4
EL 2		C9329703	M231
RA			
BH			M16
RH	C42-44	C8448509	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:
DATE 27APR 1970
PREPARED
CHECKED a. J. A. D. Krolak
ENGINEER D. Gillet
SUBMITTED
APPROVED R.S. Henry

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

EXTRACTOR

SIZE F
CODE IDENT NO. 19204
DRAWING NO. 8448512
SCALE 4/1
SHEET 1 OF 1

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

AMSWE Form 403F, 29 Jul 69

CDI

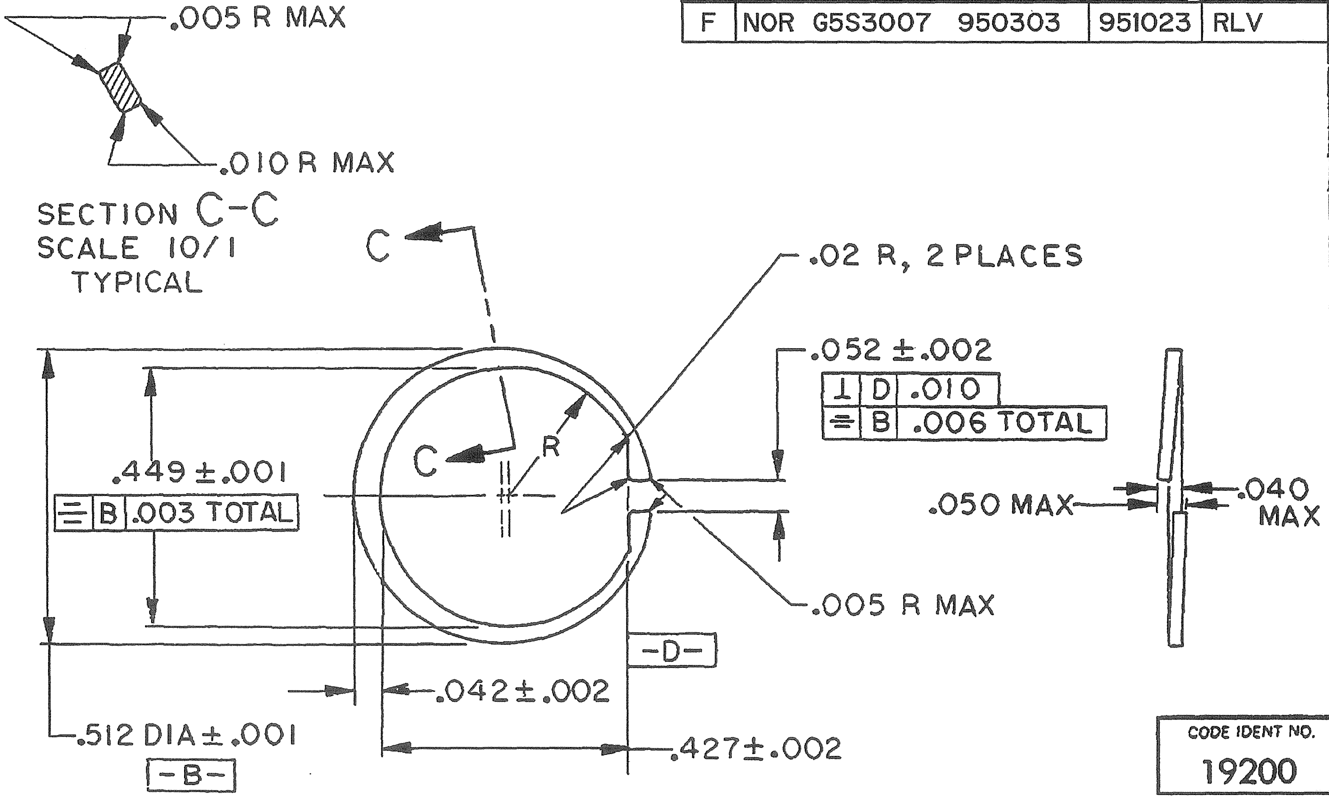
F8448512

October 13, 2004 2:52 PM

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F	NOR G5S3007 950303	951023	RLV

NOTE:

1. STEEL, CORROSION-RESISTANT, PER AMS 5906 OR 5913, THICKNESS .016±.001.
2. FINISH $\overset{125}{\surd}$ EXCEPT AS NOTED IN NOTE 4.
3. EDGES TO BE SHARP TO .005 R MAX.
4. MAX DIE BREAK ON $\boxed{-B-}$ TO BE 50%. FINISH ON SHEARED SURFACE TO BE $\overset{63}{\surd}$.
5. FINISH 5.4.1 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



.005 R MAX
.010 R MAX
SECTION C-C
SCALE 10/1
TYPICAL
C
C
R
.02 R, 2 PLACES
.052±.002
⊥ D .010
⌯ B .006 TOTAL
.449±.001
⌯ B .003 TOTAL
.050 MAX
.040 MAX
.005 R MAX
-D-
.042±.002
.512 DIA±.001
-B-
.427±.002

B8448511

DISTRIBUTION STATEMENT F.

FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC,AMSTA-AR-CCL-A 950610

CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN		8448509	M4
YS MAX		C9327073	M231
EL 2			M16
RA		C8448509	M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO:
DATE 27 APR 1970
PREP
CHK
ENGR
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RING, BOLT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448511

SCALE 5/1 SHEET 1 OF 1

CD1

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October 13, 2004 2:57 PM

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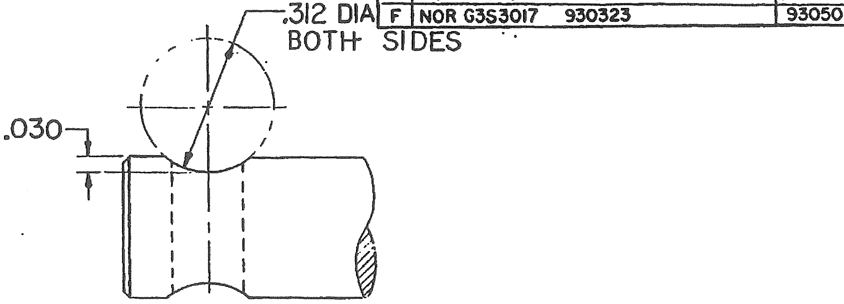
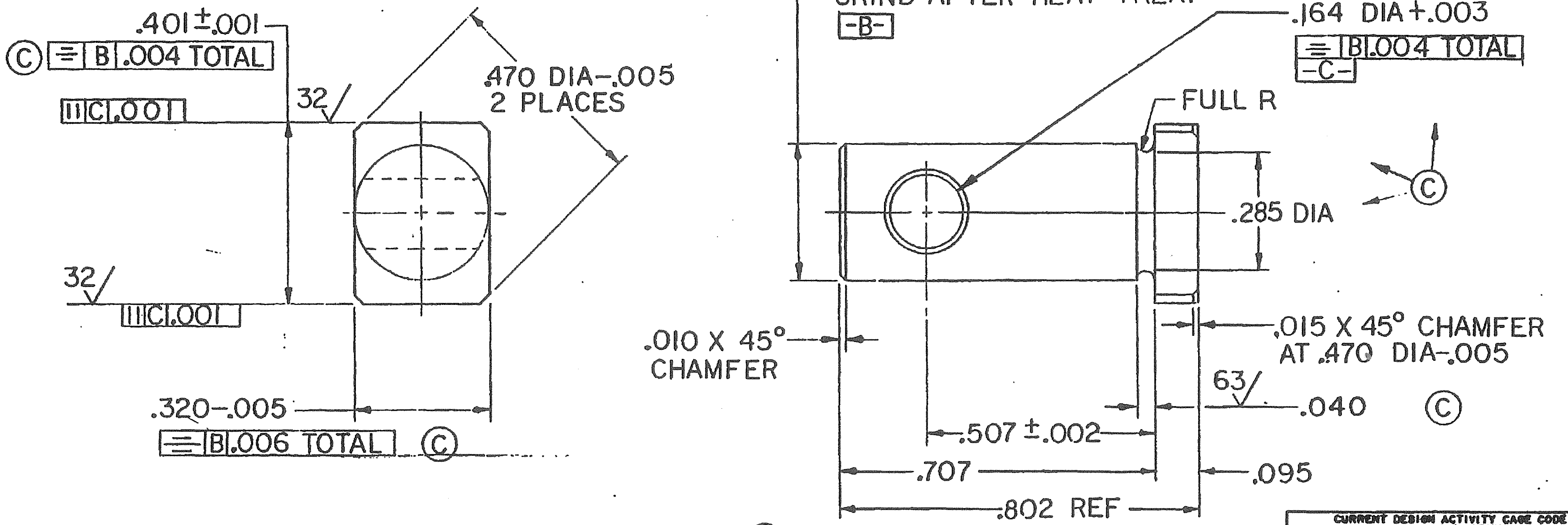
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D61704 REV A WITH CHANGE	27 APR 70	
		A	(2) SEE EO HRD 02197-3	15 JULY 70	
		B	(2) SEE HQR 10720	11 MAY 71	YB
M		C	(6) SEE ERR HQR 20778	6 OCT 72	RC
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR G1S2018 91 07 08	91-10-11	RR SL
		F	NOR G3S3017 930323	930506	CVS SR

NOTE:

1. FINISH 125√ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005+.005.
3. APPLY DRY FILM LUBRICANT MIL-L-46010. Ⓒ
   FILM THICKNESS .0002-.0004. CURE ONE HOUR AT 375° F.
   OR USE EVERLUBE 626 OR 626S, FILM THICKNESS
   .0002-.0004, CURE FOR 1 HOUR AT 375° F.
4. SUGGESTED HEAT TREATMENT:
   QUENCH IN OIL FROM 1500°F TO 1550°F. TEMPER
   AT 625°F TO 675°F FOR ONE HOUR.
5. MIL-W-13855 APPLIES.





CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

Ⓑ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		8448501	M4
RA		D9327072	M231
BH			M16
		08448501	M16A1
RH	C45-48	NEXT ASSY	USED ON
		APPLICATION	

Ⓐ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 2°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±——

MATERIAL
STEEL ALLOY E4340,
SPEC MIL-S-5000

FINAL PROTECTIVE FINISH
5.3.1.3 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970

PREPARED	PAR	a.g.H.
CHECKED		
ENGINEER		D. Billist

SUBMITTED
F. P. Yellowly

APPROVED
R. S. Henry

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
~~ROCK ISLAND~~, ILLINOIS, 61201

PIN, CAM

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448502

SCALE 5/1

C 8448502

AMSWE Form 403C, 29 Jul 69

October 13, 2004 3:00 PM

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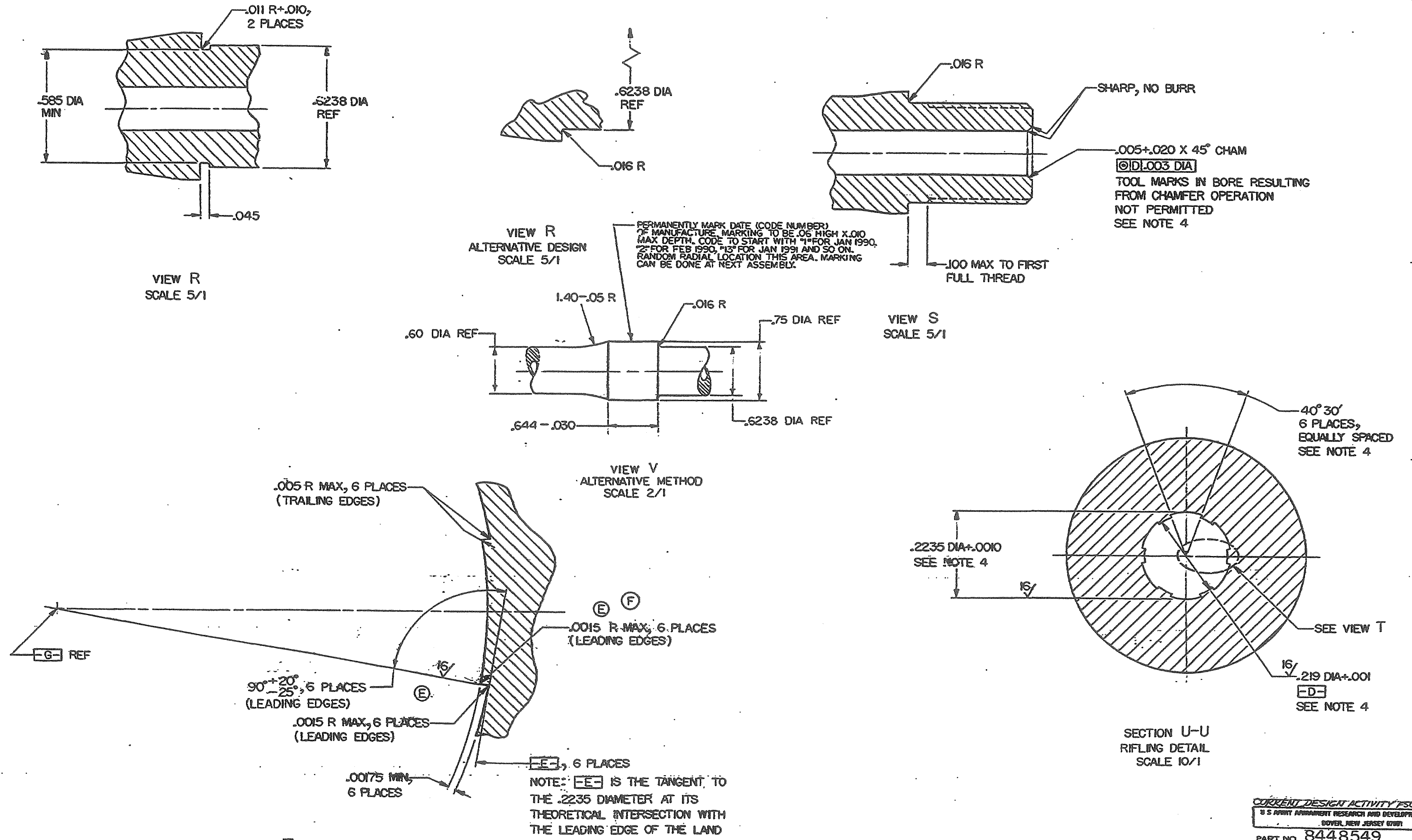
REVISIONS

INF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
[illegible]		D	REPLACES REV C W/CHANGE SEE ERR HQR 20827	14 DEC 72	ΓB
[illegible]		E	(2) SEE ERR HQR 30645	2 MAR 73	RE
[illegible]		F	(1) SEE NOR 77E0005-0000	26 JAN 77	ΓJB
		G	[illegible] 85-05-27	85-06-05	[illegible]
[illegible]		H	NOR G7S3121/870923	880928	[illegible]
		J	NOR G1S3039/910510	910512	PE [illegible]


.011 R+.010, 2 PLACES
.585 DIA MIN
.6238 DIA REF
.045
VIEW R
SCALE 5/1
.6238 DIA REF
.016 R
VIEW R
ALTERNATIVE DESIGN
SCALE 5/1
.016 R
SHARP, NO BURR
.005+.020 X 45° CHAM
◎ D .003 DIA
TOOL MARKS IN BORE RESULTING FROM CHAMFER OPERATION NOT PERMITTED
SEE NOTE 4
.100 MAX TO FIRST FULL THREAD
VIEW S
SCALE 5/1
PERMANENTLY MARK DATE (CODE NUMBER) OF MANUFACTURE. MARKING TO BE .06 HIGH X .010 MAX DEPTH. CODE TO START WITH "1" FOR JAN 1990, "2" FOR FEB 1990, "13" FOR JAN 1991 AND SO ON. RANDOM RADIAL LOCATION THIS AREA. MARKING CAN BE DONE AT NEXT ASSEMBLY.
1.40-.05 R
.016 R
.60 DIA REF
.75 DIA REF
.644-.030
.6238 DIA REF
VIEW V
ALTERNATIVE METHOD
SCALE 2/1
40° 30', 6 PLACES, EQUALLY SPACED
SEE NOTE 4
.2235 DIA+.0010
SEE NOTE 4
16
SEE VIEW T
16
.219 DIA+.001
-D-
SEE NOTE 4
SECTION U-U
RIFLING DETAIL
SCALE 10/1
.005 R MAX, 6 PLACES (TRAILING EDGES)
E
F
.0015 R MAX, 6 PLACES (LEADING EDGES)
-G- REF
16
90° +20° -25°, 6 PLACES (LEADING EDGES)
E
.0015 R MAX, 6 PLACES (LEADING EDGES)
-E-, 6 PLACES
NOTE: -E- IS THE TANGENT TO THE .2235 DIAMETER AT ITS THEORETICAL INTERSECTION WITH THE LEADING EDGE OF THE LAND
.00175 MIN, 6 PLACES

VIEW T
SCALE 100/1
NOTE 4 APPLIES TO ALL DIMENSIONS IN THIS VIEW

CURRENT DESIGN ACTIVITY FSCM No. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448549

MECHANICAL PROPERTIES		
YS MIN		
YS MAX		
EL2		
RA		
BH		
BH		
	NEXT ASSY	USED ON
	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°0'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 27 APR 70
PREPARED [illegible] P. Vacca
CHECKED A. Kolek [illegible]
ENGINEER R. Brunton R. Albe
SUBMITTED Loran F. Brunton
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BARREL

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448549

SCALE 1/1 SHEET 2 OF 2

EDITION OF 29 JUL 70 MAY BE USED.

AMSWE Form 403F, 12 NOV 70

F 8448549

October 13, 2004 3:34 PM

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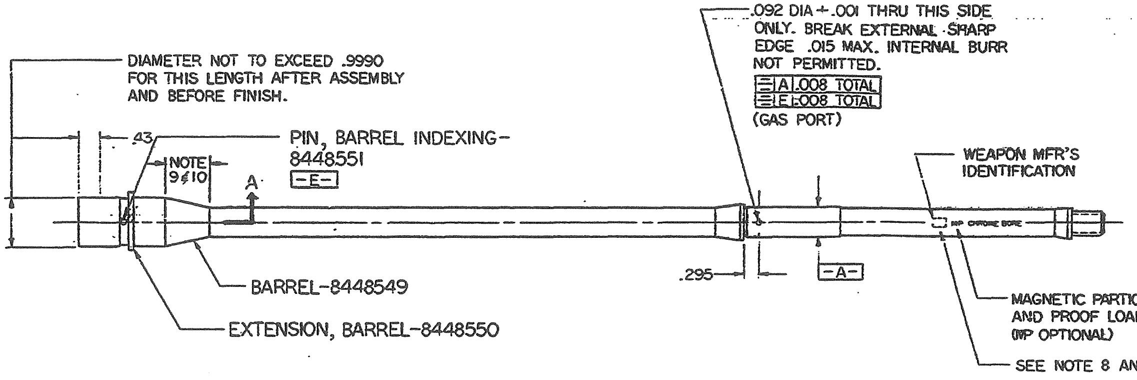
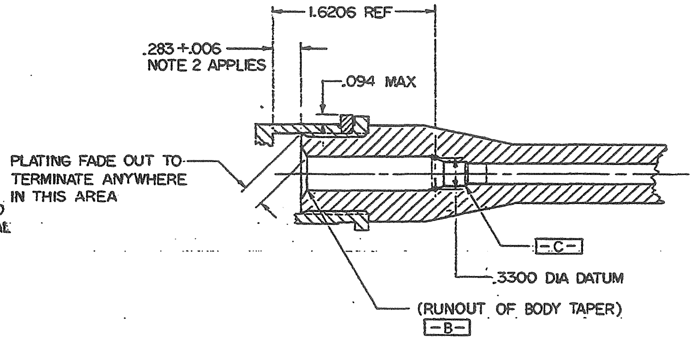
REVISIONS					
RF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		J	REPLACES REV M W/CHANGE SEE EPR MQR 3C792	10 JUN 74	
		K	SEE EPR MQR 50504	5 FEB 75	RC
		L	NOR W02500P6 [illegible]	[illegible]	
		M	NOR 67S3058/870611	880112	
		N	ERP Z9Z1182AR (ECP G8S3117 881201)	890825	

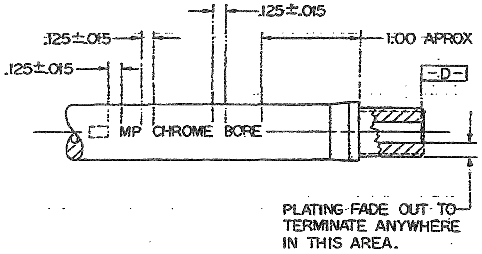
NOTES:

1. FOR FINISHED CHAMBER DIMENSIONS AFTER PLATING SEE DWG 8448649 AND SECTION A-A. FOR FINISHED BORE DIMENSIONS AFTER PLATING SEE DWG 8448549.
2. TORQUE BARREL AND BARREL EXTENSION TO 150 LB FT ± 5 LB FT. .283 DIMENSION APPLIES AFTER TORQUING TO REQUIRED LOAD.
3. FINISH REAM CHAMBER AFTER ASSEMBLY.
4. PROTECTIVE FINISH:
    A. INTERIOR: CHROMIUM PLATE CHAMBER AND BORE FINISH 12.2.2 OF MIL-STD-171. FILM THICKNESS BETWEEN POINTS -B- AND -C- .0003 TO .0015. FILM THICKNESS BETWEEN -C- AND -D- .0004 TO .0015.
    B. CHROMIUM PLATING SOLUTION TO HAVE A CONCENTRATION OF CHROMIUM TRIOXIDE (CrO_3) 50 TO 56 OUNCES PER GALLON; CHROMIC ACID TO SULPHATE ION RATIO SHALL BE 85:1 TO 95:1. THE OPERATING TEMPERATURE SHALL BE MAINTAINED AT 150° TO 155° F. THE CURRENT DENSITY SHALL BE MAINTAINED SO THE DEPOSIT IS ESSENTIALLY OF A DENSE, CRACK-FREE CHARACTER WHEN VIEWED UNDER 100X MAGNIFICATION.
    C. EXTERIOR: 5.3.1.2 OF MIL-STD-171.
5. AFTER CHROME PLATING CHAMBER AND BORE, EACH BARREL ASSEMBLY SHALL WITHSTAND THE FIRING OF ONE HIGH PRESSURE TEST CARTRIDGE M197, WITHOUT EVIDENCE OF FAILURE.
6. AFTER PROOF FIRING, EACH BARREL ASSEMBLY SHALL BE MAGNETIC PARTICLE INSPECTED FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS USING A CURRENT OF 400 TO 500 AMPERES FOR CIRCULAR CONTINUOUS MAGNETIZATION.
7. AFTER PROOF FIRING AND MAGNETIC PARTICLE INSPECTION, GRIT BLAST EXTERIOR PRIOR TO FINAL PROTECTIVE FINISH, TO PRODUCE NONREFLECTIVE MATTE FINISH. MASK CHAMBER, FEED CONE, BORE AND CROWN (MUZZLE END).
8. AFTER PROOF LOAD FIRING AND MAGNETIC PARTICLE INSPECTION EACH BARREL SHALL BE MARKED AS FOLLOWS:
    MFG IDENT, MAGNETIC PARTICLE INSPECTION / PROOF LOAD FIRING SYMBOL, AND "CHROME BORE" SHALL BE .094±.015 HIGH IN AREA SHOWN VISUALLY IN LINE WITH THE .092 DIA GAS PORT.
9. ABOVE MARKINGS SHALL BE LEGIBLE AND PERMANENT SO AS TO BE CAPABLE OF WITHSTANDING THE ENVIRONMENTAL AND CLEANING REQUIREMENTS FOR THE ASSEMBLY.
10. SINGLE LETTER CHROME PLATE VENDOR IDENT. PERMISSIBLE THIS AREA ONLY.
11. MIL-W-13855 APPLIES.


DIAMETER NOT TO EXCEED .9990 FOR THIS LENGTH AFTER ASSEMBLY AND BEFORE FINISH.
.43
NOTE 9&10
A
A
PIN, BARREL INDEXING-8448551
-E-
BARREL-8448549
EXTENSION, BARREL-8448550
.092 DIA +.001 THRU THIS SIDE ONLY. BREAK EXTERNAL SHARP EDGE .015 MAX. INTERNAL BURR NOT PERMITTED.
A .008 TOTAL
E .008 TOTAL
(GAS PORT)
.295
-A-
WEAPON MFR'S IDENTIFICATION
MP CHROME BORE
MAGNETIC PARTICLE INSPECTION AND PROOF LOAD FIRING SYMBOL. (MP OPTIONAL)
SEE NOTE 8 AND VIEW B


1.6206 REF
.283+.006 NOTE 2 APPLIES
.094 MAX
PLATING FADE OUT TO TERMINATE ANYWHERE IN THIS AREA
-C-
.3300 DIA DATUM
(RUNOUT OF BODY TAPER)
-B-

SECTION A-A
SCALE: 2/1


.125±.015
.125±.015
.125±.015
1.00 APROX
-D-
MP CHROME BORE
PLATING FADE OUT TO TERMINATE ANYWHERE IN THIS AREA.

VIEW B
SCALE: 2/1

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL-8448548

PART NO. 8448548

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA				
BH			F8448601	M16
			F8448522	M16A1
RH			NEXT ASSY.	USED ON
			APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS .XX ±.01 .XXX ±.005
ANGLES ±
MATERIAL
HEAT TREATMENT
FINAL PROTECTIVE FINISH SEE NOTES 4,7,10

ORIGINAL DATE OF DRAWING 27 APR 70
SUBMITTED
APPROVED

DEPT OF THE ARMY
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

BARREL AND BARREL
EXTENSION ASSEMBLY

DWG SIZE	CODE IDENT NO.	
F	19204	8448548

SCALE 1/1 UNIT WT SHEET 1 OF 1

F8448548

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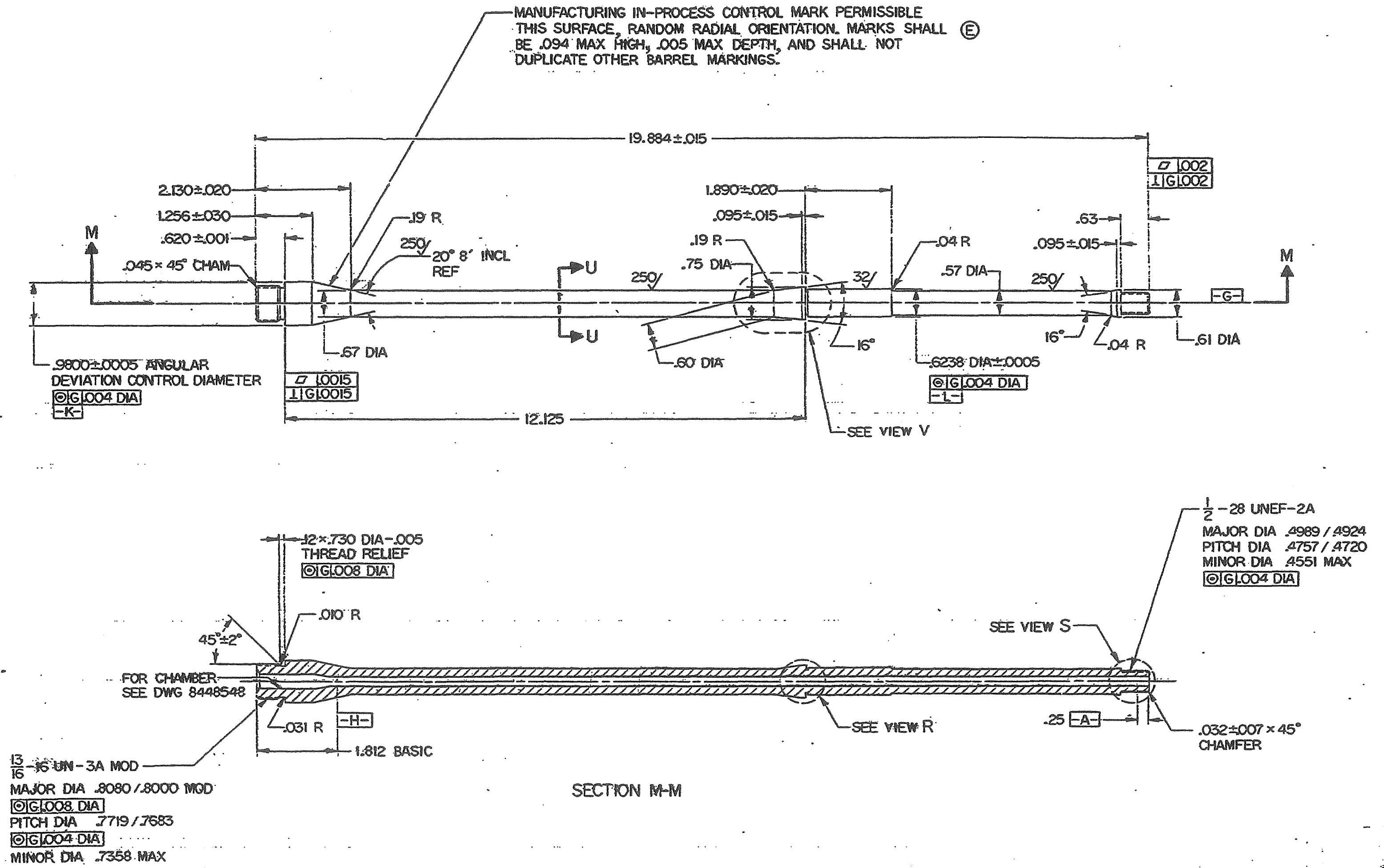
REVISIONS					
	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		D	REPLACES REV C W/ CHANGE SEE ERR-HQR 20827	14 DEC 72	RB
		E	SEE ERR-HQR 30645	2 MAR 73	RE
		F	(O) SEE NOR 77E0005-0000	26 JAN 77	FB
		G	NOR W2S 0026 82-05-21	83-02-03	
		H	NOR G7S3121 / 870923	880928	
		J	NOR GIS3039/910510	9:0612	PF

NOTES:

1. STEEL, CMPSN CHROME-MOLY-VANADIUM, SPEC MIL-S-11595.
2. CENTER LINE -G- ESTABLISHED BY BORE DIAMETER AT MUZZLE AND AT POINT -H-. ALL DIAMETERS ◎ G .010 DIA UNLESS OTHERWISE SPECIFIED.
3. BREAK SHARP EDGES .005-.010 UNLESS OTHERWISE SPECIFIED.
4. WHERE NOTED, DIMENSIONAL LIMITS AND SURFACE ROUGHNESS DESIGNATIONS APPLY AFTER CHROME PLATING.
5. RIFLING TO BE SIX GROOVES, RIGHT HAND, WITH ONE TURN IN 12.000 ± .125.
6. STRESS RELIEVE AFTER FORMING RIFLING AND PRIOR TO FURTHER MACHINING. SUGGESTED PROCEDURE: PLACE BARRELS IN A CLOSED RETORT VERTICALLY. HEAT IN A NEUTRAL ATMOSPHERE TO 1020° F. HOLD AT HEAT FOR 15 MINUTES. COOL IN RETORT TO 300°F. REMOVE AND AIR COOL.
7. A CYLINDRICAL PLUG WITH A GAGING LENGTH OF 6.000 AND A DIAMETER OF .2173 / .2174 MUST DROP THROUGH THE BORE OF ITS OWN WEIGHT.
8. A SELF ALIGNING PLUG INSERTED 3.000 INTO THE BORE AT THE MUZZLE MAY HAVE AN ANGULAR DEVIATION FROM A THEORETICAL AXIS ESTABLISHED BY -K- AND -L- OF 0° 3' MAXIMUM.
9. BORE AND GROOVE DIAMETERS SHALL BE WITHIN THE DIMENSIONAL LIMITS SPECIFIED AND, WHEN MEASURED FROM THE CHAMBER END TOWARD THE MUZZLE END, SHALL MEET THE FOLLOWING REQUIREMENTS:
    1. DIAMETRAL REDUCTION OF BORE AND GROOVE DIAMETERS SHALL BE .0001 DIA MAX FOR LENGTH -A-.
    2. NO BORE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED BORE DIAMETER.
    3. NO GROOVE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED GROOVE DIAMETER.
10. MIL-W-13855 APPLIES.


MANUFACTURING IN-PROCESS CONTROL MARK PERMISSIBLE THIS SURFACE, RANDOM RADIAL ORIENTATION. MARKS SHALL BE .094 MAX HIGH, .005 MAX DEPTH, AND SHALL NOT DUPLICATE OTHER BARREL MARKINGS. Ⓔ
19.884±.015
▱ .002
⊥ G .002
2.130±.020
1.256±.030
.620±.001
.19 R
250
20° 8' INCL REF
M
.045 × 45° CHAM
U
U
1.890±.020
.095±.015
.19 R
.75 DIA
250
32
.04 R
.57 DIA
.63
.095±.015
250
M
-G-
.67 DIA
.60 DIA
16°
16°
.04 R
.61 DIA
.6238 DIA±.0005
◎ G .004 DIA
-L-
.9800±.0005 ANGULAR DEVIATION CONTROL DIAMETER
◎ G .004 DIA
-K-
▱ .0015
⊥ G .0015
12.125
SEE VIEW V
1/2-28 UNEF-2A
MAJOR DIA .4989 / .4924
PITCH DIA .4757 / .4720
MINOR DIA .4551 MAX
◎ G .004 DIA
.12 × .730 DIA-.005 THREAD RELIEF
◎ G .008 DIA
.010 R
45°±2°
SEE VIEW S
FOR CHAMBER SEE DWG 8448548
.031 R
-H-
1.812 BASIC
SEE VIEW R
.25
-A-
.032±.007 × 45° CHAMFER
13/16-16 UN-3A MOD
MAJOR DIA .8080 / .8000 MOD
◎ G .008 DIA
PITCH DIA .7719 / .7683
◎ G .004 DIA
MINOR DIA .7358 MAX
SECTION M-M

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448549

REV STATUS OF SHT'S	
SH 1	SH 2
J	J

MECHANICAL PROPERTIES			
TS MIN			
YS MAX			
EL 2			
RA			
BH			M16
RH	C26-32	F8448548	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±1° 0'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 70
PREPARED P. Vann
CHECKED D. Kodak
ENGINEER
SUBMITTED Loren F. Brunton
APPROVED R. St Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BARREL

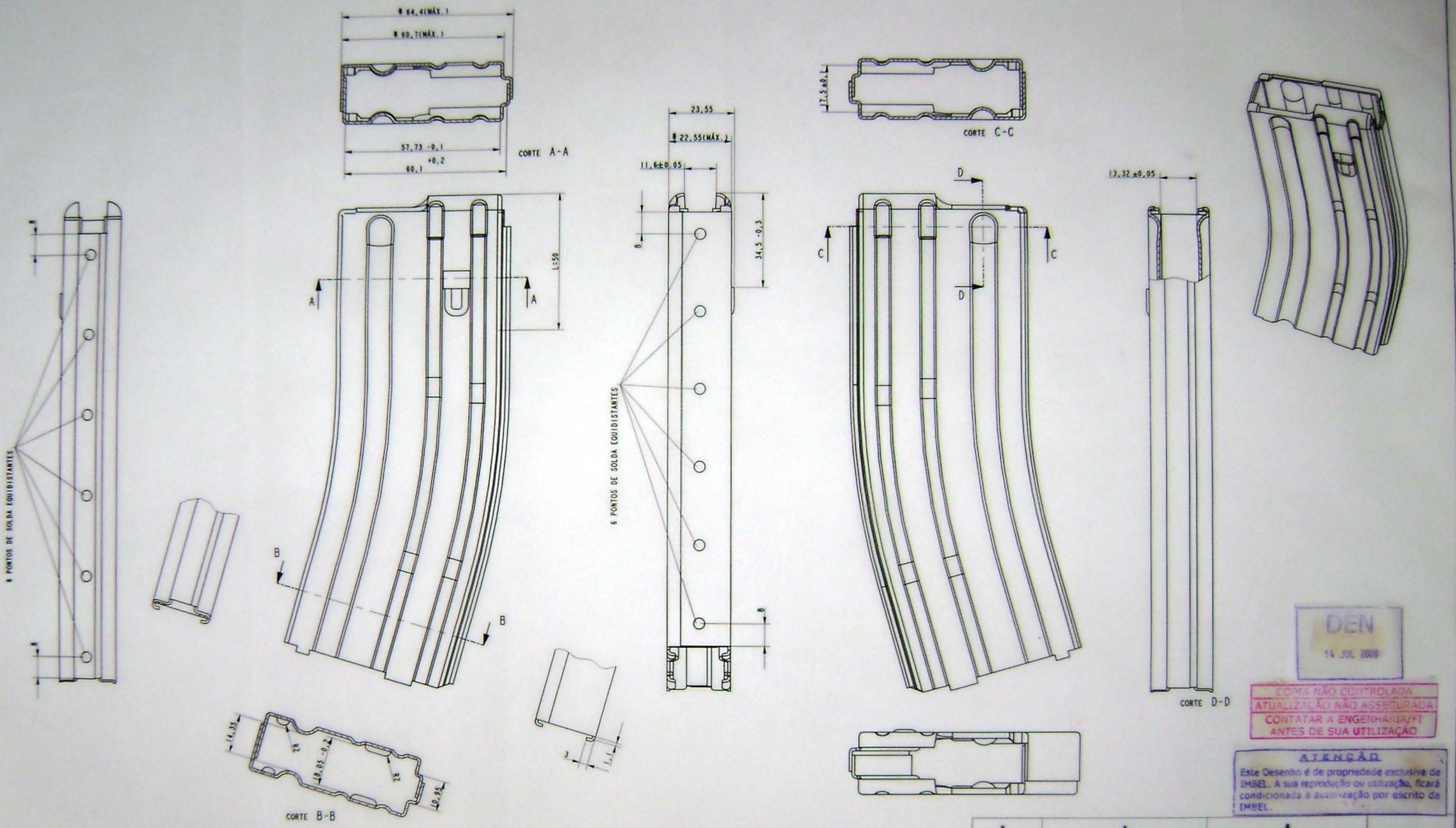
SIZE F
CODE IDENT NO. 19204
DRAWING NO. 8448549
SCALE 1/1
SHEET 1 OF 2

F8448549

AMSWE Form 403F, 13 NOV 70

EDITION OF 29 JUL 70 MAY BE USED.

October 13, 2004 3:34 PM


* 64,4(MÁX.)
* 60,7(MÁX.)
57,73 -0,1 +0,2
60,1
CORTE A-A
23,55
* 22,55(MÁX.)
11,6±0,05
34,5 -0,3
L=50
A
B
C
D
17,5±0,1
CORTE C-C
13,32±0,05
CORTE D-D
8
6 PONTOS DE SOLDA EQUIDISTANTES
14,35
R2
18,05 -0,2
10,95
3
1,1
CORTE B-B

DEN
14 JUL 2008

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CONTATAR A ENGENHARIA/FI
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Dimensões internas são as mais importantes.

As superfícies internas e externas ao longo do comprimento L=50^{-10} não deverão receber pintura.

As cotas indicadas se referem ao carregador sem tratamento superficial.

SC	MATERIAL	TRAT. TÉRMICO	TRAT. SUPERFICIAL
SC 9/1A	AÇO AISI 1010 e=0,96±0,06	CARBONITRETAÇÃO SUBCRÍTICA (75-80)HRN 15	PINTURA EPÓXI, PRETO FOSCO CAMADA DE 0,05 MÁX.
SC 9/1A-AL	ASTM 6061 e=1-0,10		ANODIZAÇÃO DURA, CAMADA DE 0,02 A 0,04mm PINTURA EPÓXI, PRETO FOSCO CAMADA DE 0,05 MÁX.

*	*	*	
Material	Tratamento Térmico	Tratamento Superficial	Código

Modificação: 4410 4960

Escala 1:1

CORPO DO CARREGADOR

Código:

Produto: Fz 5,56-IMBEL MD97L

Projeção

Peça: *

Op:

Nº A2- 9097 -500

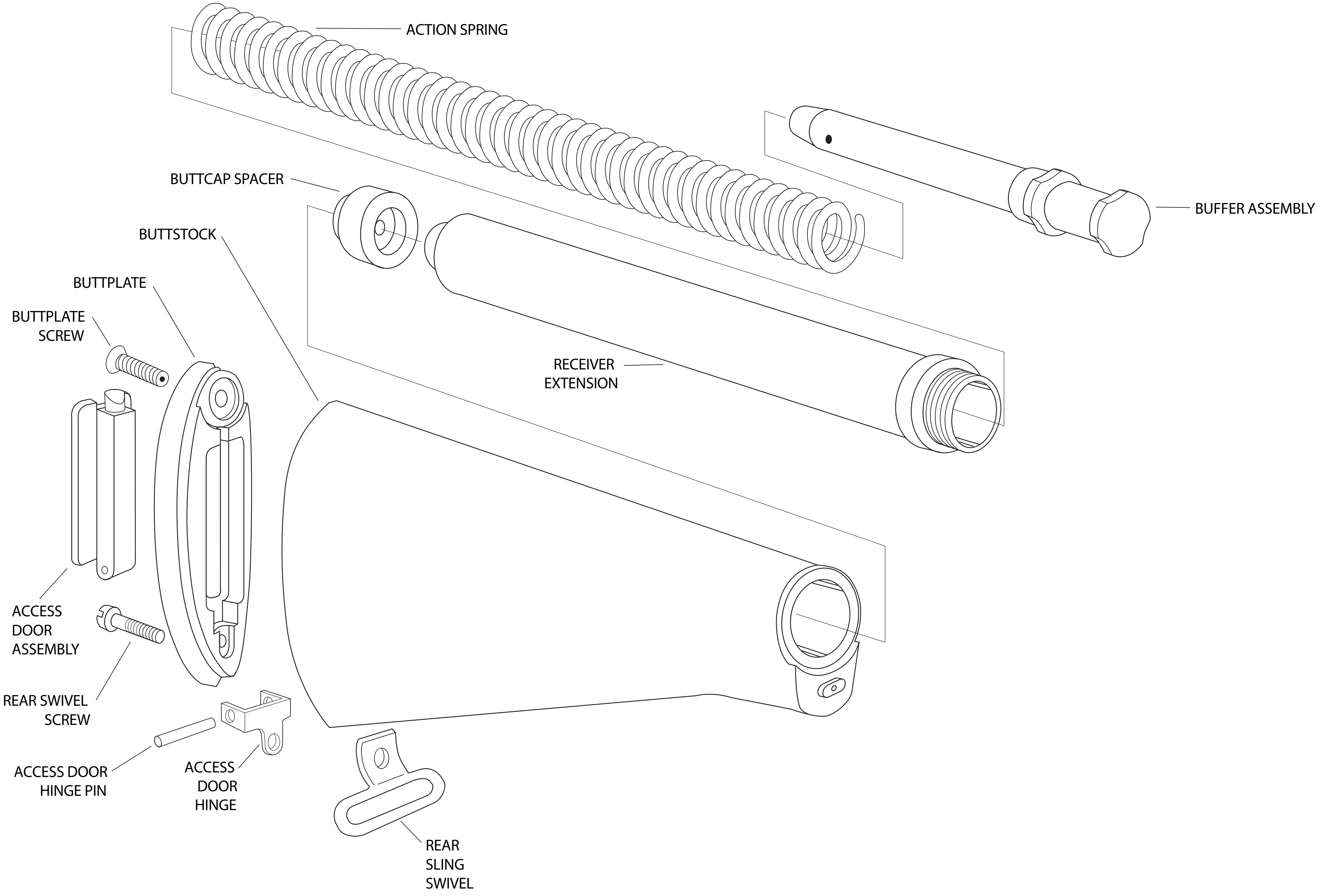
Uso: DEFINITIVO

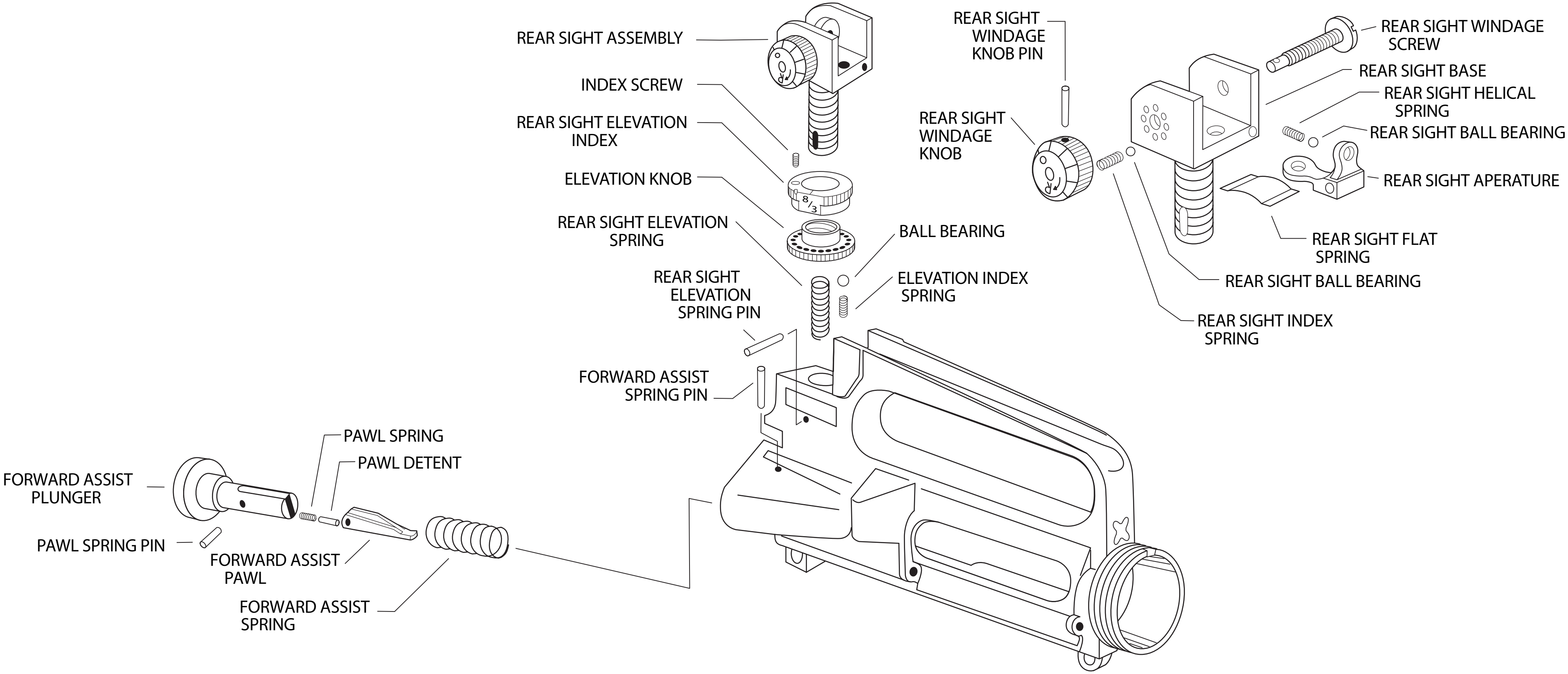
Substitui o: A2-9097 DE 21/12/04

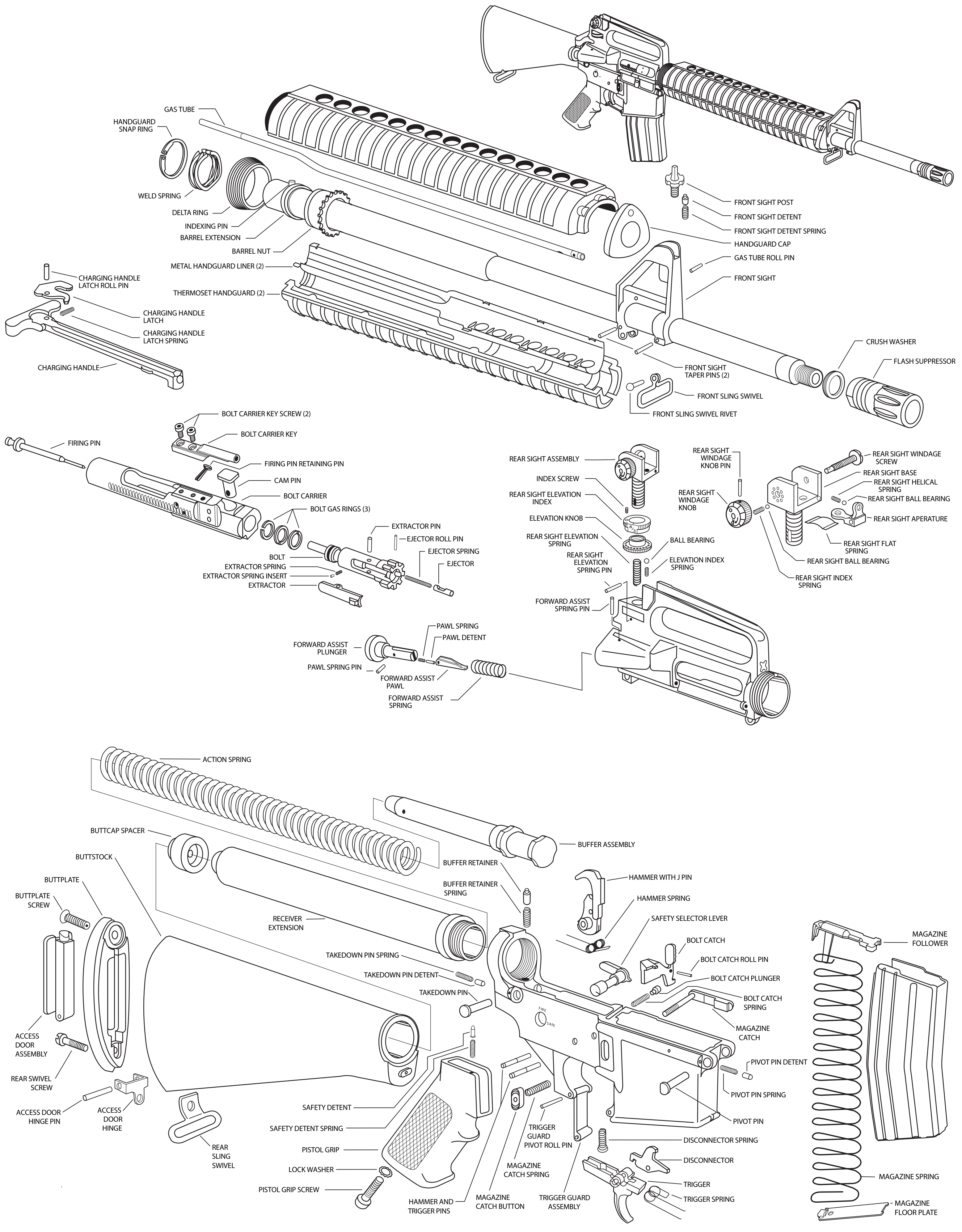
Substituído pelo:

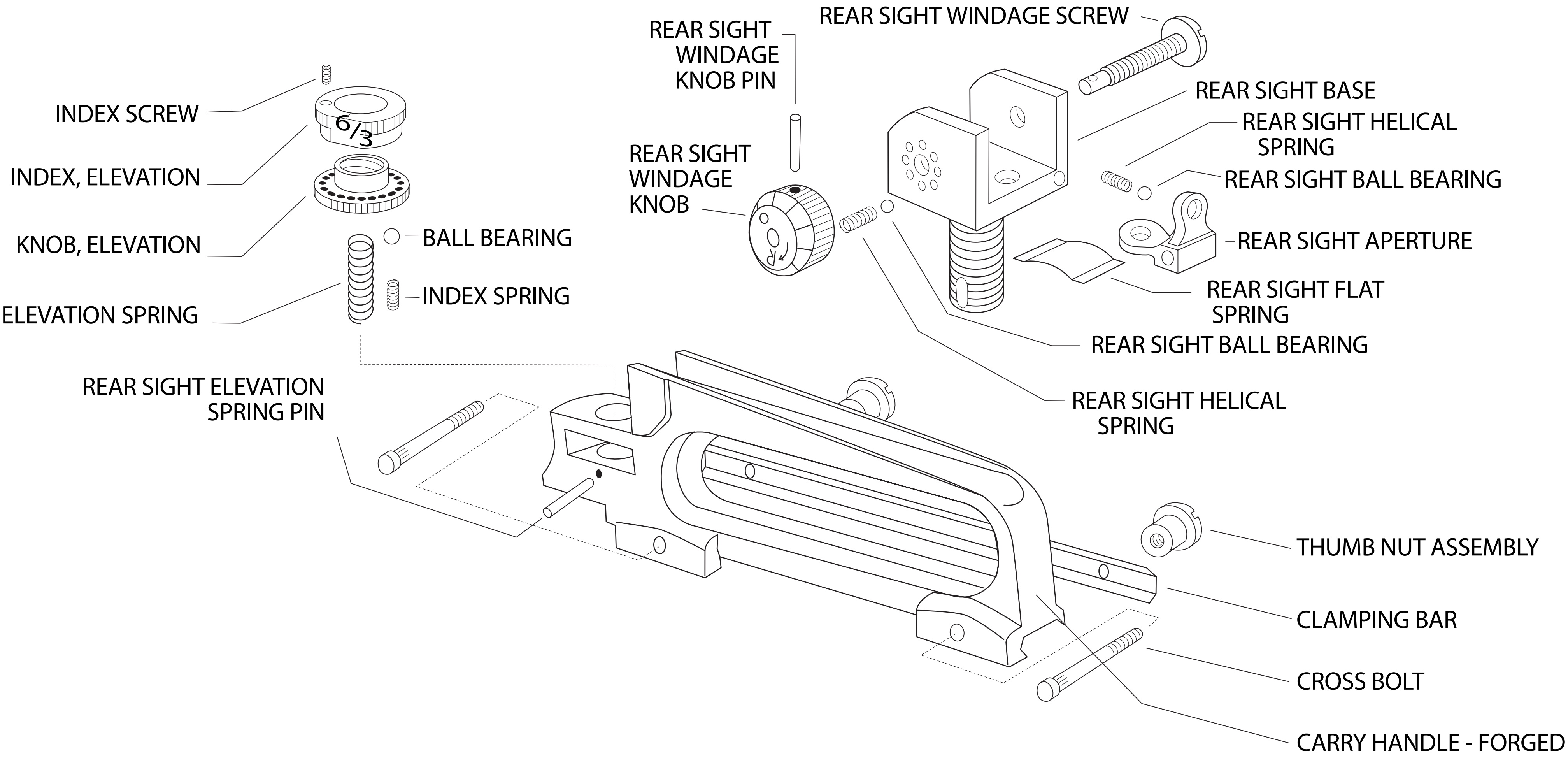
Aprovado	ENGº. CAPETTI	16/05/08
Conferido	PROJ. GUALTER	16/05/08
Projetado	PROJ. FRANCISCO	16/05/08
Desenhado	PROJ. C.VITALINO	16/05/08

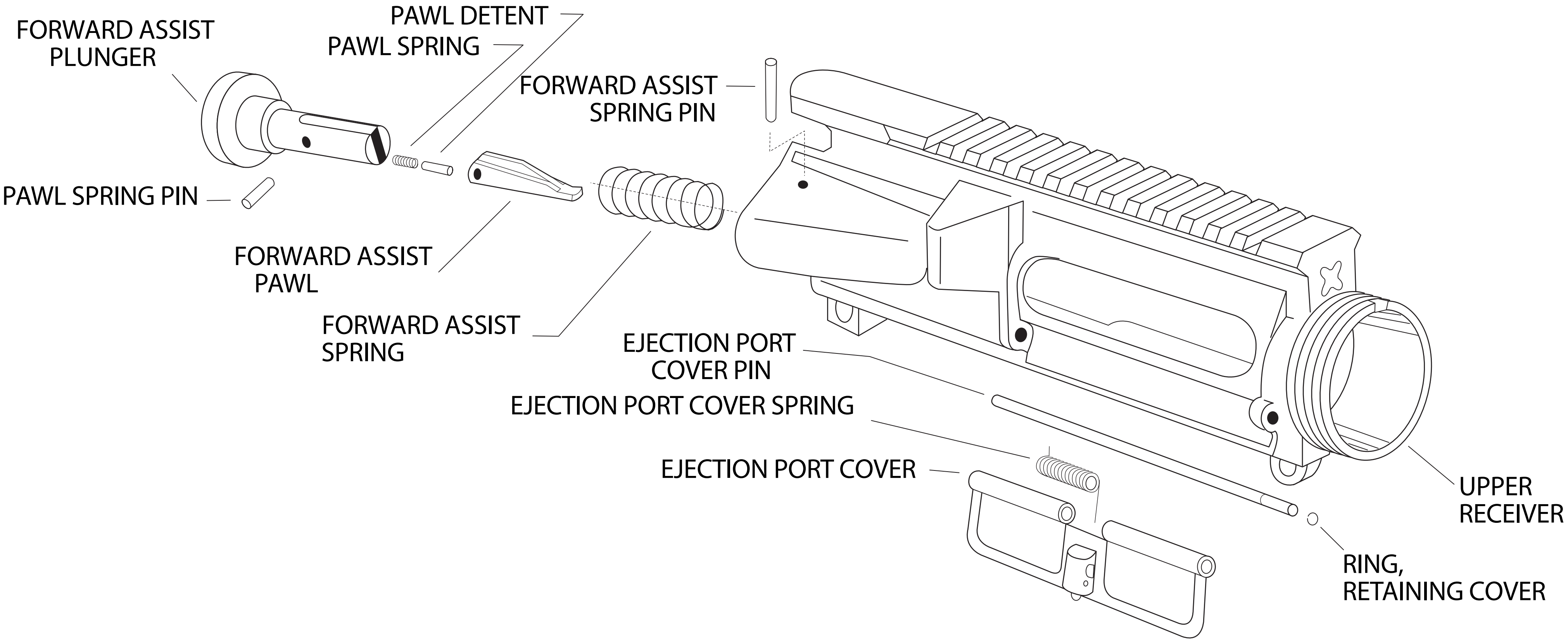
INDÚSTRIA DE MATERIAL BÉLICO DO BRASIL
IMBEL
FÁBRICA DE ITAJUBÁ - F5

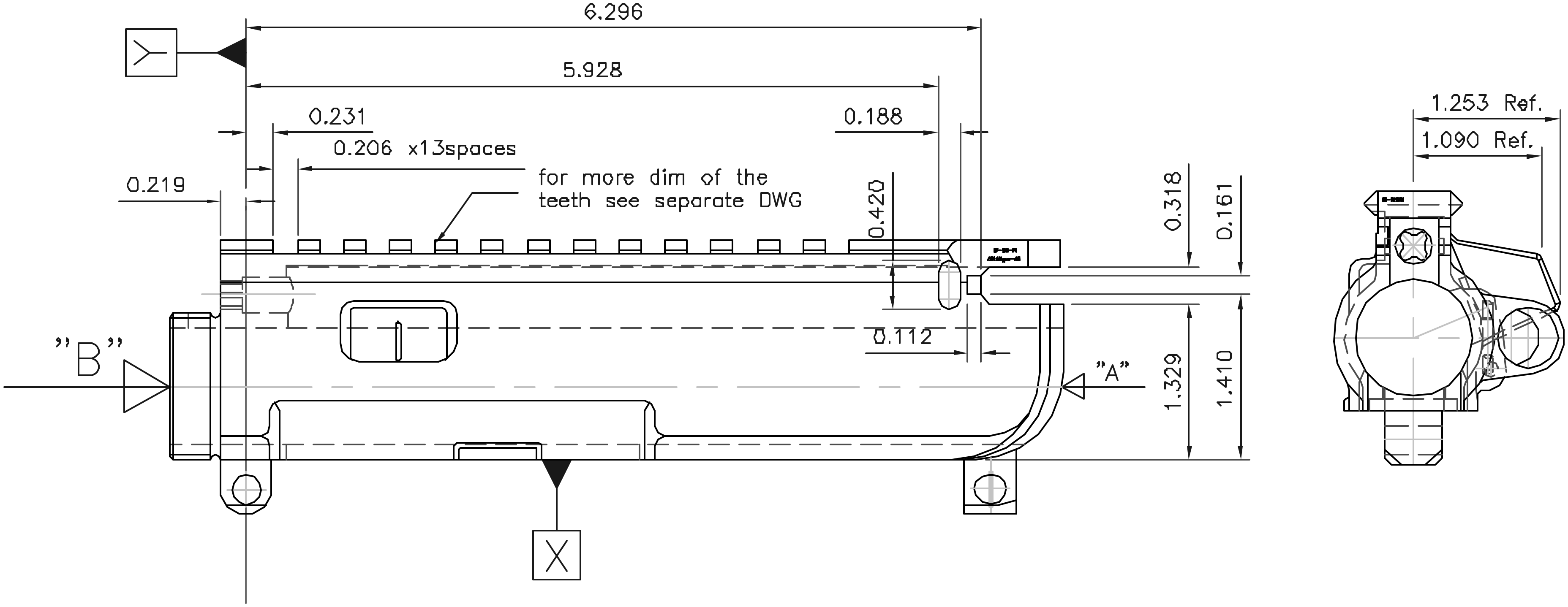

ACTION SPRING
BUFFER ASSEMBLY
BUTTCAP SPACER
BUTTSTOCK
BUTTPLATE
BUTTPLATE SCREW
RECEIVER EXTENSION
ACCESS DOOR ASSEMBLY
REAR SWIVEL SCREW
ACCESS DOOR HINGE PIN
ACCESS DOOR HINGE
REAR SLING SWIVEL


REAR SIGHT ASSEMBLY
INDEX SCREW
REAR SIGHT ELEVATION INDEX
ELEVATION KNOB
REAR SIGHT ELEVATION SPRING
BALL BEARING
ELEVATION INDEX SPRING
REAR SIGHT ELEVATION SPRING PIN
FORWARD ASSIST SPRING PIN
REAR SIGHT WINDAGE KNOB PIN
REAR SIGHT WINDAGE KNOB
REAR SIGHT WINDAGE SCREW
REAR SIGHT BASE
REAR SIGHT HELICAL SPRING
REAR SIGHT BALL BEARING
REAR SIGHT APERATURE
REAR SIGHT FLAT SPRING
REAR SIGHT BALL BEARING
REAR SIGHT INDEX SPRING
PAWL SPRING
PAWL DETENT
FORWARD ASSIST PLUNGER
PAWL SPRING PIN
FORWARD ASSIST PAWL
FORWARD ASSIST SPRING
8/3


GAS TUBE
HANDGUARD SNAP RING
WELD SPRING
DELTA RING
INDEXING PIN
BARREL EXTENSION
BARREL NUT
METAL HANDGUARD LINER (2)
THERMOSET HANDGUARD (2)
CHARGING HANDLE LATCH ROLL PIN
CHARGING HANDLE LATCH
CHARGING HANDLE LATCH SPRING
CHARGING HANDLE
FRONT SIGHT POST
FRONT SIGHT DETENT
FRONT SIGHT DETENT SPRING
HANDGUARD CAP
GAS TUBE ROLL PIN
FRONT SIGHT
CRUSH WASHER
FLASH SUPPRESSOR
FRONT SIGHT TAPER PINS (2)
FRONT SLING SWIVEL
FRONT SLING SWIVEL RIVET
BOLT CARRIER KEY SCREW (2)
BOLT CARRIER KEY
FIRING PIN
FIRING PIN RETAINING PIN
CAM PIN
BOLT CARRIER
BOLT GAS RINGS (3)
EXTRACTOR PIN
EJECTOR ROLL PIN
EJECTOR SPRING
EJECTOR
BOLT
EXTRACTOR SPRING
EXTRACTOR SPRING INSERT
EXTRACTOR
REAR SIGHT ASSEMBLY
INDEX SCREW
REAR SIGHT ELEVATION INDEX
ELEVATION KNOB
REAR SIGHT ELEVATION SPRING
REAR SIGHT ELEVATION SPRING PIN
BALL BEARING
ELEVATION INDEX SPRING
FORWARD ASSIST SPRING PIN
REAR SIGHT WINDAGE KNOB PIN
REAR SIGHT WINDAGE KNOB
REAR SIGHT WINDAGE SCREW
REAR SIGHT BASE
REAR SIGHT HELICAL SPRING
REAR SIGHT BALL BEARING
REAR SIGHT APERATURE
REAR SIGHT FLAT SPRING
REAR SIGHT BALL BEARING
REAR SIGHT INDEX SPRING
FORWARD ASSIST PLUNGER
PAWL SPRING
PAWL DETENT
PAWL SPRING PIN
FORWARD ASSIST PAWL
FORWARD ASSIST SPRING
ACTION SPRING
BUTTCAP SPACER
BUFFER ASSEMBLY
BUTTSTOCK
BUFFER RETAINER
BUTTPLATE
BUFFER RETAINER SPRING
HAMMER WITH J PIN
BUTTPLATE SCREW
HAMMER SPRING
RECEIVER EXTENSION
SAFETY SELECTOR LEVER
MAGAZINE FOLLOWER
BOLT CATCH
TAKEDOWN PIN SPRING
BOLT CATCH ROLL PIN
TAKEDOWN PIN DETENT
BOLT CATCH PLUNGER
TAKEDOWN PIN
BOLT CATCH SPRING
MAGAZINE CATCH
FIRE
SAFE
ACCESS DOOR ASSEMBLY
REAR SWIVEL SCREW
PIVOT PIN DETENT
PIVOT PIN SPRING
ACCESS DOOR HINGE PIN
ACCESS DOOR HINGE
SAFETY DETENT
PIVOT PIN
SAFETY DETENT SPRING
REAR SLING SWIVEL
TRIGGER GUARD PIVOT ROLL PIN
DISCONNECTOR SPRING
PISTOL GRIP
MAGAZINE CATCH SPRING
DISCONNECTOR
LOCK WASHER
MAGAZINE SPRING
TRIGGER
PISTOL GRIP SCREW
TRIGGER SPRING
HAMMER AND TRIGGER PINS
MAGAZINE CATCH BUTTON
TRIGGER GUARD ASSEMBLY
MAGAZINE FLOOR PLATE


REAR SIGHT WINDAGE SCREW
REAR SIGHT WINDAGE KNOB PIN
REAR SIGHT BASE
REAR SIGHT HELICAL SPRING
REAR SIGHT BALL BEARING
REAR SIGHT WINDAGE KNOB
REAR SIGHT APERTURE
REAR SIGHT FLAT SPRING
REAR SIGHT BALL BEARING
REAR SIGHT HELICAL SPRING
INDEX SCREW
6/3
INDEX, ELEVATION
KNOB, ELEVATION
BALL BEARING
INDEX SPRING
ELEVATION SPRING
REAR SIGHT ELEVATION SPRING PIN
THUMB NUT ASSEMBLY
CLAMPING BAR
CROSS BOLT
CARRY HANDLE - FORGED


FORWARD ASSIST PLUNGER
PAWL DETENT
PAWL SPRING
FORWARD ASSIST SPRING PIN
PAWL SPRING PIN
FORWARD ASSIST PAWL
FORWARD ASSIST SPRING
EJECTION PORT COVER PIN
EJECTION PORT COVER SPRING
EJECTION PORT COVER
UPPER RECEIVER
RING, RETAINING COVER


6.296
5.928
0.231
0.188
0.206 x13spaces
0.219
for more dim of the teeth see separate DWG
0.420
0.318
0.161
0.112
"B"
"A"
1.329
1.410
Y
X
1.253 Ref.
1.090 Ref.

NOT TO SCALE
DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

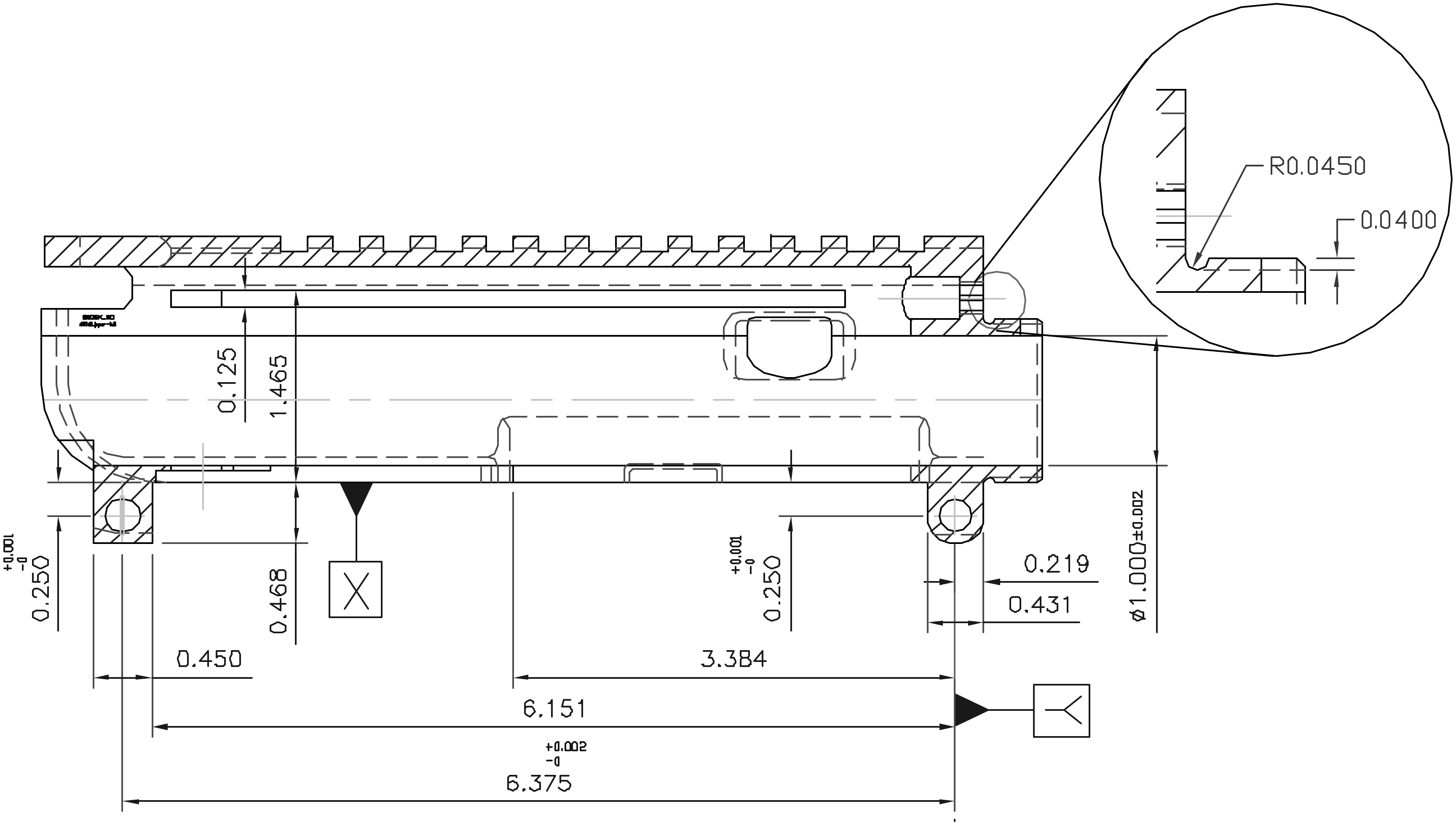
TITLE
LEFT / REAR

DRAWN BY
DATE Jan 2003
SCALE FULL

CHECKED BY
DATE
SHEET NO. 5 OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	


R0.0450
0.0400
0.125
1.465
+0.001
-0
0.250
0.468
X
+0.001
-0
0.250
0.219
0.431
Ø1.000±0.002
0.450
3.384
6.151
+0.002
-0
6.375

NOT TO SCALE
DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

TITLE
LEFT SIDE CUTTAWAY

DRAWN BY
DATE Jan 2003

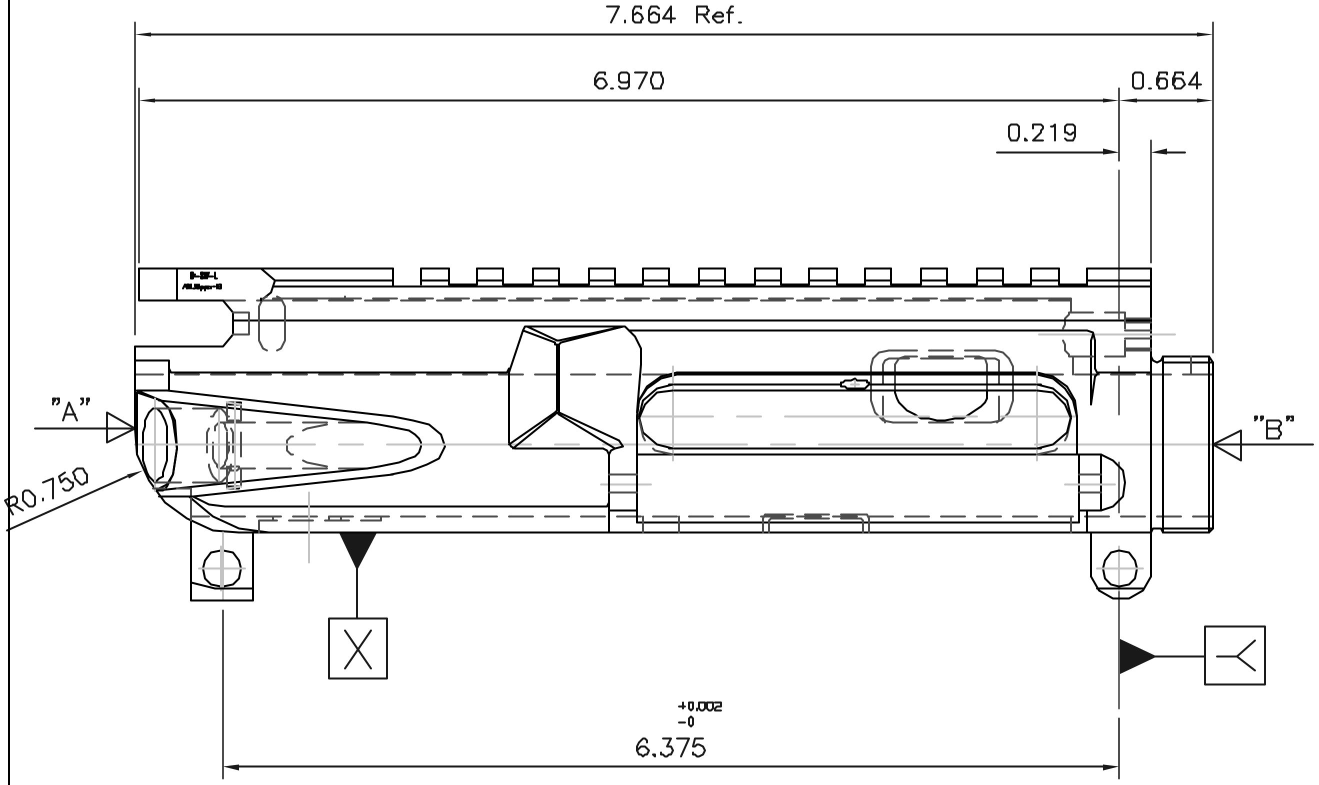
SCALE FULL

CHECKED BY
DATE

SHEET NO. 1
OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	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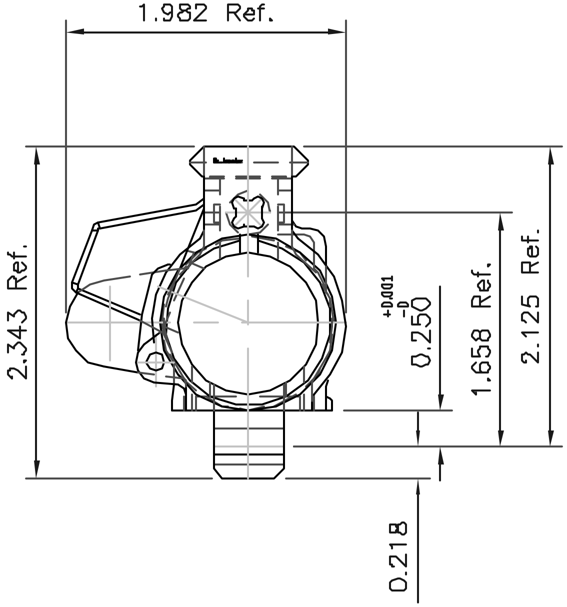
6.970
0.664
0.219
"A"
"B"
R0.750
X
Y
+0.002
-0
6.375


1.982 Ref.
2.343 Ref.
+0.001
-0
0.250
1.658 Ref.
2.125 Ref.
0.218

NOT TO SCALE

DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT RELEASE DATE

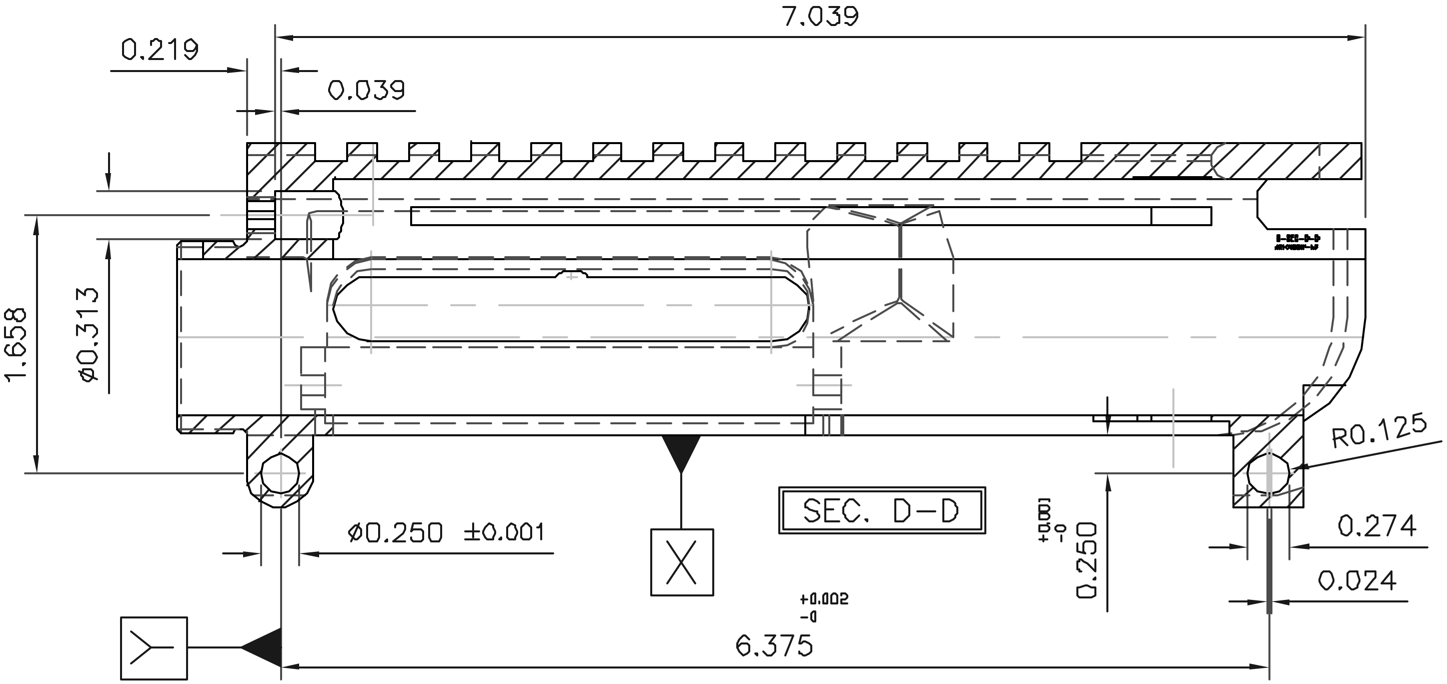
MODEL
AR15 UPPER RECEIVER (FLATTOP)

TITLE
RIGHT / FRONT

DRAWN BY	DATE Jan 2003	SCALE FULL
CHECKED BY	DATE	SHEET NO. 5 OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	


7.039
0.219
0.039
1.658
Ø0.313
R0.125
SEC. D–D
+0.001
-0
0.250
0.274
0.024
Ø0.250 ±0.001
X
+0.002
-0
6.375

NOT TO SCALE
DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT
RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

TITLE
RIGHT SIDE CUTTAWAY

DRAWN BY
DATE
Jan 2003

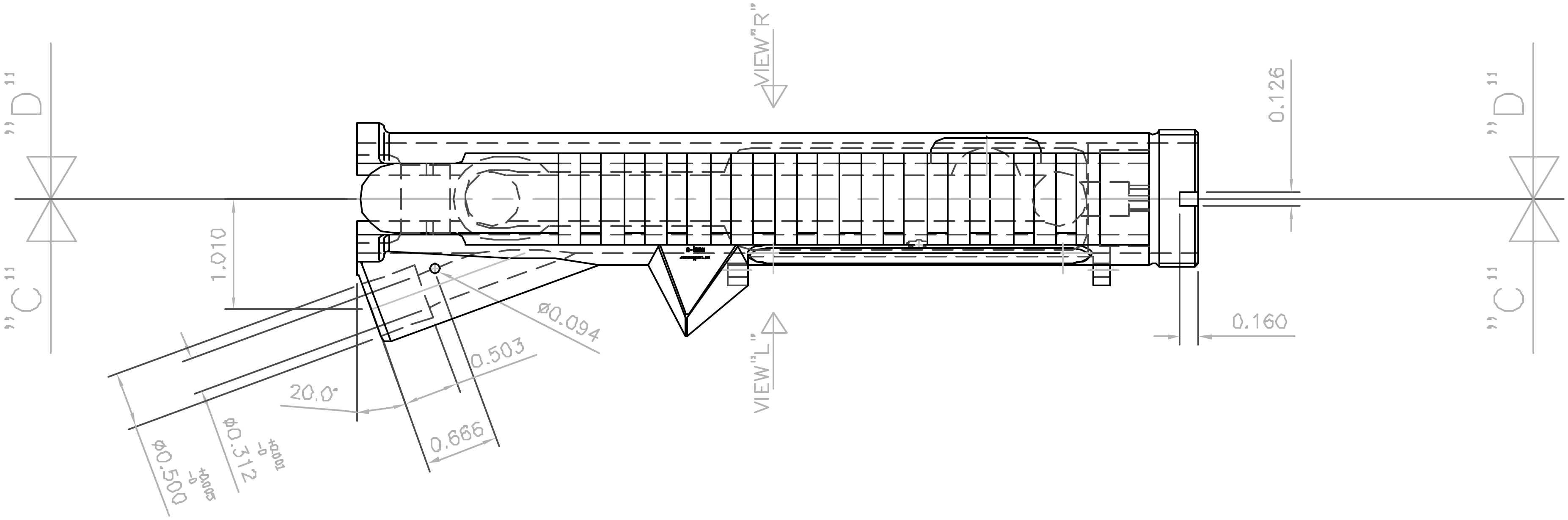
SCALE FULL

CHECKED BY
DATE

SHEET NO. 2
OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	


"D"
"C"
VIEW"R"
0.126
"D"
"C"
1.010
Ø0.094
0.503
20.0°
0.666
Ø0.312 +0.001 -0
Ø0.500 +0.005 -0
VIEW"L"
0.160

NOT TO SCALE
DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH
PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION
LATEST PLOT RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

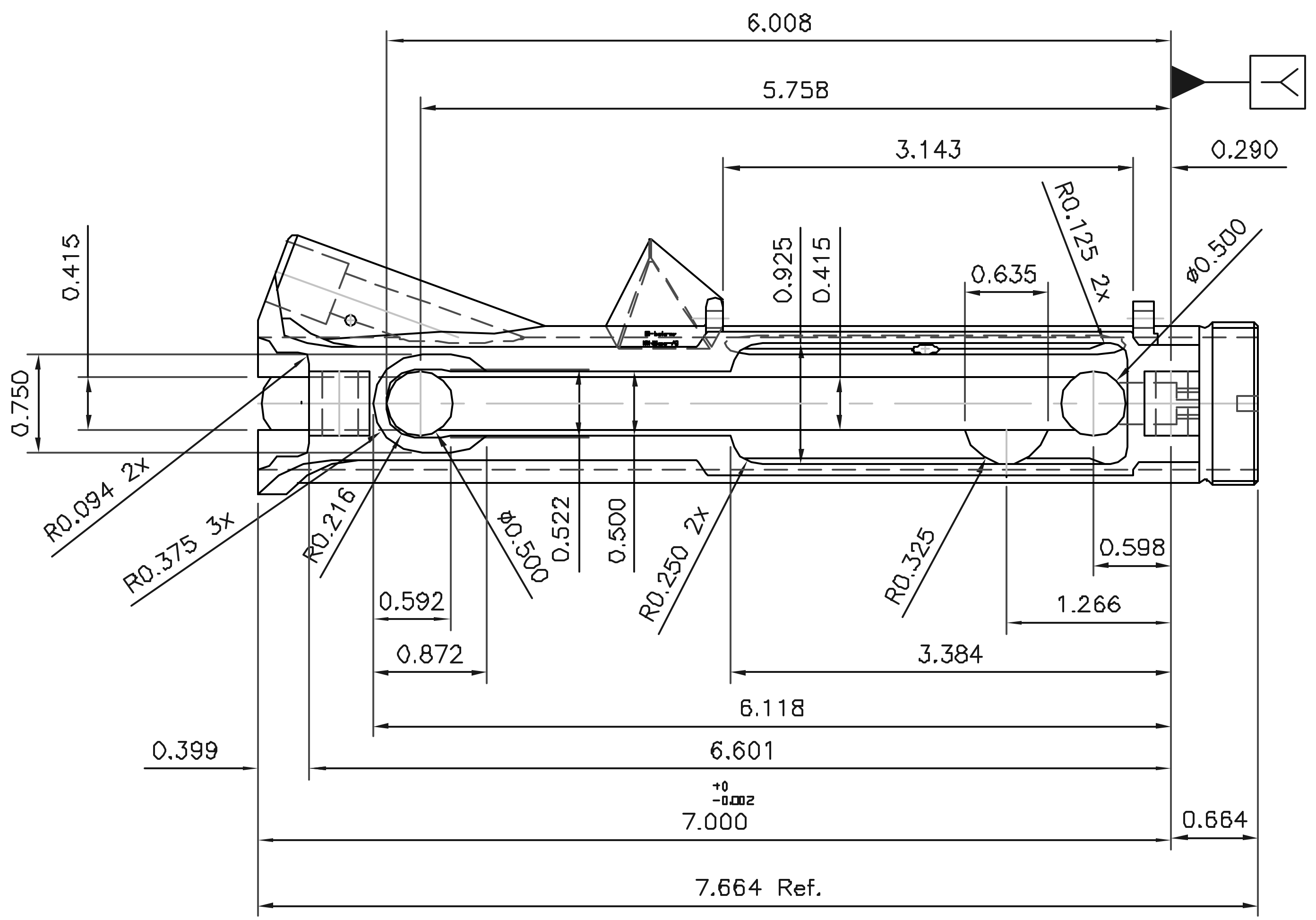
TITLE
TOP

DRAWN BY
DATE Jan 2003
SCALE FULL

CHECKED BY
DATE
SHEET NO. 5
OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	


6.008
5.758
3.143
0.290
R0.125 2x
Ø0.500
0.415
0.925
0.415
0.635
0.750
R0.094 2x
R0.375 3x
R0.216
Ø0.500
0.522
0.500
R0.250 2x
R0.325
0.598
1.266
0.592
0.872
3.384
6.118
0.399
6.601
+0
-0.002
7.000
0.664
7.664 Ref.

NOT TO SCALE

DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT
RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

TITLE
BOTTOM

DRAWN BY
DATE
Jan 2003

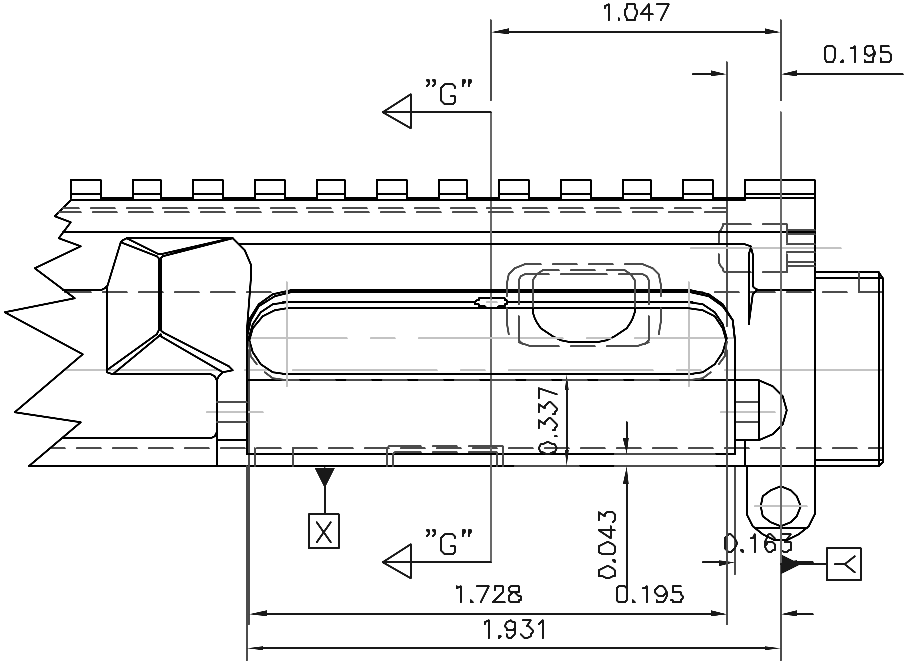
SCALE FULL

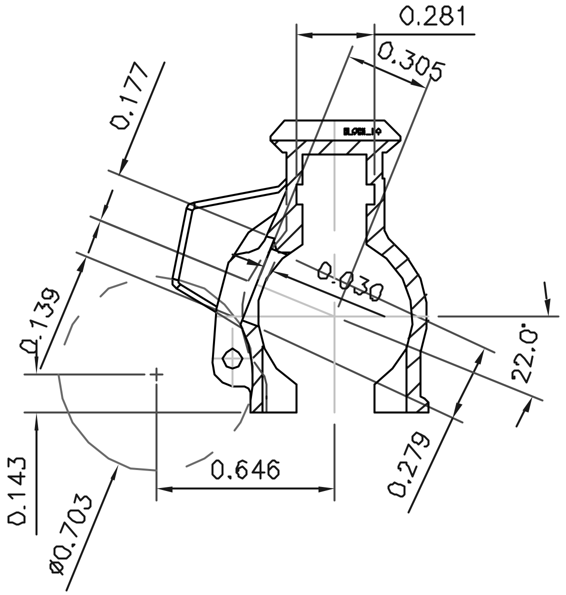
CHECKED BY
DATE

SHEET NO. 4
OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	


1.047
0.195
"G"
0.337
0.043
0.163
X
Y
"G"
1.728
0.195
1.931


0.281
0.305
0.177
0.030
0.139
22.0°
0.143
0.646
0.279
Ø0.703

NOT TO SCALE
DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT
RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

TITLE
LEFT SIDE AND FRONT DETAIL

DRAWN BY
DATE
Jan 2003

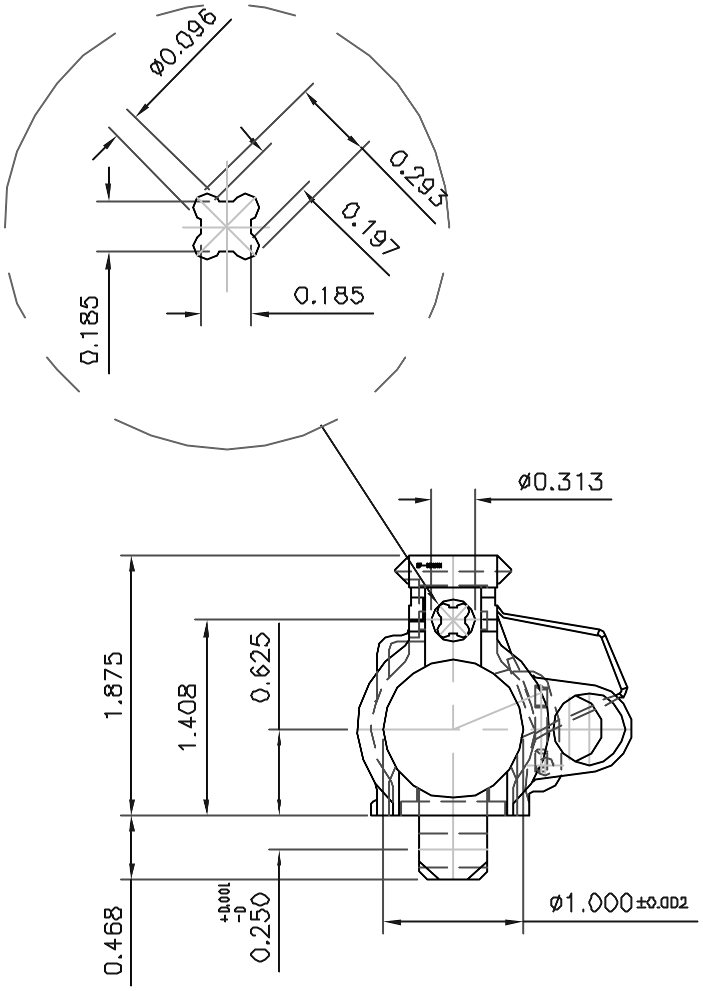
SCALE FULL

CHECKED BY
DATE

SHEET NO. 6
OF 8 SHEETS

DRAWING NUMBER

CODE	IDENT. NO.	SIZE	VAR.
		A	



Ø0.096
0.293
0.197
0.185
0.185
Ø0.313
1.875
1.408
0.625
0.468
+0.001
−0
0.250
Ø1.000±0.002

NOT TO SCALE
DIMENSIONS ARE IN IN. ■ MM. ☐ D ☐ UAL

TOLERANCES
UNLESS OTHERWISE SPECIFIED
INCH ± .005
MM. ±
ANGLE ± .5 Deg

FINISH

PARTS SPEC. NO.

MATERIAL
7075 T6 ALUMINUM FORGING

DISTRIBUTION

LATEST PLOT
RELEASE DATE

MODEL
AR15 UPPER RECEIVER (FLATTOP)

TITLE
REAR DETAIL

DRAWN BY
DATE
Jan 2003

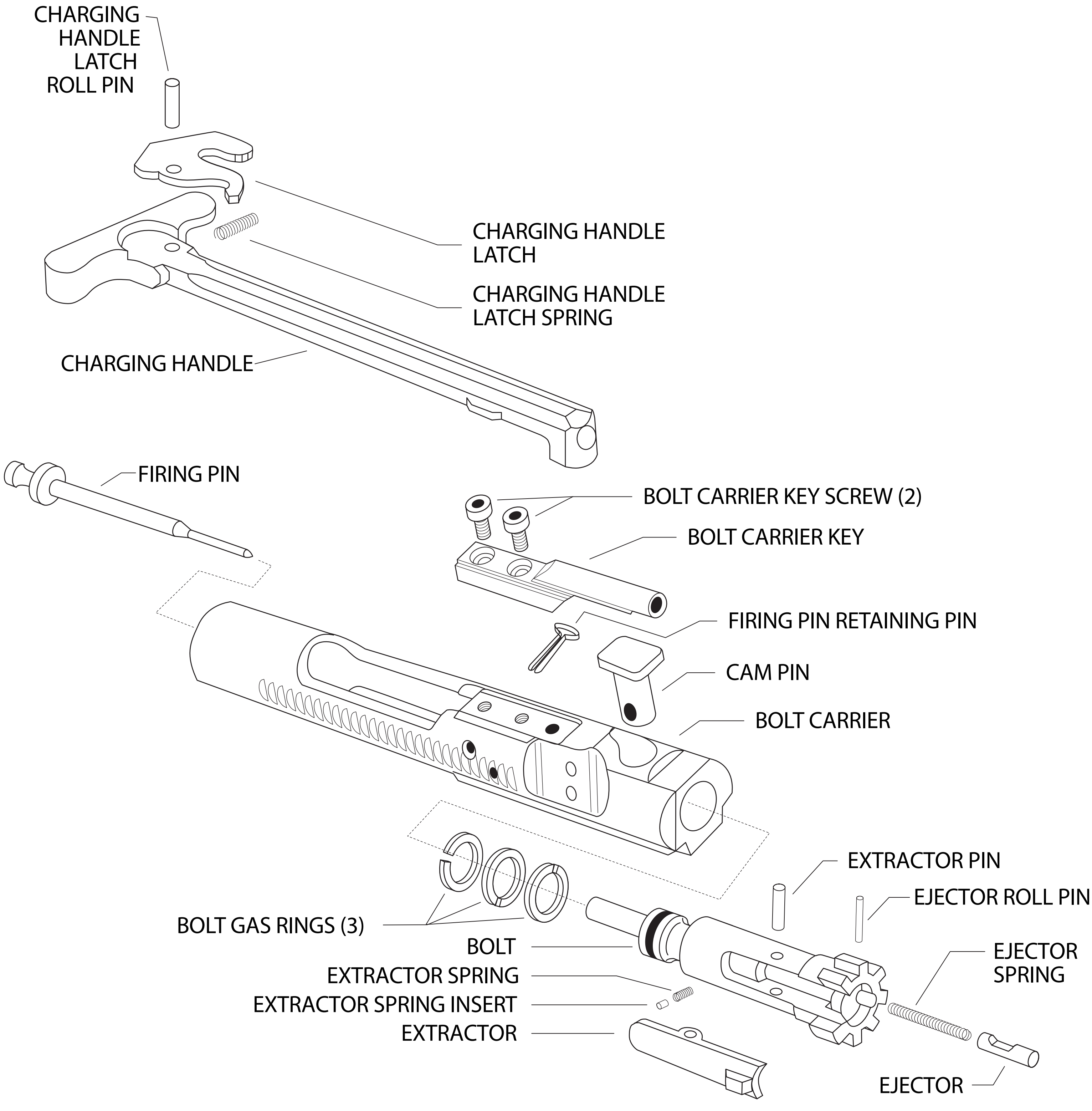
SCALE FULL

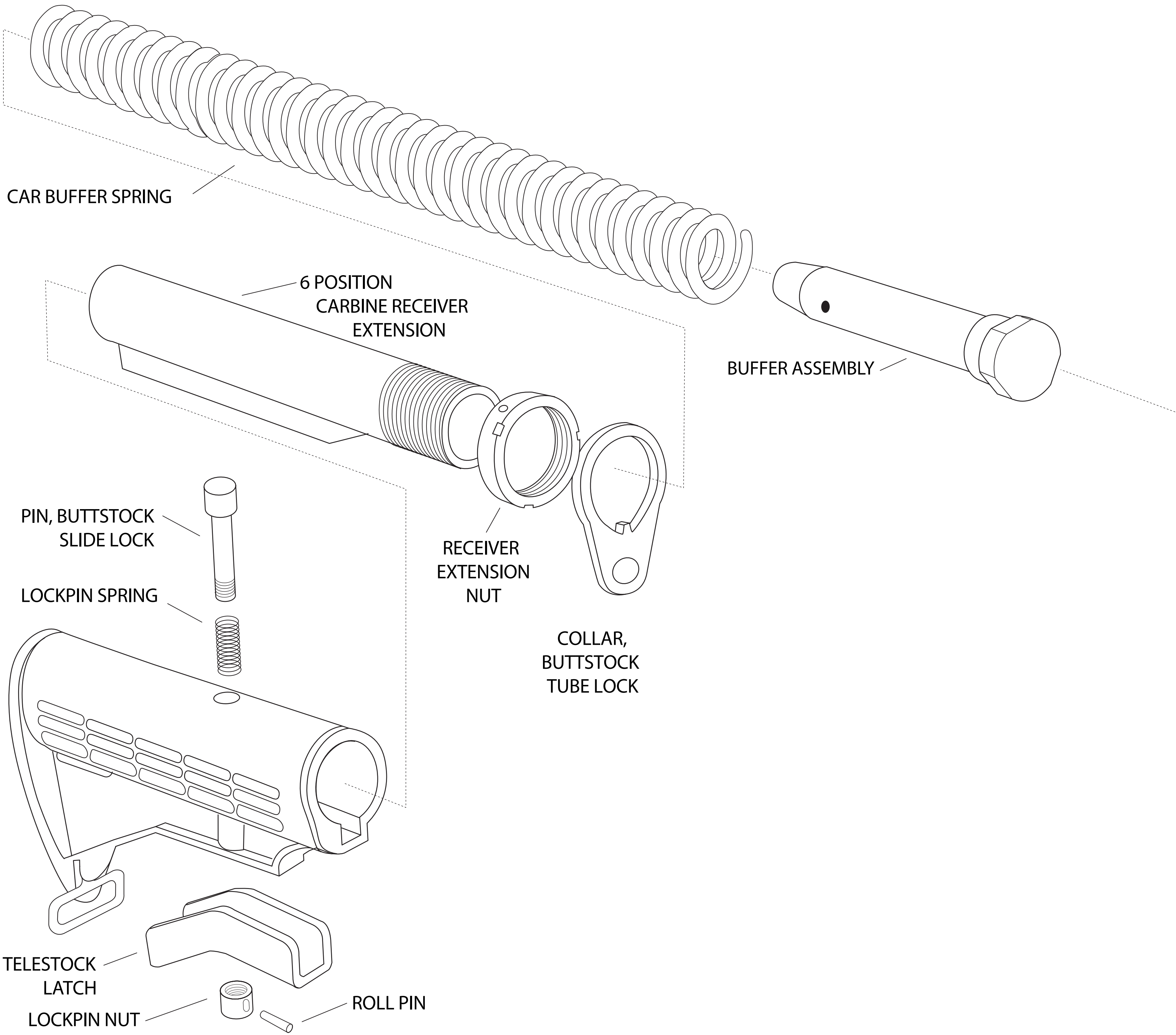
CHECKED BY
DATE

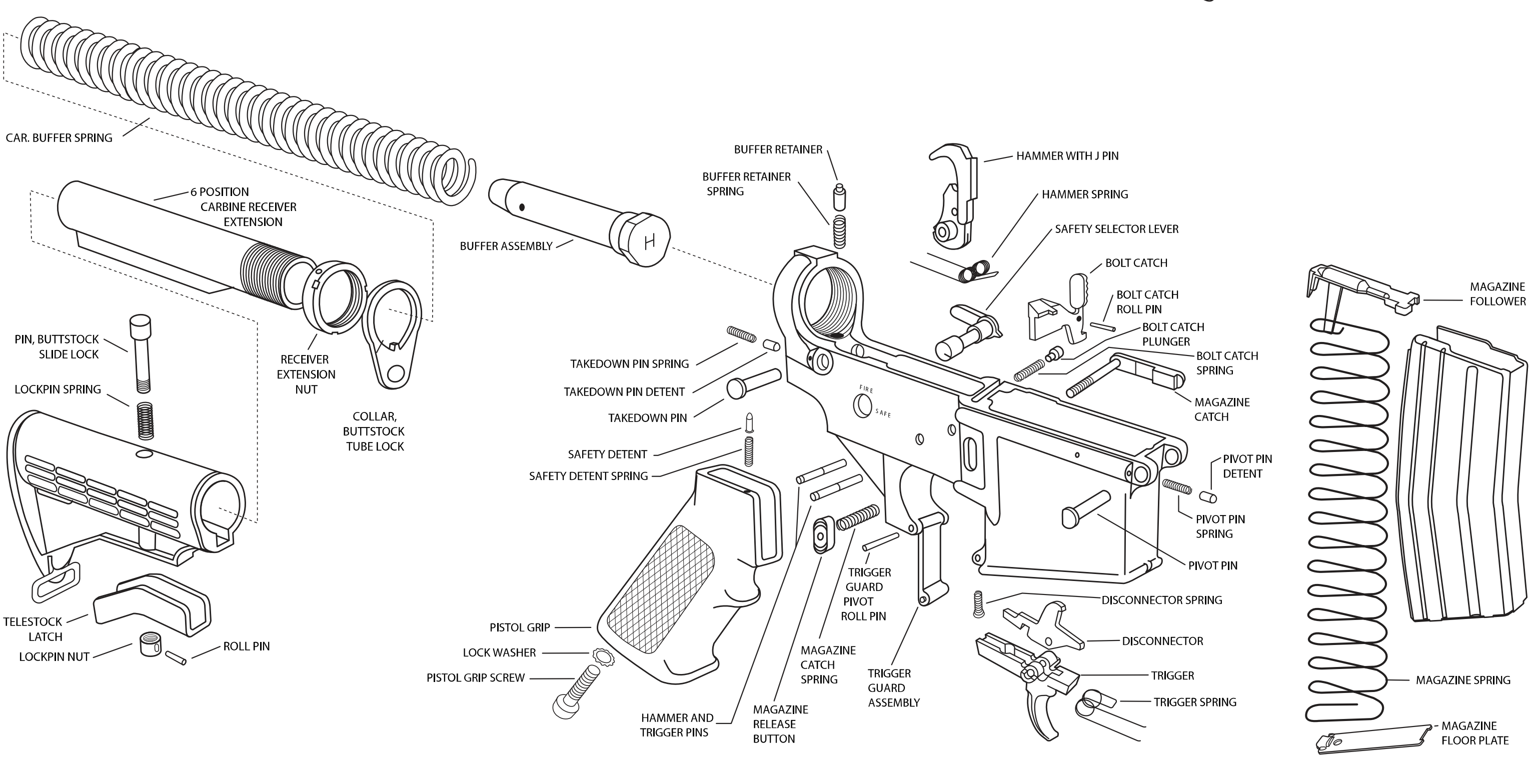
SHEET NO. 6
OF 8 SHEETS

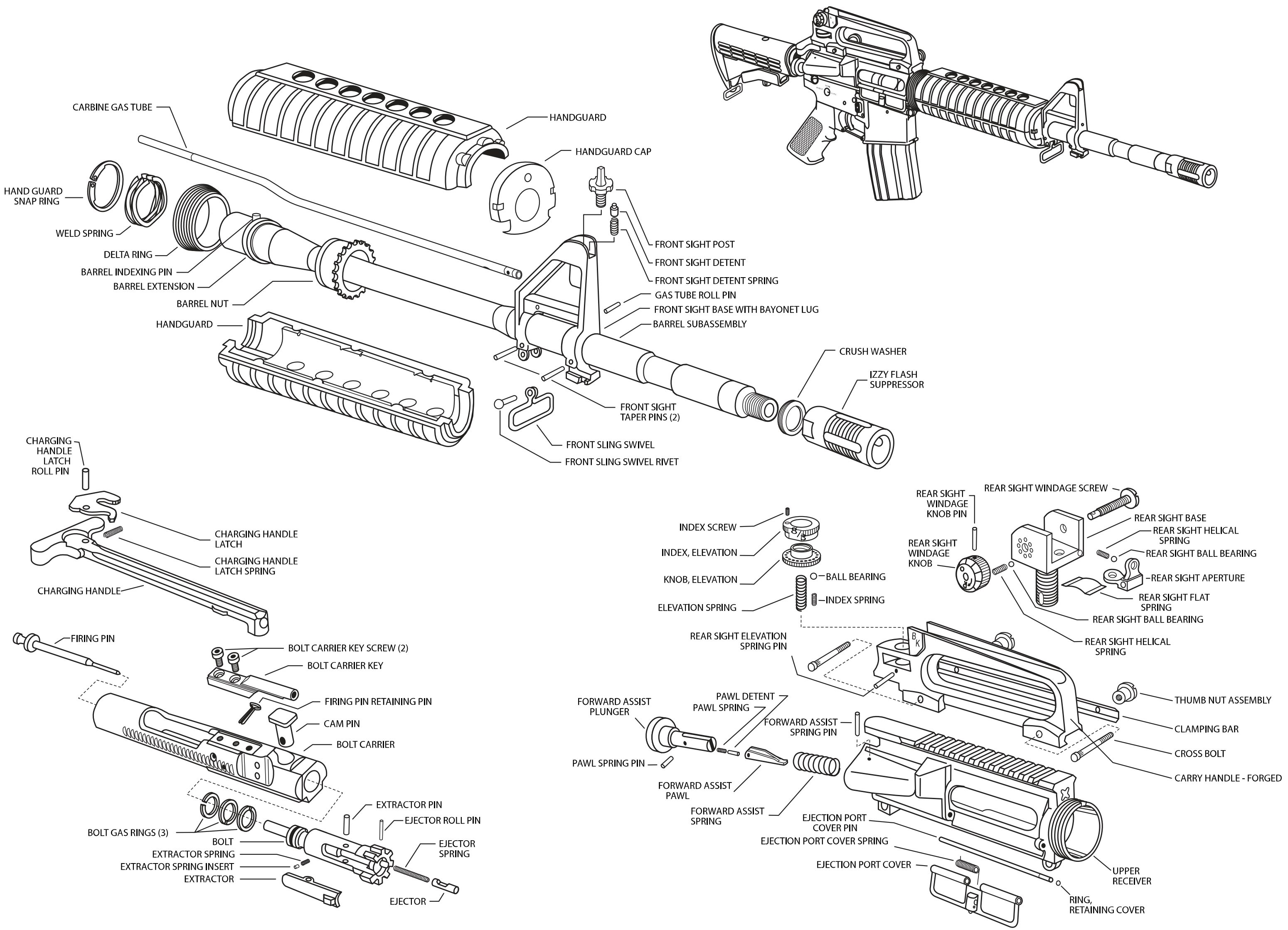
DRAWING NUMBER

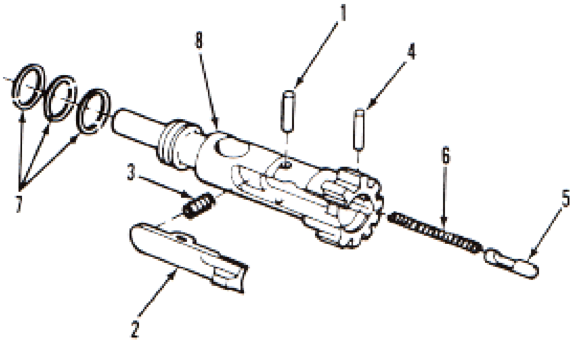
CODE	IDENT. NO.	SIZE	VAR.
		A	


CHARGING HANDLE LATCH ROLL PIN
CHARGING HANDLE LATCH
CHARGING HANDLE LATCH SPRING
CHARGING HANDLE
FIRING PIN
BOLT CARRIER KEY SCREW (2)
BOLT CARRIER KEY
FIRING PIN RETAINING PIN
CAM PIN
BOLT CARRIER
EXTRACTOR PIN
EJECTOR ROLL PIN
BOLT GAS RINGS (3)
BOLT
EXTRACTOR SPRING
EXTRACTOR SPRING INSERT
EXTRACTOR
EJECTOR SPRING
EJECTOR


CAR BUFFER SPRING
6 POSITION CARBINE RECEIVER EXTENSION
BUFFER ASSEMBLY
PIN, BUTTSTOCK SLIDE LOCK
LOCKPIN SPRING
RECEIVER EXTENSION NUT
COLLAR, BUTTSTOCK TUBE LOCK
TELESTOCK LATCH
LOCKPIN NUT
ROLL PIN


CAR. BUFFER SPRING
6 POSITION CARBINE RECEIVER EXTENSION
BUFFER ASSEMBLY
PIN, BUTTSTOCK SLIDE LOCK
RECEIVER EXTENSION NUT
LOCKPIN SPRING
COLLAR, BUTTSTOCK TUBE LOCK
TELESTOCK LATCH
LOCKPIN NUT
ROLL PIN
BUFFER RETAINER
BUFFER RETAINER SPRING
HAMMER WITH J PIN
HAMMER SPRING
SAFETY SELECTOR LEVER
BOLT CATCH
BOLT CATCH ROLL PIN
BOLT CATCH PLUNGER
BOLT CATCH SPRING
MAGAZINE CATCH
MAGAZINE FOLLOWER
TAKEDOWN PIN SPRING
TAKEDOWN PIN DETENT
TAKEDOWN PIN
SAFETY DETENT
SAFETY DETENT SPRING
FIRE
SAFE
H
PIVOT PIN DETENT
PIVOT PIN SPRING
PIVOT PIN
TRIGGER GUARD PIVOT ROLL PIN
DISCONNECTOR SPRING
DISCONNECTOR
TRIGGER
TRIGGER SPRING
PISTOL GRIP
LOCK WASHER
PISTOL GRIP SCREW
HAMMER AND TRIGGER PINS
MAGAZINE RELEASE BUTTON
MAGAZINE CATCH SPRING
TRIGGER GUARD ASSEMBLY
MAGAZINE SPRING
MAGAZINE FLOOR PLATE


CARBINE GAS TUBE
HANDGUARD
HANDGUARD CAP
HAND GUARD SNAP RING
WELD SPRING
DELTA RING
BARREL INDEXING PIN
BARREL EXTENSION
BARREL NUT
HANDGUARD
FRONT SIGHT POST
FRONT SIGHT DETENT
FRONT SIGHT DETENT SPRING
GAS TUBE ROLL PIN
FRONT SIGHT BASE WITH BAYONET LUG
BARREL SUBASSEMBLY
CRUSH WASHER
IZZY FLASH SUPPRESSOR
FRONT SIGHT TAPER PINS (2)
FRONT SLING SWIVEL
FRONT SLING SWIVEL RIVET
CHARGING HANDLE LATCH ROLL PIN
CHARGING HANDLE LATCH
CHARGING HANDLE LATCH SPRING
CHARGING HANDLE
FIRING PIN
BOLT CARRIER KEY SCREW (2)
BOLT CARRIER KEY
FIRING PIN RETAINING PIN
CAM PIN
BOLT CARRIER
EXTRACTOR PIN
EJECTOR ROLL PIN
BOLT GAS RINGS (3)
BOLT
EXTRACTOR SPRING
EXTRACTOR SPRING INSERT
EXTRACTOR
EJECTOR SPRING
EJECTOR
REAR SIGHT WINDAGE SCREW
REAR SIGHT WINDAGE KNOB PIN
REAR SIGHT BASE
REAR SIGHT HELICAL SPRING
REAR SIGHT BALL BEARING
REAR SIGHT WINDAGE KNOB
REAR SIGHT APERTURE
REAR SIGHT FLAT SPRING
REAR SIGHT BALL BEARING
REAR SIGHT HELICAL SPRING
INDEX SCREW
INDEX, ELEVATION
KNOB, ELEVATION
BALL BEARING
ELEVATION SPRING
INDEX SPRING
REAR SIGHT ELEVATION SPRING PIN
THUMB NUT ASSEMBLY
CLAMPING BAR
CROSS BOLT
CARRY HANDLE - FORGED
FORWARD ASSIST PLUNGER
PAWL DETENT
PAWL SPRING
FORWARD ASSIST SPRING PIN
PAWL SPRING PIN
FORWARD ASSIST PAWL
FORWARD ASSIST SPRING
EJECTION PORT COVER PIN
EJECTION PORT COVER SPRING
EJECTION PORT COVER
UPPER RECEIVER
RING, RETAINING COVER



Bolt

(1) Extractor Pin

(2) Extractor

(3) Extractor Spring Assembly

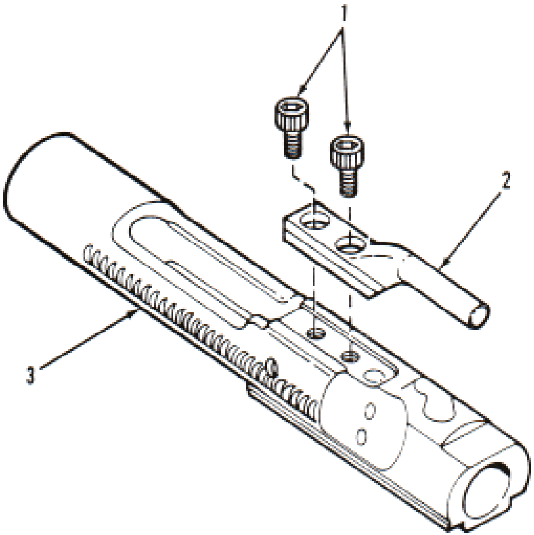
(4) Ejector Pin

(5) Ejector

(6) Ejector Helical Spring

(7) Bolt Rings

(8) Bolt

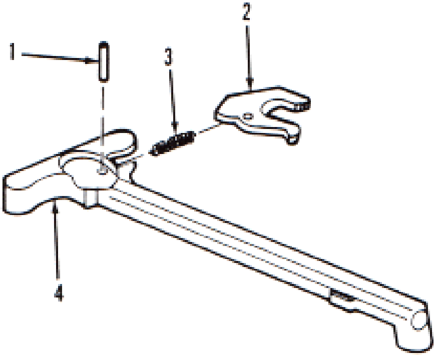


Key And Bolt Carrier Assembly

(1) Carrier And Key Screw

(2) Bolt Carrier Key

(3) Bolt Carrier



Charging Handle

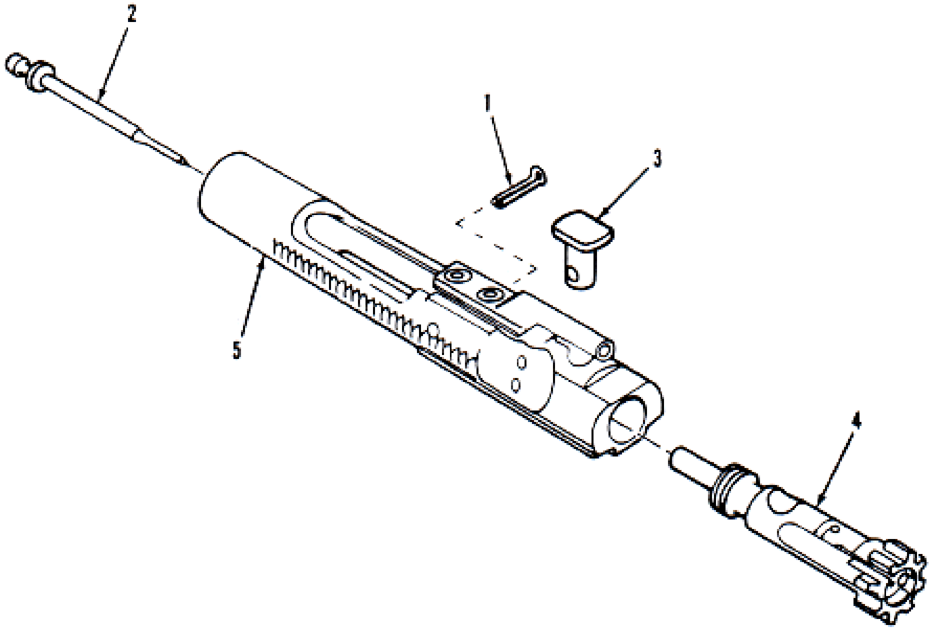
(1) Charging Handle Latch Pin

(2) Charging Handle Latch

(3) Charging Handle Latch Helical Spring

(4) Charging Handle

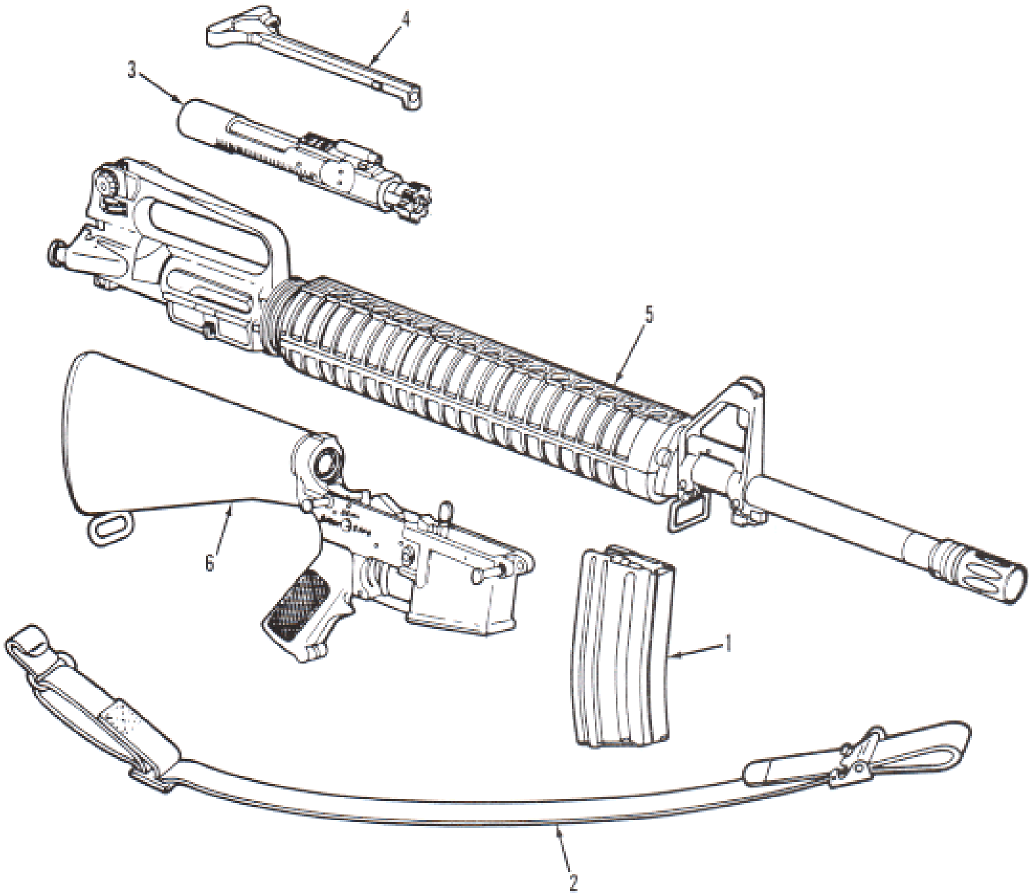
Parts Diagrams: Bolt Carrier Assembly

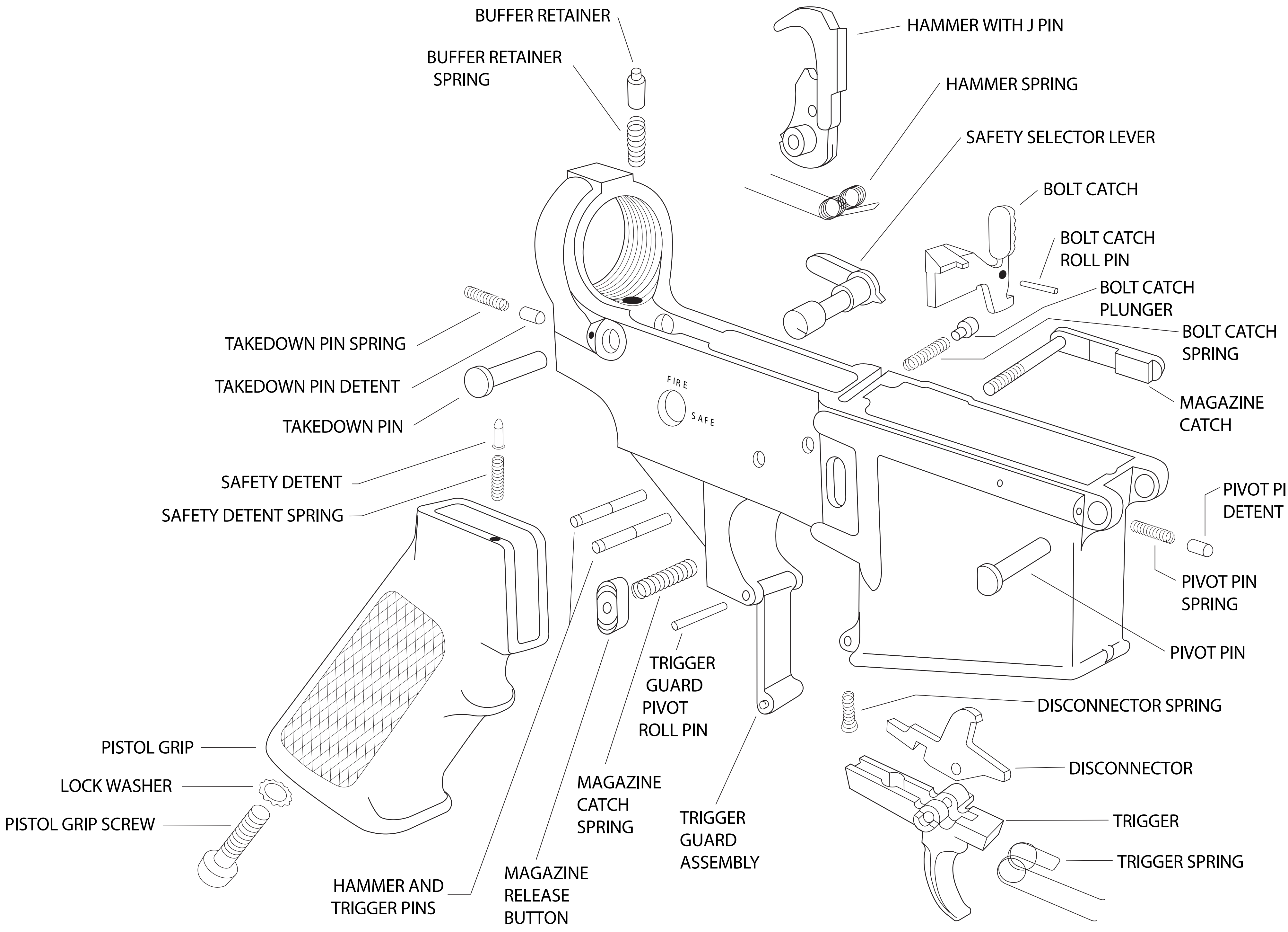


Bolt Carrier Assembly

(1) Firing Pin Retaining Pin
(2) Firing Pin
(3) Bolt Cam Pin
(4) Bolt Assembly
(5) Key and Bolt Carrier Assembly

www.ar15.com/content/guides/parts/boltcarrier.html




BUFFER RETAINER
BUFFER RETAINER SPRING
HAMMER WITH J PIN
HAMMER SPRING
SAFETY SELECTOR LEVER
BOLT CATCH
BOLT CATCH ROLL PIN
BOLT CATCH PLUNGER
BOLT CATCH SPRING
MAGAZINE CATCH
TAKEDOWN PIN SPRING
TAKEDOWN PIN DETENT
TAKEDOWN PIN
FIRE
SAFE
SAFETY DETENT
SAFETY DETENT SPRING
PIVOT PIN DETENT
PIVOT PIN SPRING
PIVOT PIN
TRIGGER GUARD PIVOT ROLL PIN
DISCONNECTOR SPRING
DISCONNECTOR
PISTOL GRIP
LOCK WASHER
PISTOL GRIP SCREW
MAGAZINE CATCH SPRING
TRIGGER GUARD ASSEMBLY
TRIGGER
TRIGGER SPRING
HAMMER AND TRIGGER PINS
MAGAZINE RELEASE BUTTON

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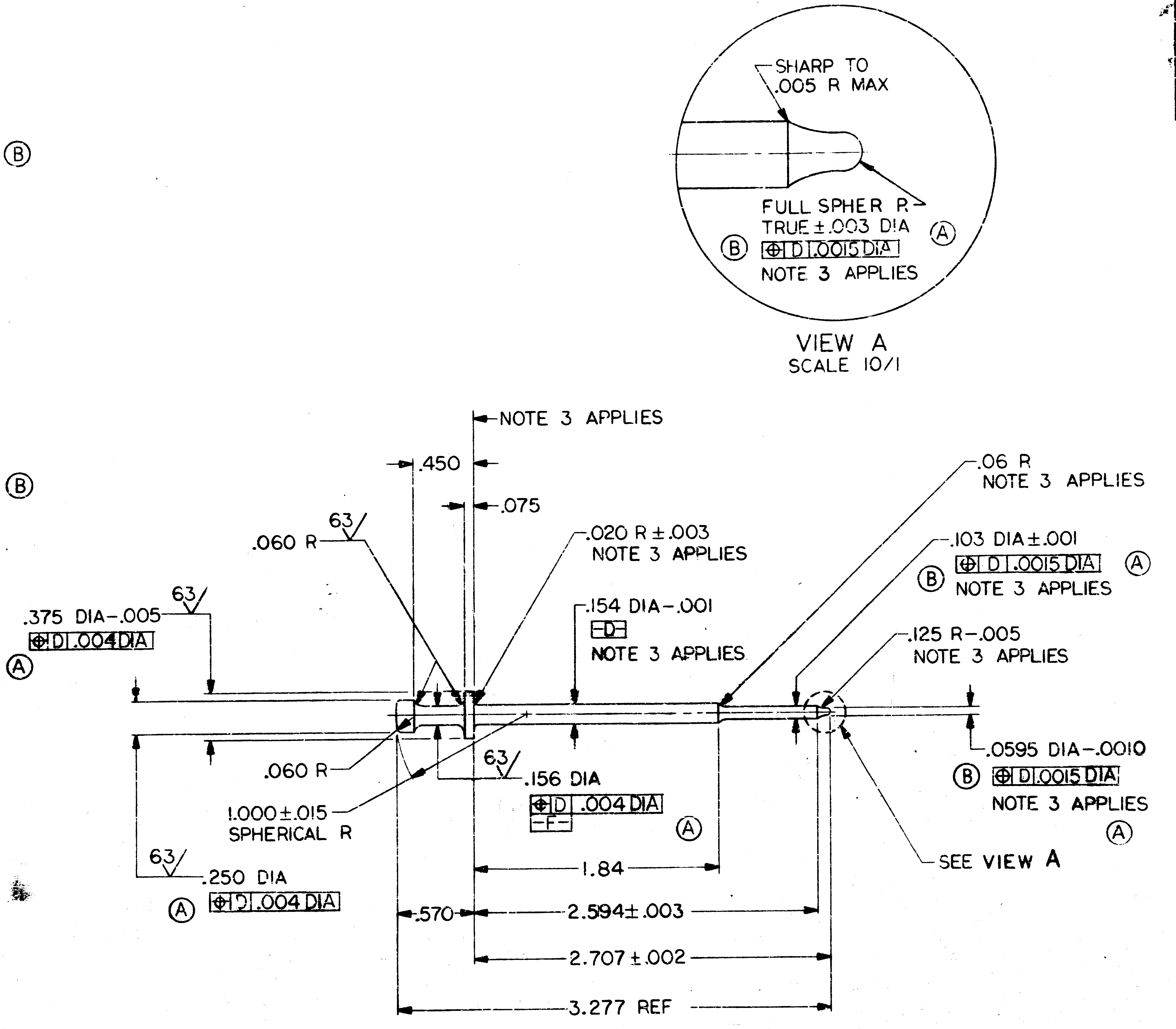
NOTE:

1. STEEL, CARPENTER 5-317, AISI 8640 OR AISI 8740. MATERIAL SHALL BE GUN QUALITY, ANNEALED TO A BRINNEL RANGE OF 187 TO 229. MEAN BRINNEL RANGE 210. Ⓑ
2. SUGGESTED HEAT TREAT PROCEDURE:
   FOR CARPENTER 5-317;
   HEAT IN NEUTRAL SALT BATH AT 1525°F ± 10°.
   QUENCH IN SALT BATH AT 605°F ± 5°. HOLD AT HEAT 18 TO 20 MINUTES. AIR COOL.
   FOR AISI 8640 AND AISI 8740; Ⓑ
   SAME PROCEDURE AS ABOVE EXCEPT QUENCH TEMPERATURE IS 585°F ± 5°.
3. GRIND AFTER HEAT TREAT. ALL GROUND SURFACES, INCLUDING RADII AND FILLETS, 32√.
4. FINISH 1.2.2.4 OF MIL-STD-171. FILM THICKNESS .0002 / .0003. CLAMP ELECTRODES ON DIA -F-. UNPLATED CONTACT AREA NOT TO EXCEED .06 DIA. Ⓑ
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010.
7. MIL-W-13855 APPLIES. Ⓐ



SHARP TO .005 R MAX
FULL SPHER R
TRUE ± .003 DIA Ⓐ
Ⓑ ⊕ D .0015 DIA
NOTE 3 APPLIES
VIEW A
SCALE 10/1
NOTE 3 APPLIES
.450
.075
.060 R
63√
.020 R ± .003
NOTE 3 APPLIES
.06 R
NOTE 3 APPLIES
.103 DIA ± .001
Ⓑ ⊕ D .0015 DIA Ⓐ
NOTE 3 APPLIES
.375 DIA -.005
⊕ D .004 DIA
Ⓐ
63√
.154 DIA -.001
-D-
NOTE 3 APPLIES
.125 R -.005
NOTE 3 APPLIES
.0595 DIA -.0010
Ⓑ ⊕ D .0015 DIA
NOTE 3 APPLIES Ⓐ
.060 R
63√ .156 DIA
⊕ D .004 DIA
-F-
Ⓐ
1.000 ± .015
SPHERICAL R
SEE VIEW A
63√ .250 DIA
Ⓐ ⊕ D .004 DIA
1.84
.570
2.594 ± .003
2.707 ± .002
3.277 REF

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
*			REDRAWN FROM COLT'S DRAWING D62294 REVISION B	27 APR 70	
		A	(7) SEE ERR HQR 20778	6 OCT 72	R.E.
		B	(6) SEE ERR HQR 30816	12 MAR 74	R.E.
		C	NOR W9S2009 80-02-13	80-05-16	
		D	ERR 29Z1285AU (ECP G063111, 90-07-06)	90-09-25	
		E	NOR G1S2018/910708	911011	RR

D3448503

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		8448501	M4
		D9327072	M231
BH			M16
		D3448501	M16A1, M16A2
RH	C45-49	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO.
DATE 27 APR 1970
PREPARED TTC
CHECKED
ENGINEER
SUBMITTED H. P. Wilhoolz
APPROVED R. S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CURRENT CODE IDENT NO. 19200

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, FIRING

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448503

SCALE 2/1 SHEET OF

CDI

AMSWE Form 403D, 29 Jul 69

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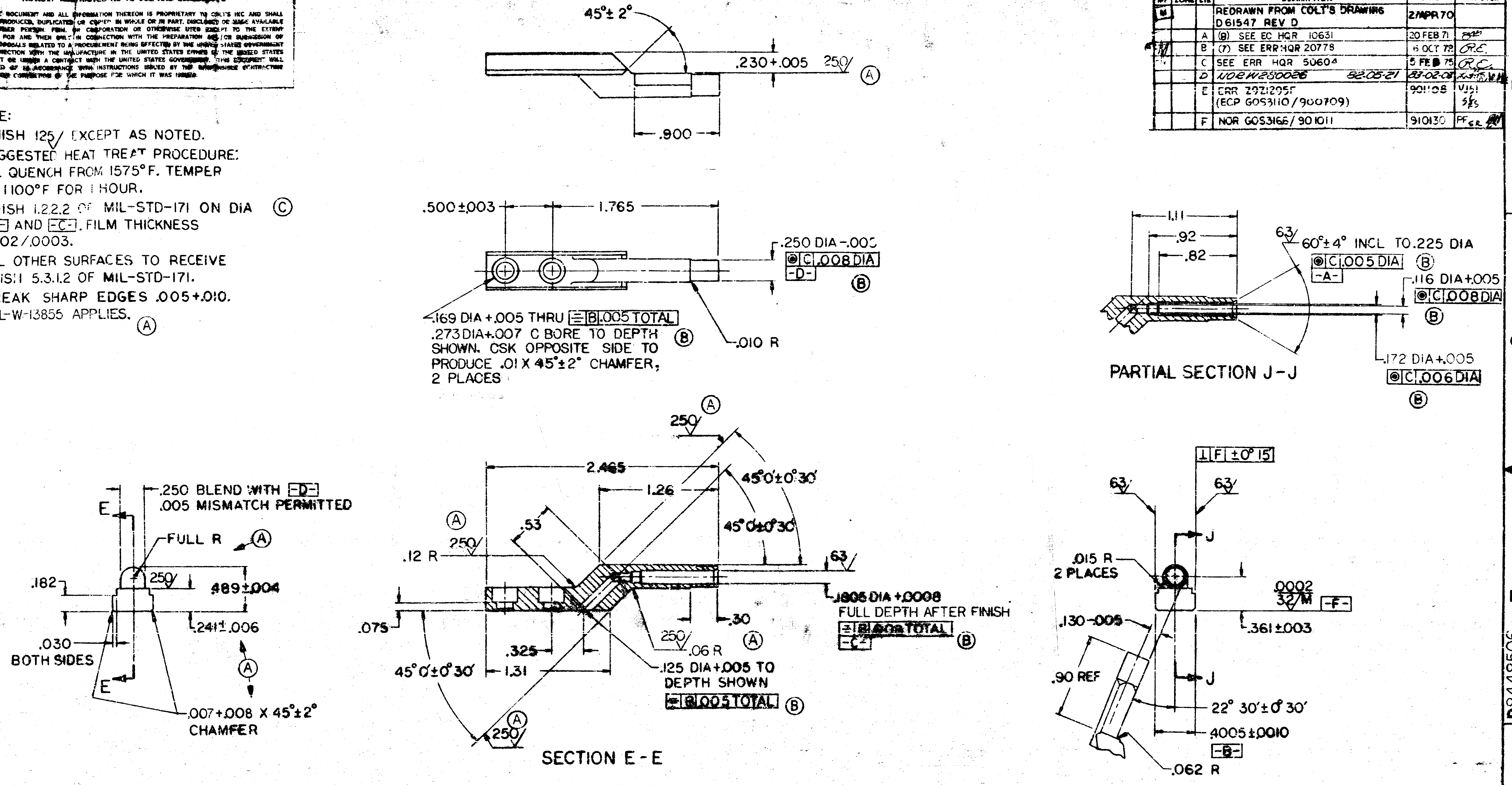
NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT PROCEDURE: OIL QUENCH FROM 1575°F. TEMPER AT 1100°F FOR 1 HOUR.
3. FINISH 1.22.2 OF MIL-STD-171 ON DIA -A- AND -C-. FILM THICKNESS .0002/.0003. Ⓒ
4. ALL OTHER SURFACES TO RECEIVE FINISH 5.3.1.2 OF MIL-STD-171.
5. BREAK SHARP EDGES .005+.010.
6. MIL-W-13855 APPLIES. Ⓐ

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D61547 REV D	27APR70	
		A	(8) SEE EC HQR 10631	20 FEB 71	
		B	(7) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	SEE ERR HQR 50604	5 FEB 75	R.C.
		D	NORW250026 82-05-21	83-02-08	
		E	ERR Z9Z1295F (ECP G0S3110/900709)	901108	VJS1 5/15
		F	NOR G0S3166/901011	910130	PF GR


45°± 2°
.230+.005
250/ Ⓐ
.900
.500±.003
1.765
.250 DIA -.005
◉ C .008 DIA
-D-
Ⓑ
.169 DIA +.005 THRU ⌯ B .005 TOTAL
.273 DIA+.007 C BORE TO DEPTH SHOWN. CSK OPPOSITE SIDE TO PRODUCE .01 X 45°±2° CHAMFER, 2 PLACES
Ⓑ
.010 R
1.11
.92
.82
63/
60°±4° INCL TO .225 DIA
◉ C .005 DIA Ⓑ
-A-
.116 DIA+.005
◉ C .008 DIA
Ⓑ
.172 DIA+.005
◉ C .006 DIA
Ⓑ
PARTIAL SECTION J-J
.250 BLEND WITH -D-
.005 MISMATCH PERMITTED
E
FULL R Ⓐ
.182
250/
.489±.004
.241±.006
.030 BOTH SIDES
E
Ⓐ
.007+.008 X 45°±2° CHAMFER
250/ Ⓐ
2.465
1.26
45°0'±0°30'
45°0'±0°30'
Ⓐ
.53
.12 R
250/
63/
.1805 DIA +.0008
FULL DEPTH AFTER FINISH
⌯ B .008 TOTAL
-C-
Ⓑ
.30
.075
.325
250/ .06 R Ⓐ
45°0'±0°30'
1.31
.125 DIA+.005 TO DEPTH SHOWN
⌯ B .005 TOTAL Ⓑ
Ⓐ 250/
SECTION E-E
⊥ F ±0°15'
63/
63/
J
.015 R
2 PLACES
.0002
32/M
-F-
.130-.005
.361±.003
.90 REF
J
22° 30'±0°30'
.4005±.0010
-B-
.062 R

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES					UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO:	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND, ROCK ISLAND, ILLINOIS, 61201
YS MIN					MATERIAL STEEL, AISI 4130 GUN QUALITY MAX BHN 229	DATE 27 APR 1970	KEY, BOLT CARRIER
YS MAX						PREPARED	
EL 2						CHECKED	
RA				M16A2		ENGINEER	
BH				M16		SUBMITTED	SIZE D
			C8448505	M16A1			CODE IDENT NO. 19204
RH	C26-32		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH SEE NOTES 3&4	APPROVED	DRAWING NO. 8448506
			APPLICATION				SCALE 2/1 SHEET OF

CDI

D8448506

MSWE Form 403D, 29 Jul 69

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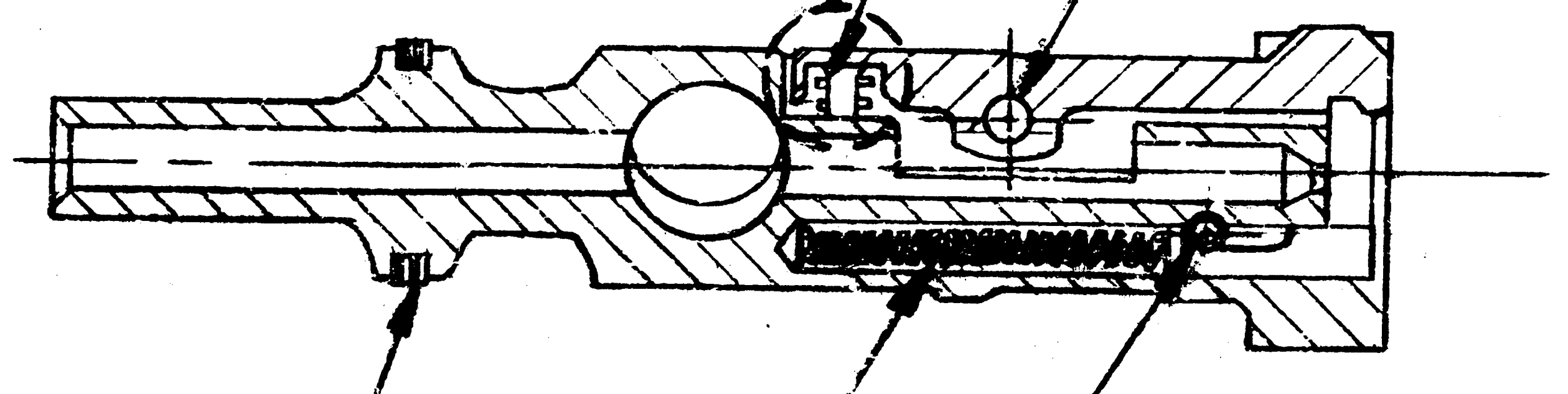
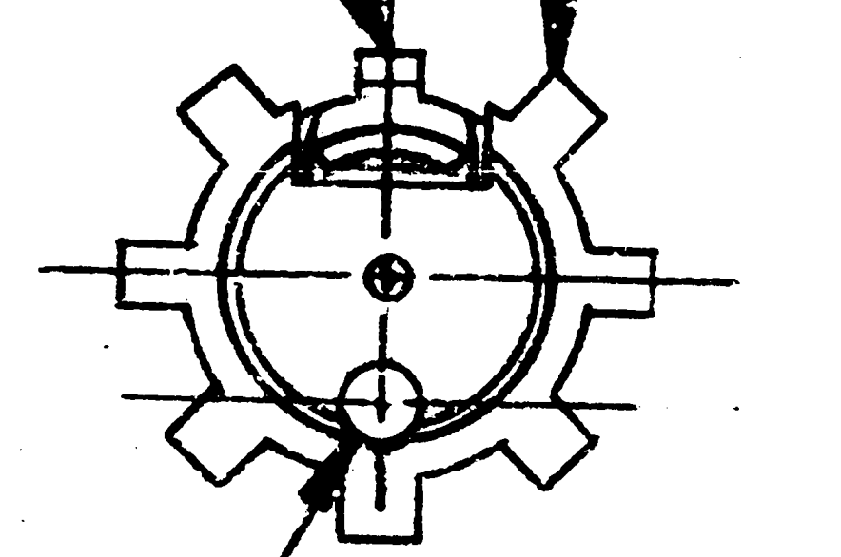
REVISIONS

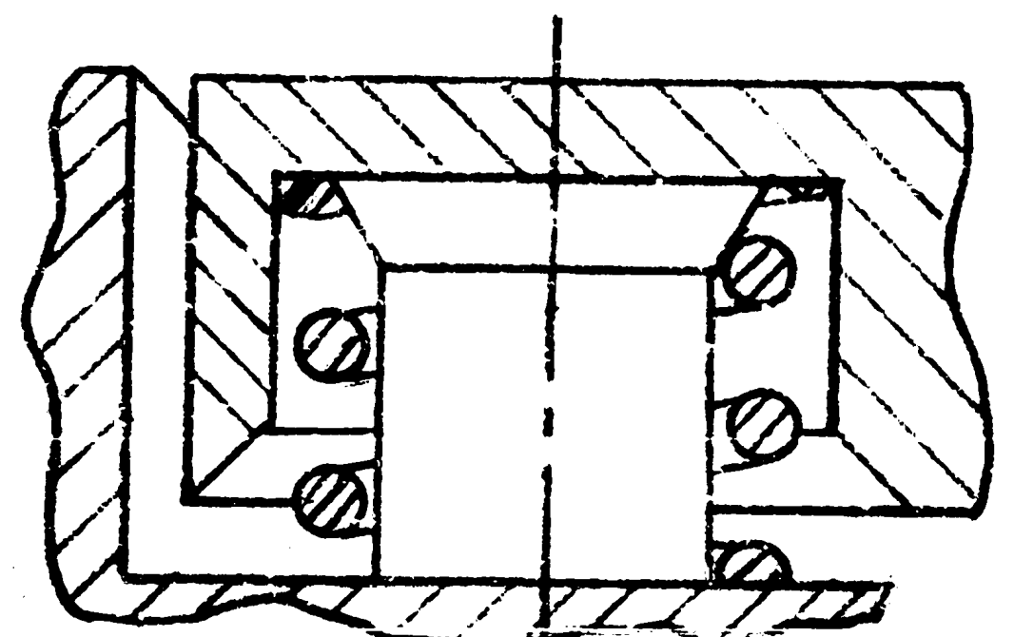
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M	-	D	REPLACES REV C W/CHANGE SEE ERR HQR 20778	6 OCT 72	RE
		E	NORW2S0020 82-06-09	83-02-03	LAH
		F	NOR W2S 0026 / 82-05-21	83-09-22	

NOTES:

1. MIL-W-13855 APPLIES.


SPRING ASSY, EXTRACTOR–8448755
FLARED END OF SPRING MUST BE BOTTOMED IN EXTRACTOR AS SHOWN IN VIEW A.
SEE VIEW A
PIN, EXTRACTOR – 8448513
3-RING, BOLT–8448511
RING GAPS MUST BE STAGGERED
PIN, SPRING-MS16562-98
SPRING, EJECTOR AND SAFETY DETENT–8448516


EXTRACTOR-8448512
BOLT-8448510
EJECTOR-8448515



VIEW A
SCALE 10/1

SEE PL-8448509

CURRENT DESIGN ACTIVITY FSCM No. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448509

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			M16
RH		D8448501	M16 A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±

MATERIAL

FINAL PROTECTIVE FINISH

CONTRACT NO:

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED A. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BOLT ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448509

SCALE 2/1 SHEET OF

AMSWE Form 403C, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

C8448509

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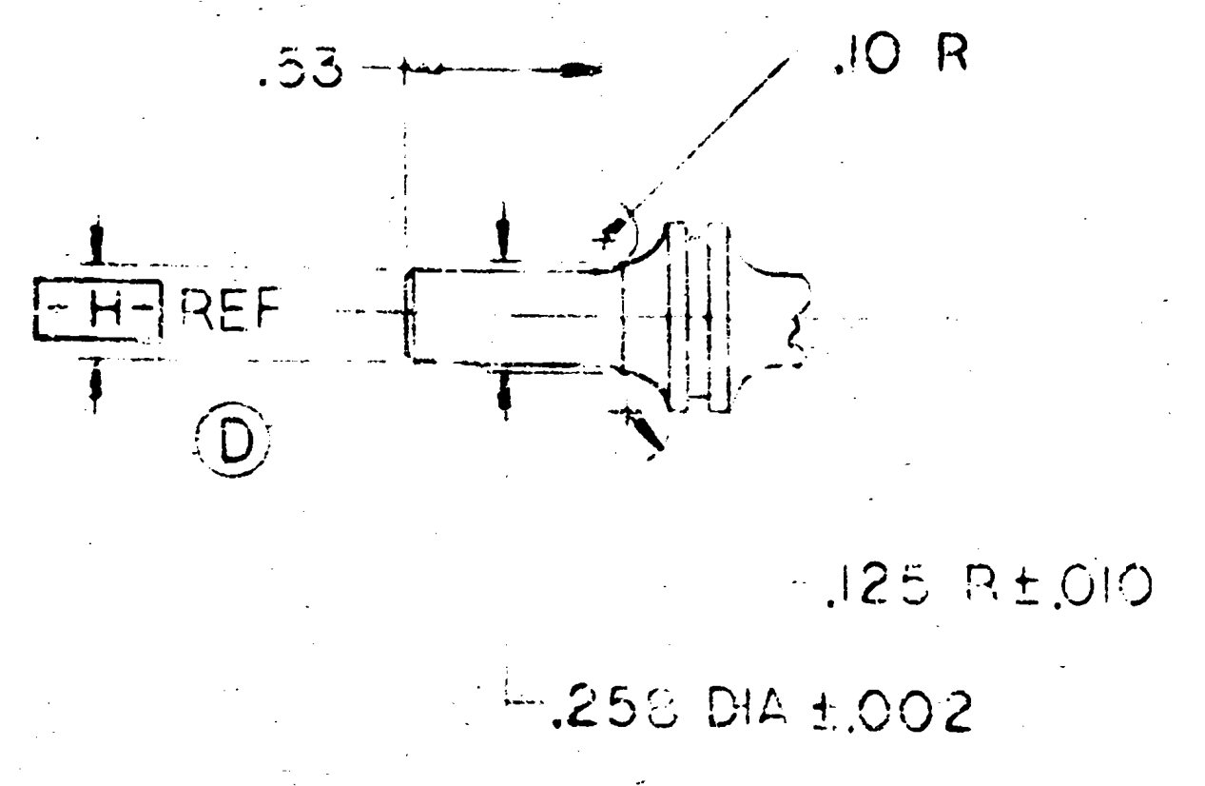
NOTES:

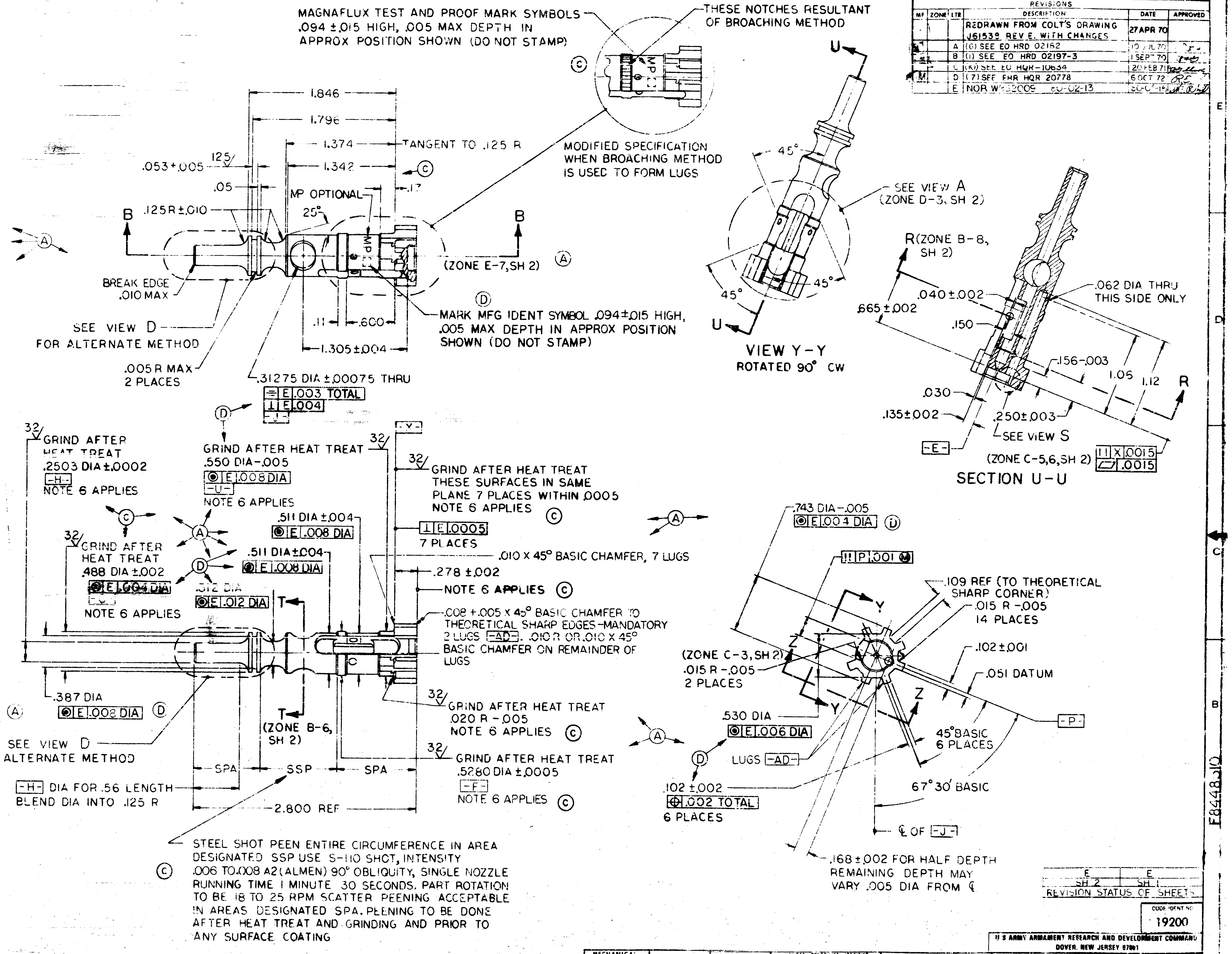
1. [illegible] CARPENTER 158 [illegible] QUALITY ANNEALED STRESS RELIEVED BAR. BRINNELL H[illegible] 195/235, AIM FOR 207/229.
2. FINISH $\overset{63}{\surd}$ EXCEPT AS NOTED.
3. AXIS -E- ESTABLISHED BY -F- AND -H-.
4. -P- ESTABLISHED BY INTERSECTION WITH -E- AND .051 DATUM.
5. DIAMETERS -F-, -G-, AND -H- TO BE CONCENTRIC TO EACH OTHER WITHIN .002 TOTAL.
6. .005 MINIMUM CASE DEPTH PERMISSIBLE.
7. EACH BOLT SHALL WITHSTAND FIRING A HIGH PRESSURE TEST CARTRIDGE XM157 WITHOUT EVIDENCE OF FAILURE. MAGNETIC PARTICLE INSPECT IN ACCORDANCE WITH MIL-I-6868 USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 200 TO 300 AMPERES. CIRCULAR AND LONGITUDINAL CONTINUOUS MAGNETIZATION AND A WET FLUORESCENT SOLUTION SHALL BE USED.
8. A. SUGGESTED HEAT TREATMENT PROCEDURE:
   - (1) STRESS RELIEVE AT 850° F FOR ONE HOUR.
   - (2) CARBURIZE IN A SALT BATH OR GAS CARBURIZING ATMOSPHERE TO SPECIFIED CASE DEPTH.
   - (3) OIL QUENCH.
   - (4) TEMPER ONE HOUR AT 350° TO 375° F.
   - (5) REFRIGERATE TO MINUS 110° F OR LOWER FOR TWO HOURS.
   - (6) REPEAT ONE HOUR, 350° TO 375° F TEMPER TREATMENT.

   B. MANDATORY HEAT TREATMENT REQUIREMENTS:
   - (1) CASE DEPTH .010 TO .014 TOTAL AND SURFACE HARDNESS ROCKWELL 15N89/90.5 (CASE DEPTH AND SURFACE HARDNESS APPLY PRIOR TO GRIND AFTER HEAT TREAT).
   - (2) MICROSTRUCTURE OF CARBURIZED CASE SHALL SHOW NO CARBIDE OR PRECIPITATE NETWORKS. IF PRESENT, CARBIDES OR INTERGRANULAR PRECIPITATES SHALL BE VERY FINE, WELL DISPERSED, AND EXTEND NO DEEPER THAN .0005 BELOW THE SURFACE.
   - (3) AFTER CARBURIZE AND QUENCHING OPERATIONS, TEMPER AT NOT LESS THAN 350° F FOR NOT LESS THAN ONE HOUR. REFRIGERATE AT MINUS 100° F OR LOWER FOR NOT LESS THAN TWO HOURS. RE-TEMPER AT NOT LESS THAN 350° F FOR NOT LESS THAN ONE HOUR.
   - (4) THE USE OF A STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED.
9. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓑ
10. MIL-W-13855 APPLIES. Ⓒ


.53
.10 R
-H- REF
Ⓓ
.125 R±.010
.250 DIA ±.002

VIEW D
ALTERNATE METHOD

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J61539 REV E. WITH CHANGES	27APR 70	
		A	(6) SEE EO HRD 02162	10 JUL 70	
		B	(1) SEE EO HRD 02197-3	1 SEPT 70	
		C	(10) SEE EO HQR-10634	20 FEB 71	
M		D	(7) SEE ERR HQR 20778	6 OCT 72	RE
		E	NOR W[illegible]2009 80-02-13	80-0[illegible]-1[illegible]	


MAGNAFLUX TEST AND PROOF MARK SYMBOLS .094 ±.015 HIGH, .005 MAX DEPTH IN APPROX POSITION SHOWN (DO NOT STAMP)
THESE NOTCHES RESULTANT OF BROACHING METHOD
MODIFIED SPECIFICATION WHEN BROACHING METHOD IS USED TO FORM LUGS
1.846
1.796
1.374
TANGENT TO .125 R
1.342
.053+.005
.05
125
.125R±.010
MP OPTIONAL
25°
.17
B
B
BREAK EDGE .010 MAX
SEE VIEW D FOR ALTERNATE METHOD
(ZONE E-7, SH 2)
MARK MFG IDENT SYMBOL .094±.015 HIGH, .005 MAX DEPTH IN APPROX POSITION SHOWN (DO NOT STAMP)
.11
.600
1.305±.004
.005 R MAX 2 PLACES
.31275 DIA ±.00075 THRU
E .003 TOTAL
E .004
U
45°
SEE VIEW A (ZONE D-3, SH 2)
VIEW Y-Y
ROTATED 90° CW
R(ZONE B-8, SH 2)
.040±.002
.665±.002
.150
.062 DIA THRU THIS SIDE ONLY
.156-.003
1.06
1.12
R
.030
.135±.002
.250±.003
SEE VIEW S (ZONE C-5,6, SH 2)
-E-
.0015
SECTION U-U
GRIND AFTER HEAT TREAT .2503 DIA ±.0002 -H- NOTE 6 APPLIES
GRIND AFTER HEAT TREAT .550 DIA-.005 E .008 DIA -U- NOTE 6 APPLIES
GRIND AFTER HEAT TREAT THESE SURFACES IN SAME PLANES 7 PLACES WITHIN .0005 NOTE 6 APPLIES
.511 DIA ±.004 E .008 DIA
.511 DIA±.004 E .008 DIA
E .0005 7 PLACES
.010 X 45° BASIC CHAMFER, 7 LUGS
GRIND AFTER HEAT TREAT .488 DIA ±.002 E .004 DIA NOTE 6 APPLIES
.312 DIA E .012 DIA
.278 ±.002
NOTE 6 APPLIES
.008 +.005 x 45° BASIC CHAMFER TO THEORETICAL SHARP EDGES-MANDATORY 2 LUGS -AD-. .010 R OR .010 x 45° BASIC CHAMFER ON REMAINDER OF LUGS
.387 DIA E .008 DIA
SEE VIEW D FOR ALTERNATE METHOD
T (ZONE B-6, SH 2)
GRIND AFTER HEAT TREAT .020 R -.005 NOTE 6 APPLIES
GRIND AFTER HEAT TREAT .5280 DIA ±.0005 -F- NOTE 6 APPLIES
-H- DIA FOR .56 LENGTH BLEND DIA INTO .125 R
SPA
SSP
SPA
2.800 REF
.743 DIA -.005 E .004 DIA
P .001
.109 REF (TO THEORETICAL SHARP CORNER)
.015 R -.005 14 PLACES
(ZONE C-3, SH 2)
.015 R -.005 2 PLACES
.102±.001
.051 DATUM
-P-
.530 DIA E .006 DIA
LUGS -AD-
.102 ±.002 .002 TOTAL 6 PLACES
45° BASIC 6 PLACES
67°30' BASIC
℄ OF -J-
.168±.002 FOR HALF DEPTH REMAINING DEPTH MAY VARY .005 DIA FROM ℄
Y
Z

Ⓒ STEEL SHOT PEEN ENTIRE CIRCUMFERENCE IN AREA DESIGNATED SSP USE S-110 SHOT, INTENSITY .006 TO .008 A2 (ALMEN) 90° OBLIQUITY, SINGLE NOZZLE RUNNING TIME 1 MINUTE 30 SECONDS. PART ROTATION TO BE 18 TO 25 RPM SCATTER PEENING ACCEPTABLE IN AREAS DESIGNATED SPA. PEENING TO BE DONE AFTER HEAT TREAT AND GRINDING AND PRIOR TO ANY SURFACE COATING

E	E
SH 2	SH 1

REVISION STATUS OF SHEETS

CODE IDENT NO 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801
~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		C5327073	M231
BH			M16
RH	SEE NOTE 8B	C8448509	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: 5.3.1.2 OF [illegible] P-171

CONTRACT NO
DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED R. A. Henry

BOLT

SIZE	CODE IDENT NO	DRAWING NO
F	~~19204~~	8448510

SCALE 2/1 SHEET 1 OF 2

Ⓒ

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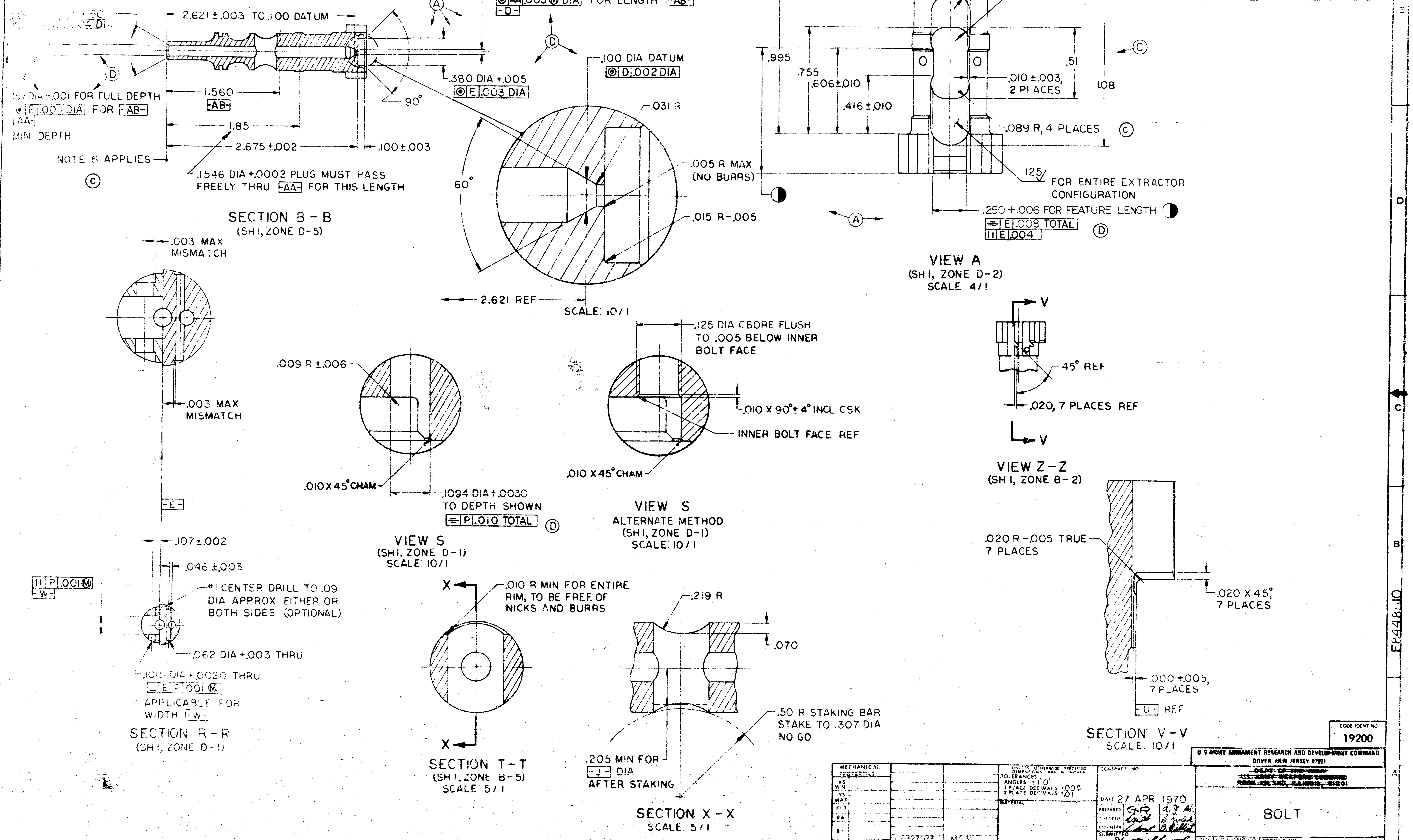
REVISIONS

MF	ZONE	LTR	DESCRIPTION	D	APPROVED
			REDRAWN FROM COLT'S DRAWING J61538 REV E. WITH CHANGES	27A[illegible]70	
		A	(4) SEE EO HRD 02162	10 JUL 70	
		B	NO CHANGE	1 SEPT 70	
		C	(4) SEE EO HQR 10634	20 FEB 7[illegible]	
		D	(4) SEE EPP HQR 20778	[illegible] OCT 72	R.C.
		E	NOR W952 80-02-13	80-05-15	


2.621 ±.003 TO .100 DATUM
.0635 DIA ±.0010
◎ AA .003 Ⓜ DIA FOR LENGTH -AB-
-D-
.380 DIA +.005
◎ E .003 DIA
.100 DIA DATUM
◎ D .002 DIA
.031 R
90°
60°
1.560
-AB-
1.85
2.675 ±.002
.100 ±.003
.1?7 DIA ±.001 FOR FULL DEPTH
◎ E .003 DIA FOR -AB-
-AA-
MIN DEPTH
NOTE 6 APPLIES
.1546 DIA +.0002 PLUG MUST PASS FREELY THRU -AA- FOR THIS LENGTH
.005 R MAX (NO BURRS)
.015 R -.005
2.621 REF
SCALE: 10/1
SECTION B - B
(SH1, ZONE D-5)
.010 ±.003, 2 PLACES
.125 R, 4 PLACES
.089 R, 4 PLACES
.995
.755
.606 ±.010
.416 ±.010
.51
1.08
.010 ±.003, 2 PLACES
.089 R, 4 PLACES
125 FOR ENTIRE EXTRACTOR CONFIGURATION
.250 +.006 FOR FEATURE LENGTH
E .008 TOTAL
E .004
VIEW A
(SH1, ZONE D-2)
SCALE 4/1
.003 MAX MISMATCH
.003 MAX MISMATCH
-E-
.107 ±.002
.046 ±.003
P .001 Ⓜ
-W-
#1 CENTER DRILL TO .09 DIA APPROX EITHER OR BOTH SIDES (OPTIONAL)
.062 DIA +.003 THRU
.1015 DIA +.0020 THRU
E P .001 Ⓜ
APPLICABLE FOR WIDTH -W-
SECTION R-R
(SH1, ZONE D-1)
.009 R ±.006
.010 X 45° CHAM
.1094 DIA +.0030 TO DEPTH SHOWN
P .010 TOTAL
VIEW S
(SH1, ZONE D-1)
SCALE 10/1
.125 DIA CBORE FLUSH TO .005 BELOW INNER BOLT FACE
.010 X 90° ± 4° INCL CSK
INNER BOLT FACE REF
.010 X 45° CHAM
VIEW S
ALTERNATE METHOD
(SH1, ZONE D-1)
SCALE 10/1
V
45° REF
.020, 7 PLACES REF
V
VIEW Z-Z
(SH1, ZONE B-2)
.020 R -.005 TRUE 7 PLACES
.020 X 45° 7 PLACES
.000 +.005, 7 PLACES
-U- REF
SECTION V-V
SCALE 10/1
X
.010 R MIN FOR ENTIRE RIM, TO BE FREE OF NICKS AND BURRS
X
SECTION T-T
(SH1, ZONE B-5)
SCALE 5/1
.219 R
.070
.50 R STAKING BAR STAKE TO .307 DIA NO GO
.205 MIN FOR -J- DIA AFTER STAKING
SECTION X-X
SCALE 5/1
A
B
C
D
E
8
7
6
5
4
3
2
1

FSP448-10

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL ?				
RA				
BH				
RH			C5327073	M231
			NEXT ASSY	USED ON
			APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1°0'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01
MATERIAL
FINAL PROTECTIVE FINISH

CONTRACT NO
DATE 27 APR 1970
PREPARED G.R. A.J.N.
CHECKED
ENGINEER
SUBMITTED
APPROVED T.S. Kenny

CODE IDENT NO 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801
~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

BOLT

SIZE F
CODE IDENT NO ~~19204~~
DRAWING NO 8448510
SCALE 2/1
SHEET 2 OF 2

CDI

AMSWE Form 4037 29 Jun 69

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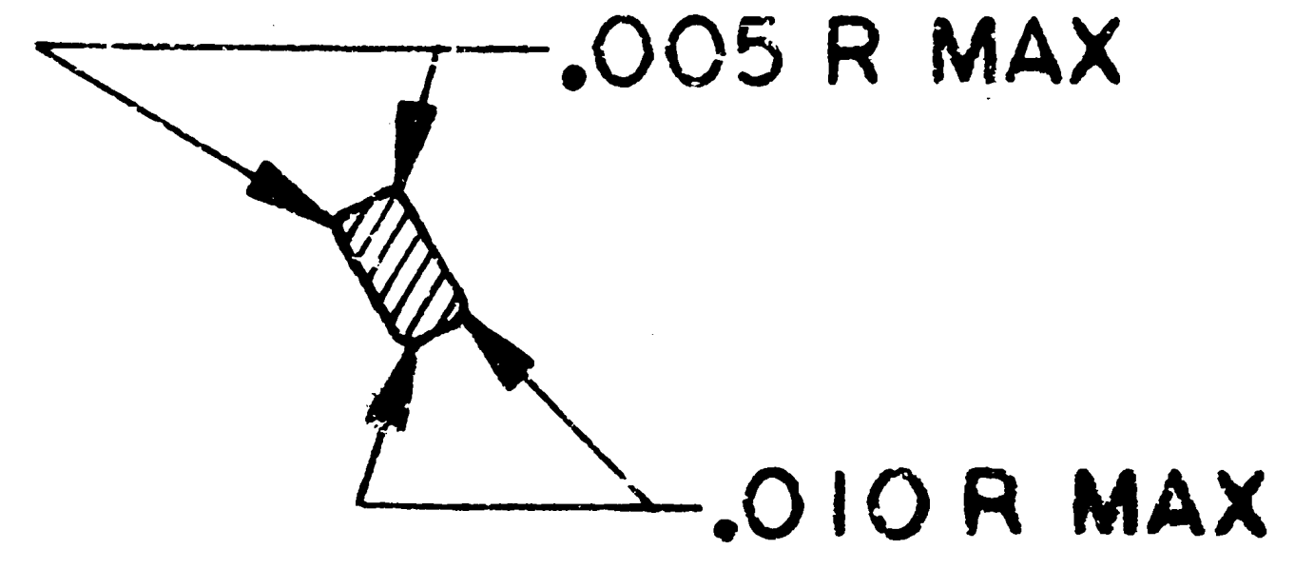
REVISIONS

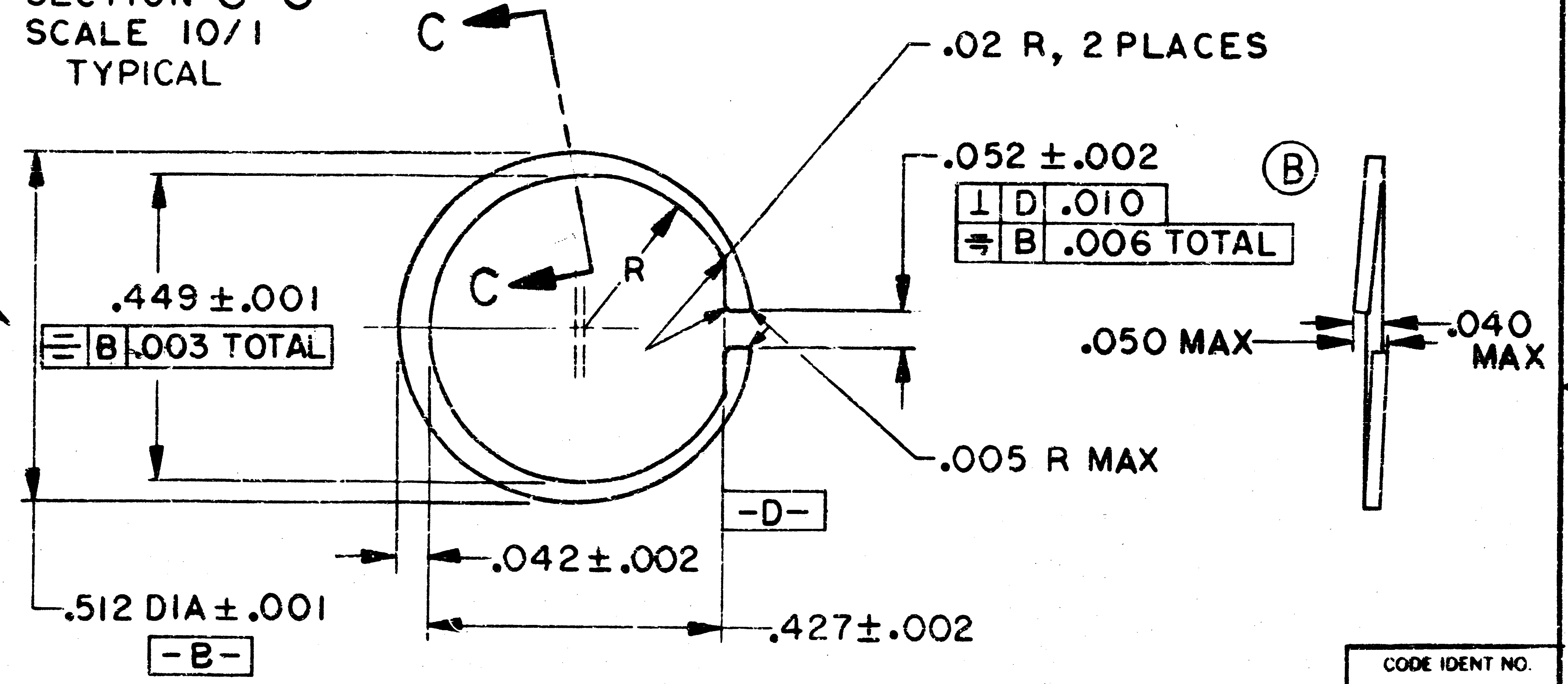
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61540 REVISION B	27APR 70	
		A	(2) SEE ERR HQR 10852	24 SEP 71	LB
M		B	(2) SEE ERR HQR 20778	6 OCT 72	RE
		C	NOR W9S2009 80-02-13	80-05-16	



SECTION C-C
SCALE 10/1
TYPICAL

NOTE:

1. STEEL, CORROSION-RESISTANT, PER MIL-S-5059. CMPSN 302 OR 304, CONDITION HARD, THICKNESS .016±.001. Ⓐ
2. FINISH 125/√ EXCEPT AS NOTED IN NOTE 4. Ⓑ
3. EDGES TO BE SHARP TO .005 R MAX.
4. MAX DIE BREAK ON -B- TO BE 50%. FINISH ON SHEARED SURFACE TO BE 63/√.
5. FINISH 5.4.1 OF MIL-STD-171.
6. MIL-W-13855 APPLIES. Ⓐ



CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES ± —— 3 PLACE DECIMALS ± —— 2 PLACE DECIMALS ± .01	CONTRACT NO DATE 27 APR 1970
YS MIN					PREP
YS MAX		C9327073	M231		CHK
EL 2			M16	MATERIAL SEE NOTE 1	ENGR
RA					SUBMITTED F. P.
BH		C8448509	M16A1		
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH SEE NOTE 5	APPROVED R. S. Henry
RH		APPLICATION			

~~DEPT OF THE ARMY~~
~~US ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

RING, BOLT

SIZE	CODE IDENT NO	DRAWING NO
B	~~19204~~	8448511

SCALE 5/1 SHEET 1 OF 1

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AMSWE Form 403B, 29 Jul 69

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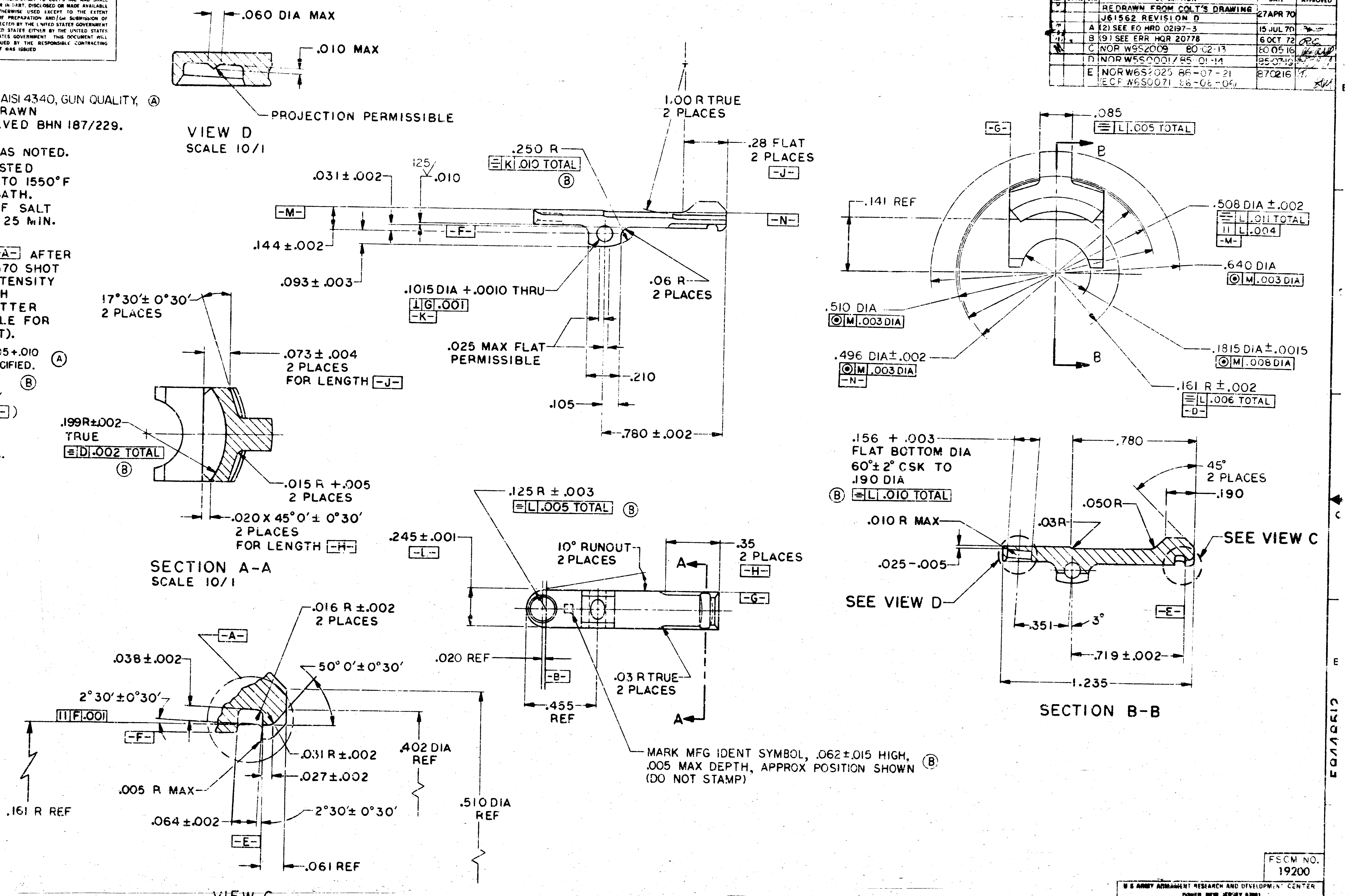
NOTES:

1. STEEL, AISI 4140 OR AISI 4340, GUN QUALITY, Ⓐ ANNEALED, COLD DRAWN AND STRESS RELIEVED BHN 187/229.
2. FINISH $\overset{63}{\checkmark}$ EXCEPT AS NOTED.
3. AUSTEMPER SUGGESTED PROCEDURE: HEAT TO 1550°F IN NEUTRAL SALT BATH. TRANSFER TO 680°F SALT BATH. HOLD 20 TO 25 MIN. AIR COOL.
4. SHOT PEEN AREA -A- AFTER HEAT TREAT WITH S70 SHOT .006 TO .008A2 INTENSITY IN ACCORDANCE WITH MIL-S-13165 (SCATTER PEENING PERMISSIBLE FOR REMAINDER OF PART).
5. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓐ
6. START OF 10° RUNOUT Ⓑ SHALL BE LOCATED BY .125 R(LOCATED ON -B-) INTERSECTION WITH SURFACE -L-.
7. MIL-W-13855 APPLIES.



.060 DIA MAX
.010 MAX
PROJECTION PERMISSIBLE
VIEW D
SCALE 10/1
1.00 R TRUE
2 PLACES
.28 FLAT
2 PLACES
-J-
.250 R
≡ K .010 TOTAL Ⓑ
.031±.002
125 ✓ .010
-M-
-F-
-N-
.144±.002
.093±.003
.1015 DIA +.0010 THRU
⊥ G .001
-K-
.06 R
2 PLACES
.025 MAX FLAT PERMISSIBLE
.210
.105
.780±.002
17°30'± 0°30'
2 PLACES
.073±.004
2 PLACES
FOR LENGTH -J-
.199R±.002
TRUE
≡ D .002 TOTAL Ⓑ
.015 R +.005
2 PLACES
.020 X 45°0'± 0°30'
2 PLACES
FOR LENGTH -H-
SECTION A-A
SCALE 10/1
.125 R ±.003
≡ L .005 TOTAL Ⓑ
.245±.001
-L-
10° RUNOUT
2 PLACES
.35
2 PLACES
-H-
-G-
A
.020 REF
-B-
.455
REF
.03 R TRUE
2 PLACES
A
.016 R ±.002
2 PLACES
-A-
.038±.002
50° 0'±0°30'
2°30'±0°30'
∥ F .001
-F-
.031 R±.002
.027±.002
.402 DIA
REF
.005 R MAX
.161 R REF
.510 DIA
REF
.064±.002
2°30'± 0°30'
-E-
.061 REF
VIEW C
SCALE 10/1
MARK MFG IDENT SYMBOL, .062±.015 HIGH, .005 MAX DEPTH, APPROX POSITION SHOWN (DO NOT STAMP) Ⓑ
.085
≡ L .005 TOTAL
-G-
B
.141 REF
.508 DIA ±.002
≡ L .011 TOTAL
∥ L .004
-M-
.640 DIA
◎ M .003 DIA
.510 DIA
◎ M .003 DIA
.496 DIA±.002
◎ M .003 DIA
-N-
.1815 DIA±.0015
◎ M .008 DIA
B
.161 R ±.002
≡ L .006 TOTAL
-D-
.156 + .003
FLAT BOTTOM DIA
60°± 2° CSK TO
.190 DIA
Ⓑ ≡ L .010 TOTAL
.780
45°
2 PLACES
.190
.050 R
.03R
.010 R MAX
SEE VIEW C
.025-.005
SEE VIEW D
.351
3°
-E-
.719±.002
1.235
SECTION B-B

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J61562 REVISION D	27APR 70	
		A	(2) SEE EO HRD 02197-3	15 JUL 70	
		B	(9) SEE ERR HQR 20778	6 OCT 72	R.E.
		C	NOR W9S2009 80-02-13	80 05 16	
		D	NOR W5S0001/85-01-14	85-07-19	
		E	NOR W6S2025 86-07-21 (ECF W6S0071 86-08-06)	870216	

FSCM NO.
19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		C9329703	M231
BH			M16
RH	C42-44	C8448509	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO
DATE 27APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

EXTRACTOR

SIZE F
CODE IDENT NO 19204
DRAWING NO 8448512
SCALE 4/1
SHEET 1 OF 1

CDI

AMSWE Form 403F, 29 Jul 69

5 4 3 2 1

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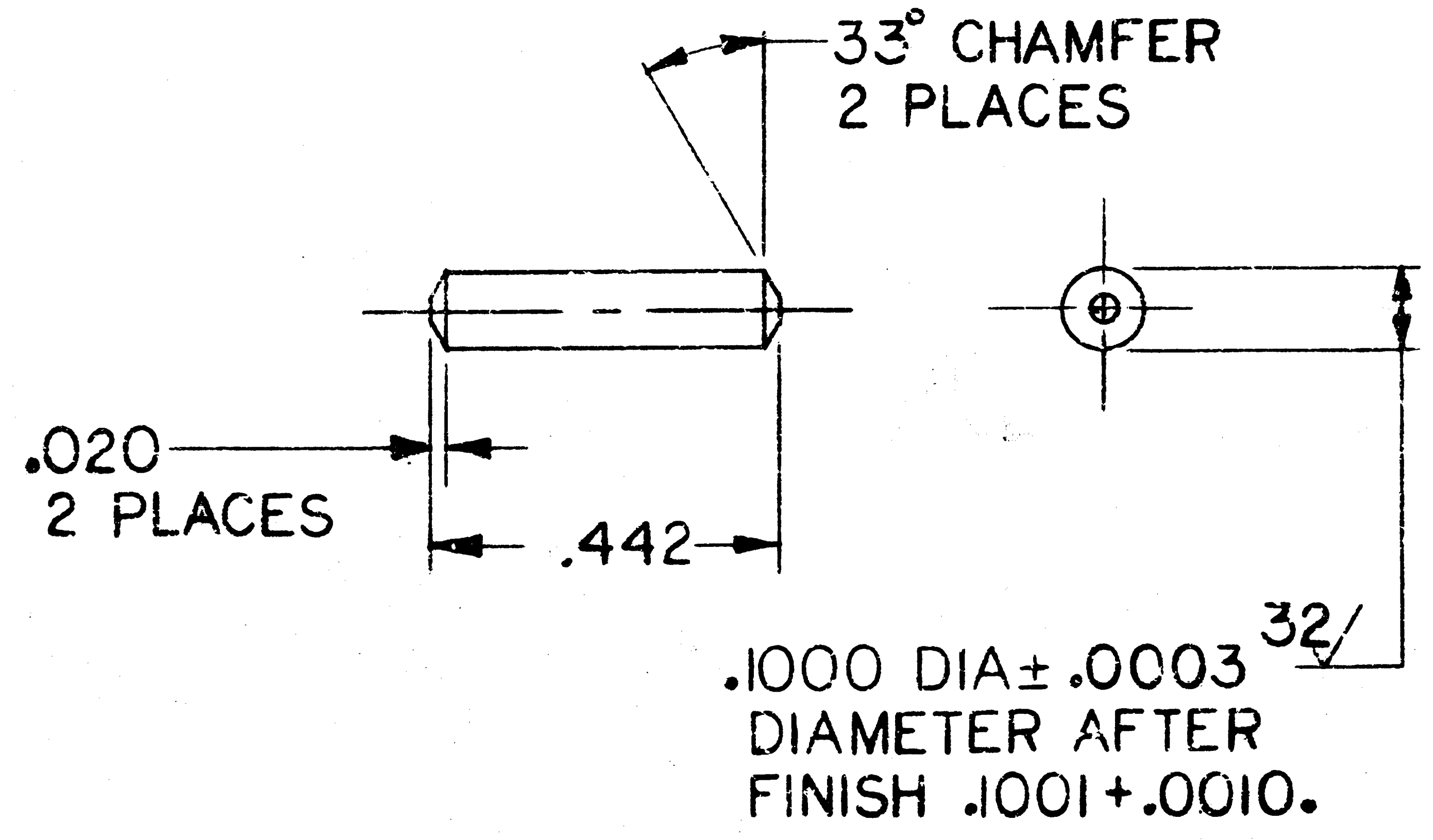
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61563 REV C	27 APR70	
M		A	(3) SEE ERRHQR 20778	6 OCT 72	R.E.
		B	NOR W9S2009 80-02-13	80-05-16	RJW

NOTE:

1. FINISH 125 EXCEPT AS NOTED.
2. OIL QUENCH FROM 1600°F, TEMPER AT 275°F TO 400°F. Ⓐ
3. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005+.002-A2 ALMEN, 150% COVERAGE.
4. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT OMIT SANDBLAST.
5. ~~MIL-W-13855~~ APPLIES. Ⓐ



8448513

Ⓐ

CODE IDENT NO.	19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		C9327073	M 231
EL 2			M16
RA		C8448509	M16A1
BH		NEXT ASSY	USED ON
RH	15N 88.5—90.5	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± ——

MATERIAL
TOOL STEEL, CLASS S2,
SPEC QQ-T-570

FINAL PROTECTIVE FINISH
SEE NOTE 4

CONTRACT NO		
DATE	27 APR 1970	
PREP	B.R.L.	a.J.H.
CHK	D.H.	
ENGR		
SUBMITTED	F.P. Gilhool	
APPROVED	R.S. Henry	

PIN, EXTRACTOR

SIZE	CODE IDENT NO	DRAWING NO
B	~~19204~~	8448513

SCALE 4/1 SHEET OF

CDI

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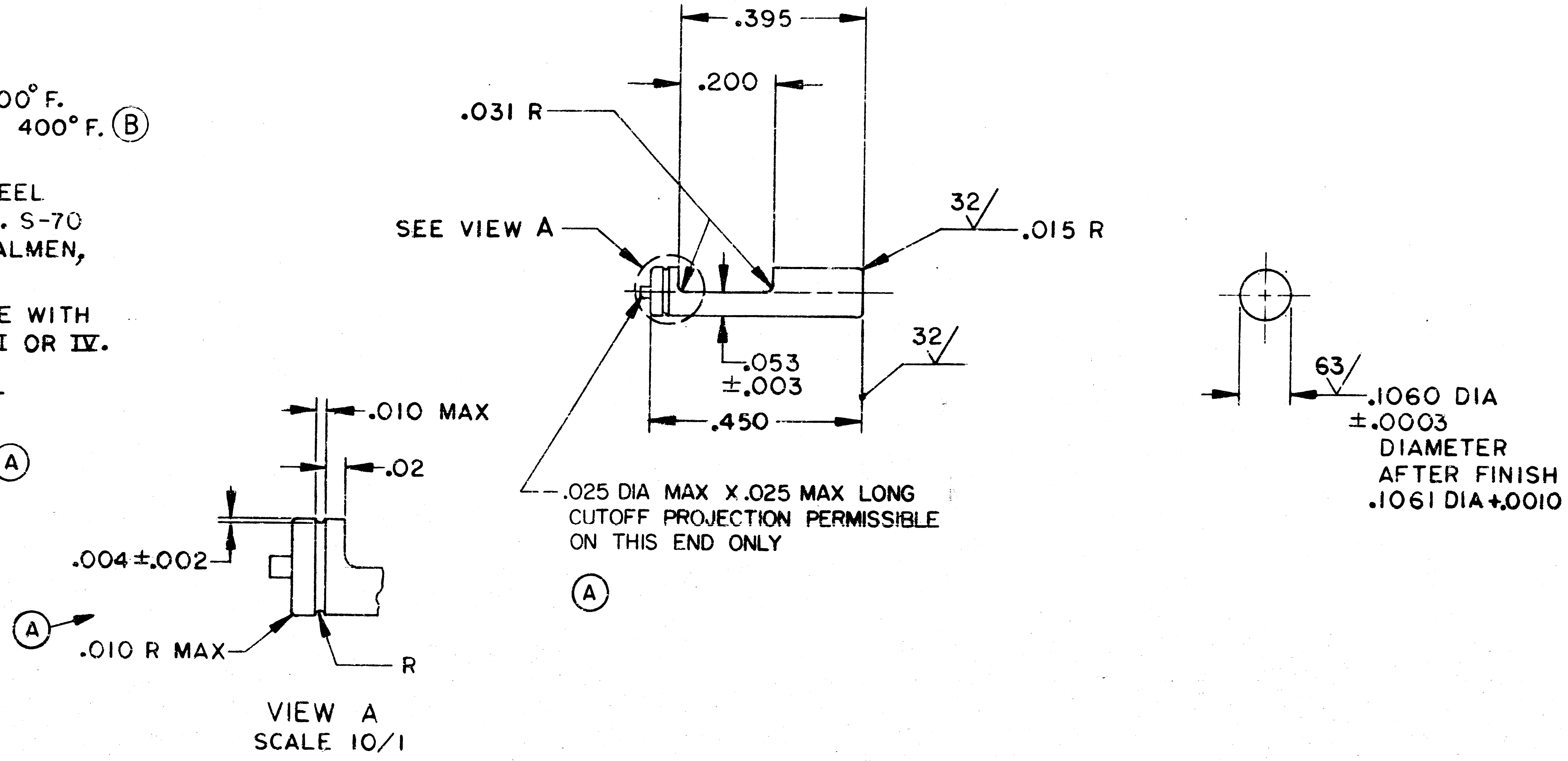
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61564 REVISION B	27 APR 70	
M		A	(3) SEE EO HRD 02255	15 OCT 70	F.P. Gillooly
M		B	(2) SEE ERR HQR 20778	6 OCT 72	
		C	NOR W9S2009 80-02-13	80-05-16	

NOTE:

1. FINISH 125/√ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 R MAX.
3. OIL QUENCH FROM 1600° F. TEMPER AT 275° F TO 400° F. Ⓑ
4. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005-.007-A2 ALMEN, 150 % COVERAGE.
5. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT OMIT SANDBLAST.
6. MIL-W-13855 APPLIES. Ⓐ



C8448515

Ⓑ

MECHANICAL PROPERTIES		APPLICATION	
YS MIN			
YS MAX			
EL 2			
RA		C9327073	M231
BH			M16
RH	15N 88.5 -90.5	C8448509	M16A1
		NEXT ASSY	USED ON

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
TOOL STEEL, CLASS S2, SPEC QQ-T-570

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO.
DATE 27 APR 1970
PREPARED R61
CHECKED
ENGINEER D. Bilket
SUBMITTED P. Gillooly
APPROVED K. S. Henry

CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

EJECTOR

SIZE C
CODE IDENT NO
DRAWING NO. 8448515
SCALE 5/1
SHEET 1 OF 1

CDI

AMSWE Form 403C, 29 Jul 69

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778	6 OCT 72	L B
		D	NOR W9S2009 80-02-13	80-05-16	
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)	83-11-04	

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER ______ .0240 ± .0003
COIL DIAMETER (O.D) ______ .103 ± .003
FREE LENGTH AFTER SETTING ______ .926 REF
TOTAL COILS ______ 27 REF
DIRECTION OF HELIX ______ OPTIONAL
LOAD AT COMPRESSED LENGTH OF .850 ______ 2.94 LB ± .30 LB
LOAD AT COMPRESSED LENGTH OF .784 ______ 5.50 LB ± .25 LB
SPRING RATE ______ ______
SOLID LENGTH ______ .650 MAX
TYPE OF ENDS ______ SQUARED, GROUND
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC QQ-W-470. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ± 25° FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 + .012 .

CURRENT

FSCM NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448516

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		F9327230	M231
YS MAX			M16
EL 2		C8448509	M16A1
RA		F8448604	M16
BH		F8448578	M16A1
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 27 APR 70
PREP P. Vernon
CHK
ENGR R. Elbe
SUBMITTED R. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, EJECTOR AND SAFETY DETENT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448516

SCALE NONE SHEET 1 OF 1

B8448516

AMSWE Form 403B, 29 Jul 69

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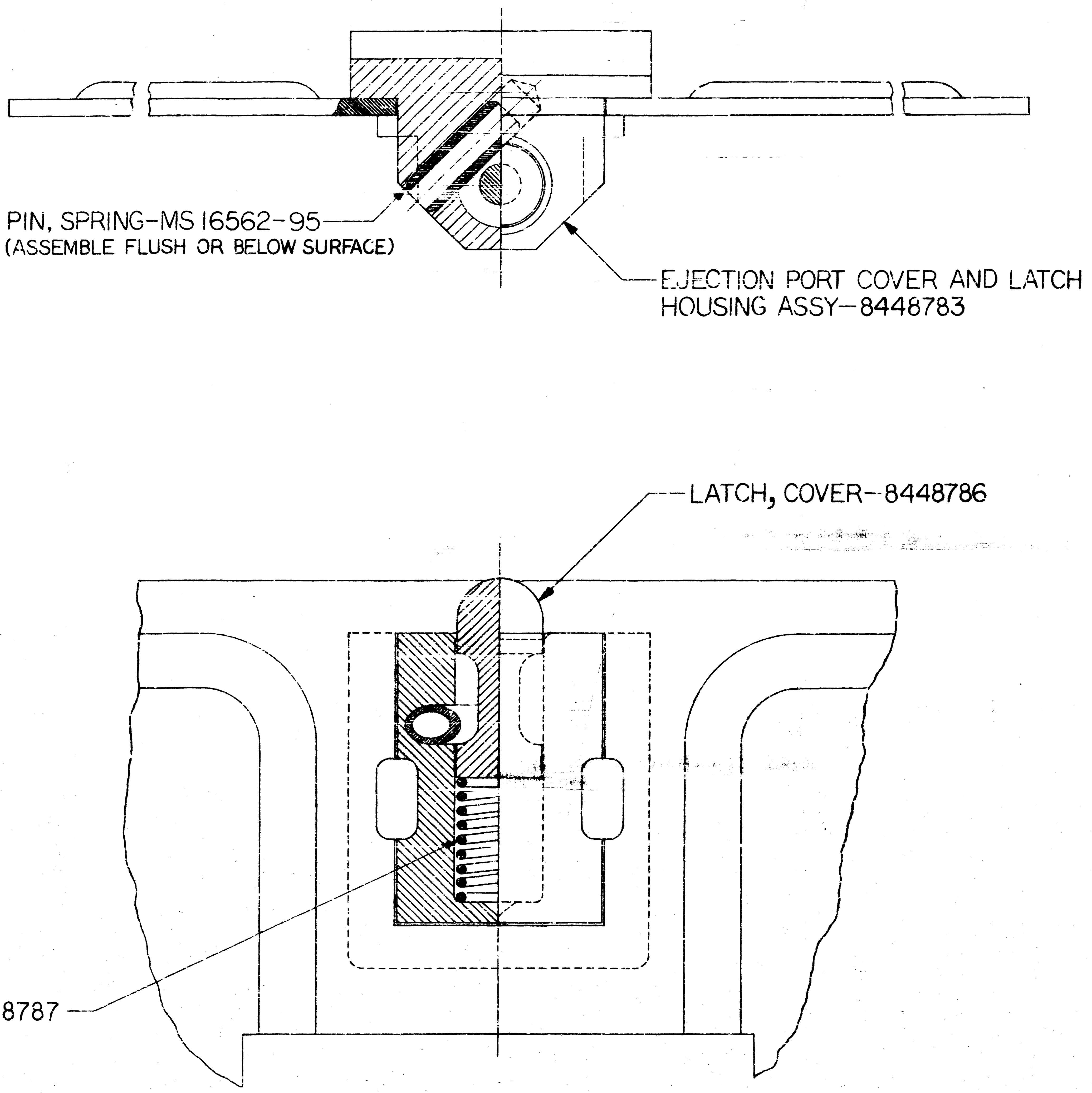
NOTES:

1. THE LOAD NECESSARY TO DEPRESS THE LATCH, COVER 8448786, .060 INCHES FROM ITS ASSEMBLED POSITION SHALL BE 1.2 ± .3 LB.
2. MIL-W-13855 APPLIES.

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	REPLACES REV (-) W/CHANGE SEE ERR HQR 20748	21 SEPT 72	
		B	NOR W9S2009 80-02-13	80-05-16	



PIN, SPRING-MS 16562-95
(ASSEMBLE FLUSH OR BELOW SURFACE)
EJECTION PORT COVER AND LATCH HOUSING ASSY-8448783
LATCH, COVER-8448786
SPRING, COVER LATCH-8448787

SEE PL-8448525

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

PART NO. 8448525

CODE IDENT NO. 19200

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
D9327228	M231
D8448602	M16
D8448523	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL —

FINAL PROTECTIVE FINISH —

CONTRACT NO

DATE 27 APR 70

PREPARED
CHECKED
ENGINEER
SUBMITTED Loren Brunton
APPROVED

EJECTION PORT COVER ASSY

SIZE D
CODE IDENT NO.
DRAWING NO. 8448525
SCALE 10/1
SHEET 1 OF 1

D8448525

AMSWE Form 403D, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED

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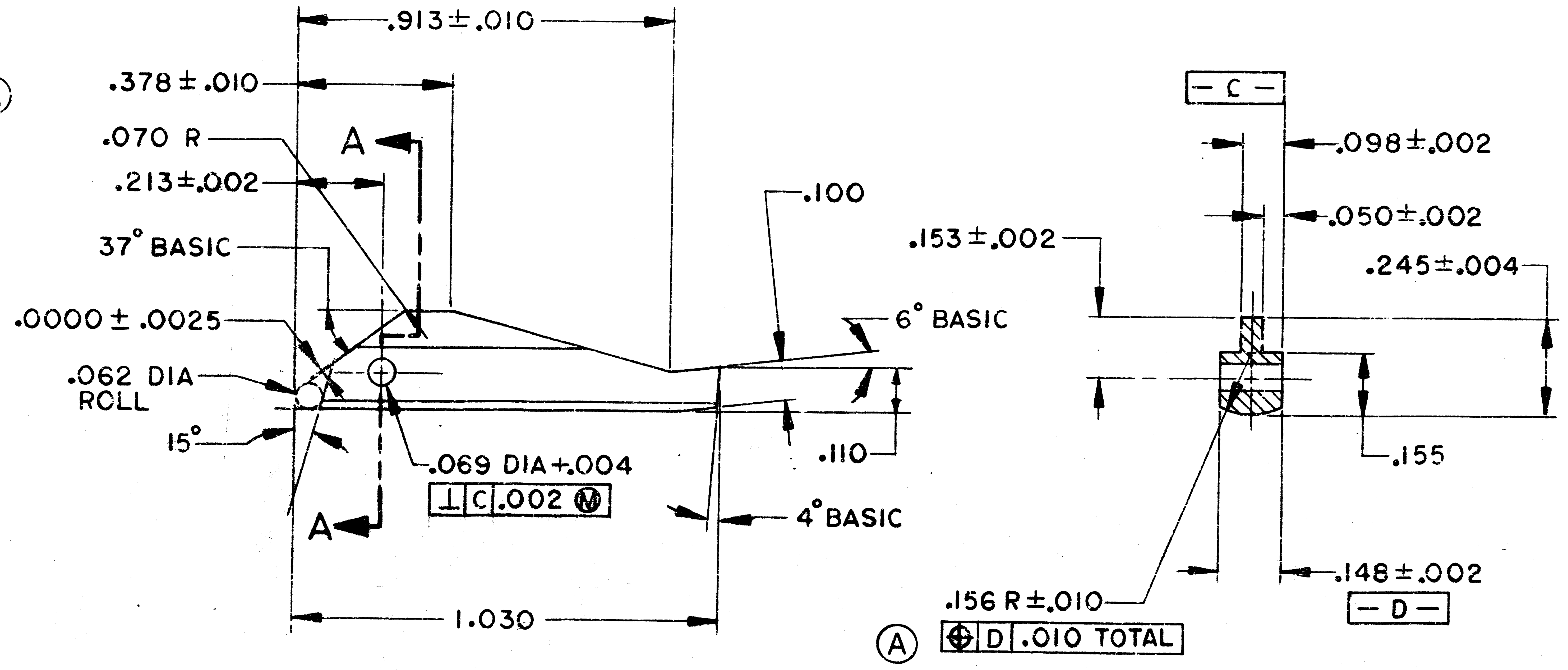
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62269 REVISION B	27 APR 70	
M		A	(3) SEE ERR HQR 20778	6 OCT 72	R.C.
		B	NOR W9S2009 80-02-13	80-05-16	

NOTE:-

1. FINISH 63/
2. BREAK ALL EDGES .005+.005.
3. STEEL, CMPSN 1137, 1141, OR 1144, SPEC ASTM A322 OR ASTM A331.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓐ
5. MIL-W-13855 APPLIES.



SECTION A-A

CODE IDENT NO.
19200

Ⓐ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			
RH	C44-48	C8448541	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± 1°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± ——

MATERIAL
SEE NOTE 3

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO:

DATE 27 APR 1970

PREPARED	RGA	a.j. H.
CHECKED		J. Leafer
ENGINEER		D. Gillet

SUBMITTED T. P. Gelhooly

APPROVED K. S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

PAWL,
FORWARD ASSIST

SIZE	CODE IDENT NO.	DRAWING NO.
C	~~19204~~	8448543

SCALE 4/1 SHEET 1 OF 1

CDI

AMSWE Form 403C, 29 Jul 69

C8448543

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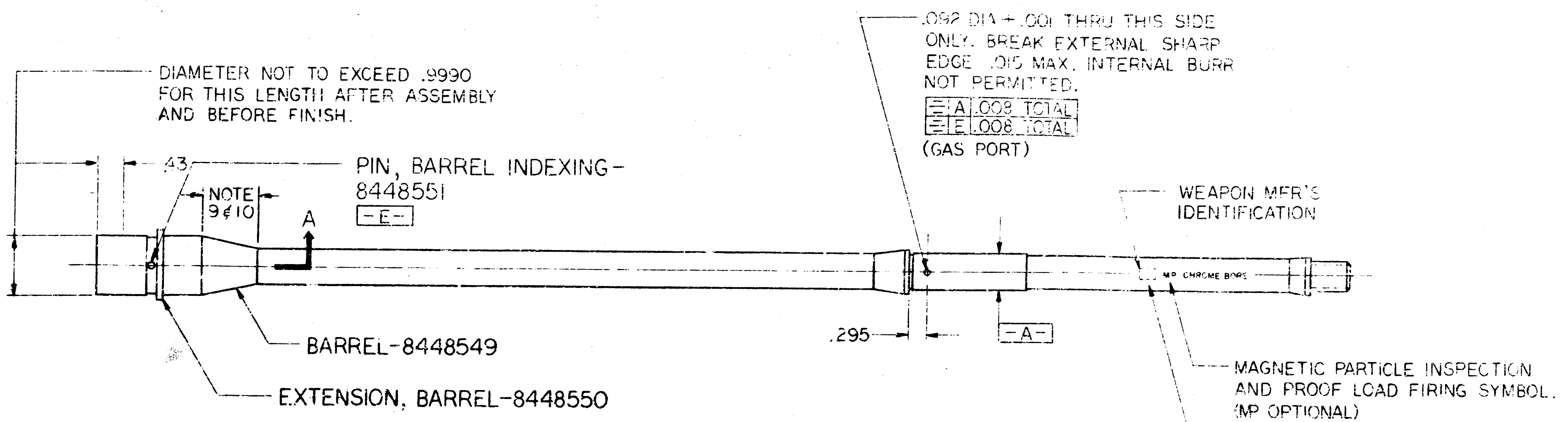
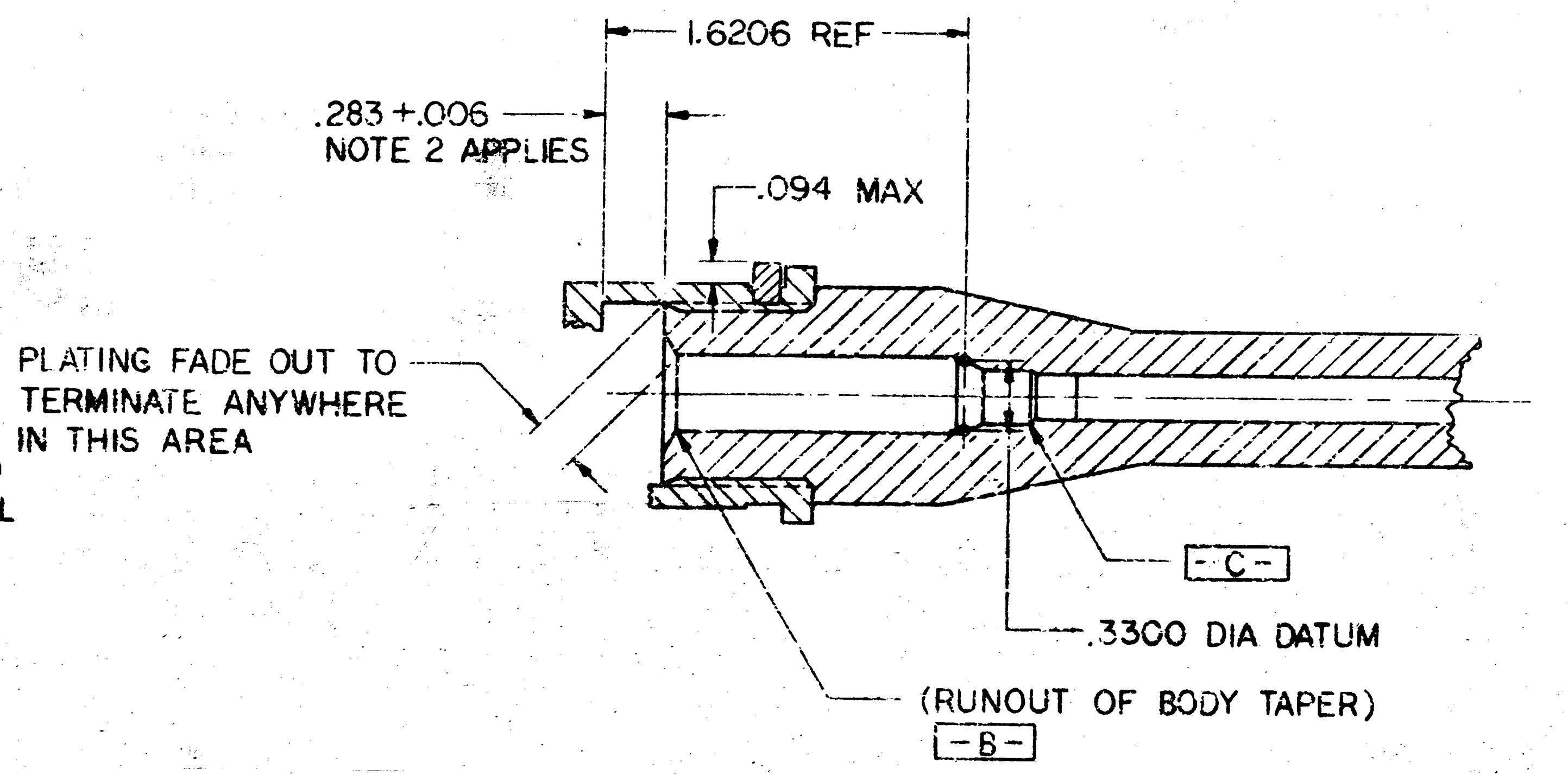
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		J	REPLACES REV H W/CHANGE		
			SEE ERR HQR 30792	10 JUN 74	
		K	SEE ERR HQR 50604	3 FEB 75	
		L	[illegible]	[illegible]	
		M	NOR G7S3058/820611	980112	
		N	EH 79[illegible] (LC) G5S3117 [illegible]	[illegible]	

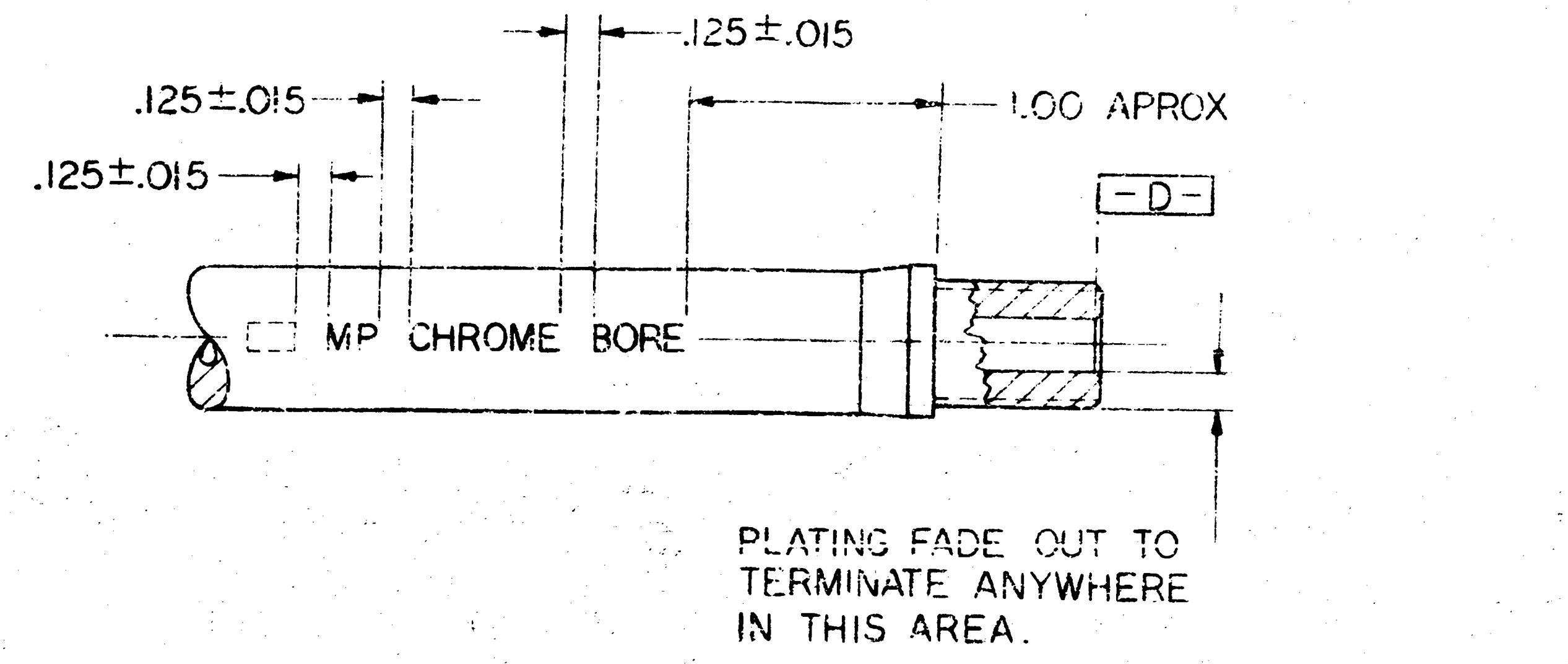
NOTES:

1. FOR FINISHED CHAMBER DIMENSIONS AFTER PLATING SEE DWG 84486-9 AND SECTION A-A. FOR FINISHED BORE DIMENSIONS AFTER PLATING SEE DWG 8448549.
2. TORQUE BARREL AND BARREL EXTENSION TO 150 LB FT ± 5 LB FT. .283 DIMENSION APPLIES AFTER TORQUING TO REQUIRED LOAD.
3. FINISH REAM CHAMBER AFTER ASSEMBLY.
4. PROTECTIVE FINISH:
   - A. INTERIOR: CHROMIUM PLATE CHAMBER AND BORE FINISH 1.2.2.2 OF MIL-STD-171. FILM THICKNESS BETWEEN POINTS -B- AND -C- .0003 TO .0015. FILM THICKNESS BETWEEN -C- AND -D- .0004 TO .0015.
   - B. CHROMIUM PLATING SOLUTION TO HAVE A CONCENTRATION OF CHROMIUM TRIOXIDE (CRO$_3$) 50 TO 56 OUNCES PER GALLON. CHROMIC ACID TO SULPHATE ION RATIO SHALL BE 85:1 TO 95:1. THE OPERATING TEMPERATURE SHALL BE MAINTAINED AT 150° TO 155°F. THE CURRENT DENSITY SHALL BE MAINTAINED SO THE DEPOSIT IS ESSENTIALLY OF A DENSE, CRACK-FREE CHARACTER WHEN VIEWED UNDER 100X MAGNIFICATION.
   - C. EXTERIOR: 5.3.1.2 OF MIL-STD-171.
5. AFTER CHROME PLATING CHAMBER AND BORE, EACH BARREL ASSEMBLY SHALL WITHSTAND THE FIRING OF ONE HIGH PRESSURE TEST CARTRIDGE M197, WITHOUT EVIDENCE OF FAILURE.
6. AFTER PROOF FIRING, EACH BARREL ASSEMBLY SHALL BE MAGNETIC PARTICLE INSPECTED FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS USING A CURRENT OF 400 TO 500 AMPERES FOR CIRCULAR CONTINUOUS MAGNETIZATION.
7. AFTER PROOF FIRING AND MAGNETIC PARTICLE INSPECTION, GRIT BLAST EXTERIOR PRIOR TO FINAL PROTECTIVE FINISH, TO PRODUCE NONREFLECTIVE MATTE FINISH. MASK CHAMBER, FEED CONE, BORE AND CROWN (MUZZLE END).
8. AFTER PROOF LOAD FIRING AND MAGNETIC PARTICLE INSPECTION EACH BARREL SHALL BE MARKED AS FOLLOWS:
   MFG IDENT, MAGNETIC PARTICLE INSPECTION / PROOF LOAD FIRING SYMBOL, AND "CHROME BORE" SHALL BE .094±.015 HIGH IN AREA SHOWN VISUALLY IN LINE WITH THE .092 DIA GAS PORT.
9. ABOVE MARKINGS SHALL BE LEGIBLE AND PERMANENT SO AS TO BE CAPABLE OF WITHSTANDING THE ENVIRONMENTAL AND CLEANING REQUIREMENTS FOR THE ASSEMBLY.
10. SINGLE LETTER CHROME PLATE VENDOR IDENT. PERMISSIBLE THIS AREA ONLY.
11. MIL-W-13855 APPLIES.


DIAMETER NOT TO EXCEED .9990
FOR THIS LENGTH AFTER ASSEMBLY
AND BEFORE FINISH.
.43
NOTE 9 & 10
PIN, BARREL INDEXING-8448551
-E-
A
A
BARREL-8448549
EXTENSION, BARREL-8448550
.092 DIA +.001 THRU THIS SIDE
ONLY. BREAK EXTERNAL SHARP
EDGE .015 MAX. INTERNAL BURR
NOT PERMITTED.
-A- .008 TOTAL
-E- .008 TOTAL
(GAS PORT)
WEAPON MFR'S IDENTIFICATION
MP CHROME BORE
.295
-A-
MAGNETIC PARTICLE INSPECTION
AND PROOF LOAD FIRING SYMBOL.
(MP OPTIONAL)
SEE NOTE 8 AND VIEW B


1.6206 REF
.283 +.006
NOTE 2 APPLIES
.094 MAX
PLATING FADE OUT TO
TERMINATE ANYWHERE
IN THIS AREA
-C-
.3300 DIA DATUM
(RUNOUT OF BODY TAPER)
-B-

SECTION A-A
SCALE: 2/1


.125±.015
.125±.015
.125±.015
1.00 APROX
-D-
MP CHROME BORE
PLATING FADE OUT TO
TERMINATE ANYWHERE
IN THIS AREA.

VIEW B
SCALE: 2/1

SEE PL-8448548

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT C[illegible]
DOVER, NEW JERSEY 07801

PART NO 8448548

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
YS MIN				TOLERANCES ON DECIMALS XX ±.01	
YS MAX				ANGLES ± XXX ±.005	
EL 2				MATERIAL	
RA					
BH		F8448610	M16	HEAT TREATMENT	
RH		F8448522	M16A1		
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	SEE NOTES 4, 7, 10
		APPLICATION			

ORIGINAL DATE OF DRAWING 27 APR 70

DEPT OF THE ARMY
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

BARREL AND BARREL
EXTENSION ASSEMBLY

DWG SIZE	CODE IDENT NO	
F	19204	8448548
SCALE	UNIT WT	SHEET OF

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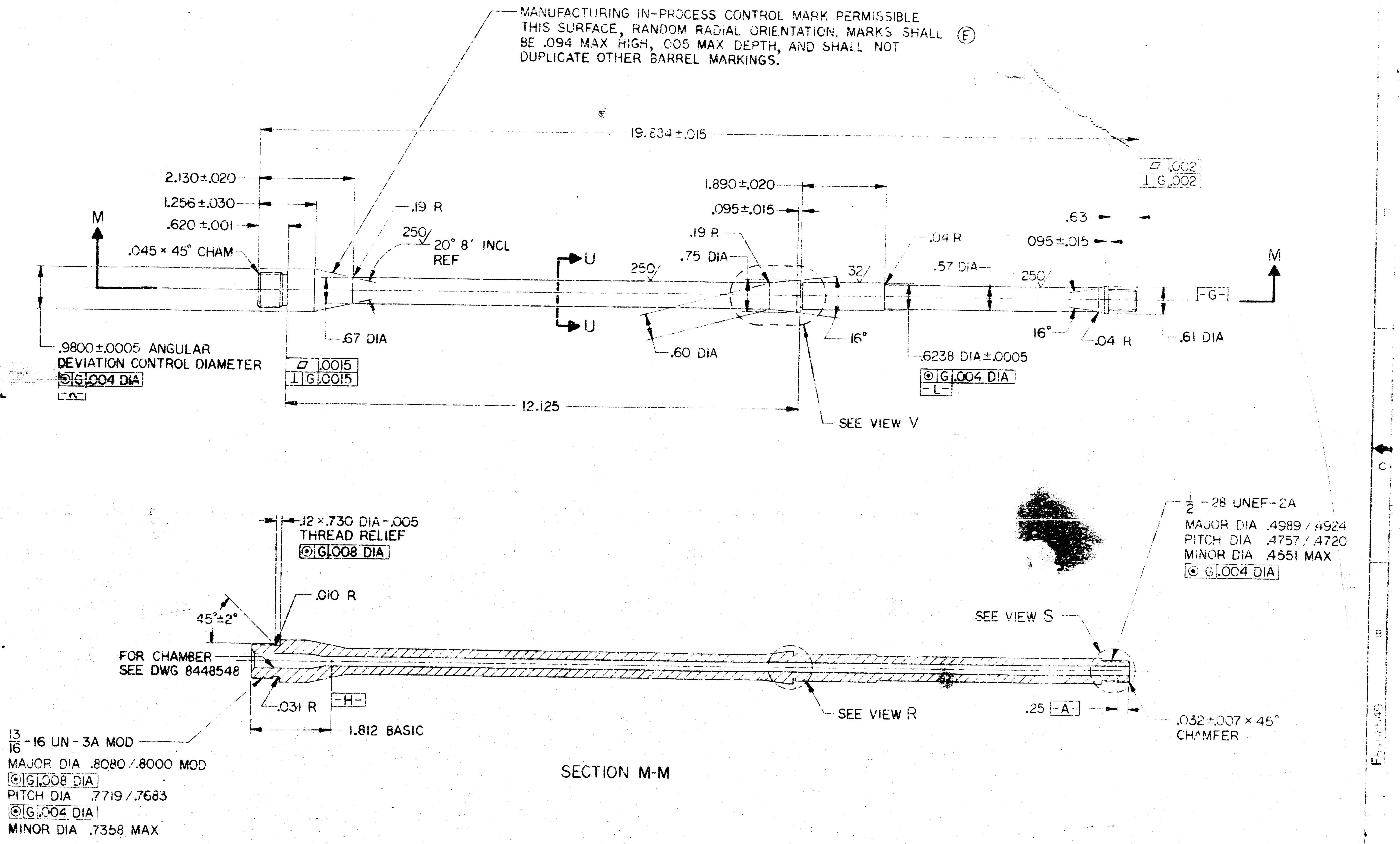
[illegible] DOCUMENT AN[illegible] INFORMATION THEREON IS PROPRIETARY TO COLT'S INC AND SHALL [illegible] DUPLICATED OR COPIED IN WHOLE OR IN PART, DISCLOSED OR MADE AVAILABLE [illegible] OR OTHERWISE USED EXCEPT TO THE EXTENT [illegible] FOR AND THEN ONLY IN CONNECTION WITH THE PREPARATION AND/OR SUBMISSION OF [illegible] RELATED TO A PROCUREMENT BEING EFFECTED BY THE UNITED STATES GOVERNMENT [illegible] WITH THE MANUFACTURE IN THE UNITED STATES EITHER BY THE UNITED STATES [illegible] A CONTRACT WITH THE UNITED STATES GOVERNMENT. THIS DOCUMENT WIL[illegible] IN ACCORDANCE WITH INSTRUCTIONS ISSUED BY THE RESPONSIBLE CONTRACTING [illegible] UPON COMPLETION OF THE PURPOSE FOR WHICH IT WAS ISSUED.

REVISIONS					
	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		D	REPLACES REV C W/CHANGE SEE ERR HQR 20827	14 DEC 72	
		E	SEE ERR HQR 30645	2 MAR 73	RE
		F	(O) SEE NOR 7760005-0000	26 JAN 77	
		G	NOR [illegible]	[illegible]	
		H	NOR G753121 / 870923	880928	

NOTES:

1. STEEL, CMPSN CHROME MOLY-VANADIUM, SPEC MIL-S-11595.
2. CENTER LINE -G- ESTABLISHED BY BORE DIAMETER AT MUZZLE AND AT POINT -H-. ALL DIAMETERS ◎ G .010 DIA UNLESS OTHERWISE SPECIFIED.
3. BREAK SHARP EDGES .005-.010 UNLESS OTHERWISE SPECIFIED.
4. WHERE NOTED, DIMENSIONAL LIMITS AND SURFACE ROUGHNESS DESIGNATIONS APPLY AFTER CHROME PLATING.
5. RIFLING TO BE SIX GROOVES, RIGHT HAND, WITH ONE TURN IN 12.000 ±.125.
6. STRESS RELIEVE AFTER FORMING RIFLING AND PRIOR TO FURTHER MACHINING. SUGGESTED PROCEDURE: PLACE BARRELS IN A CLOSED RETORT VERTICALLY. HEAT IN A NEUTRAL ATMOSPHERE TO 1020° F. HOLD AT HEAT FOR 15 MINUTES. COOL IN RETORT TO 300° F. REMOVE AND AIR COOL.
7. A CYLINDRICAL PLUG WITH A GAGING LENGTH OF 6.000 AND A DIAMETER OF .2173 / .2174 MUST DROP THROUGH THE BORE OF ITS OWN WEIGHT.
8. A SELF ALIGNING PLUG INSERTED 3.000 INTO THE BORE AT THE MUZZLE MAY HAVE AN ANGULAR DEVIATION FROM A THEORETICAL AXIS ESTABLISHED BY -K- AND -L- OF 0° 3′ MAXIMUM.
9. BORE AND GROOVE DIAMETERS SHALL BE WITHIN THE DIMENSIONAL LIMITS SPECIFIED AND, WHEN MEASURED FROM THE CHAMBER END TOWARD THE MUZZLE END, SHALL MEET THE FOLLOWING REQUIREMENTS:
   1. DIAMETRAL REDUCTION OF BORE AND GROOVE DIAMETERS SHALL BE .0001 DIA MAX FOR LENGTH -A-.
   2. NO BORE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED BORE DIAMETER.
   3. NO GROOVE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED GROOVE DIAMETER.
10. MIL-W-13855 APPLIES.


MANUFACTURING IN-PROCESS CONTROL MARK PERMISSIBLE THIS SURFACE, RANDOM RADIAL ORIENTATION. MARKS SHALL BE .094 MAX HIGH, .005 MAX DEPTH, AND SHALL NOT DUPLICATE OTHER BARREL MARKINGS. (F)
19.834 ±.015
▱ .002
⊥ G .002
2.130 ±.020
1.256 ±.030
.620 ±.001
.045 × 45° CHAM
M
.19 R
250
20° 8′ INCL REF
U
1.890 ±.020
.095 ±.015
.19 R
.75 DIA
250
32
.04 R
.57 DIA
.63
.095 ±.015
250
M
-G-
.9800 ±.0005 ANGULAR DEVIATION CONTROL DIAMETER
◎ G .004 DIA
-K-
▱ .0015
⊥ G .0015
.67 DIA
.60 DIA
16°
16°
.04 R
.61 DIA
.6238 DIA ±.0005
◎ G .004 DIA
-L-
12.125
SEE VIEW V
.12 × .730 DIA -.005 THREAD RELIEF
◎ G .008 DIA
.010 R
45° ±2°
FOR CHAMBER SEE DWG 8448548
.031 R
-H-
1.812 BASIC
1/2 - 28 UNEF-2A
MAJOR DIA .4989 / .4924
PITCH DIA .4757 / .4720
MINOR DIA .4551 MAX
◎ G .004 DIA
SEE VIEW S
SEE VIEW R
.25 -A-
.032 ±.007 × 45° CHAMFER
13/16 -16 UN-3A MOD
MAJOR DIA .8080 / .8000 MOD
◎ G .008 DIA
PITCH DIA .7719 / .7683
◎ G .004 DIA
MINOR DIA .7358 MAX
SECTION M-M

REV STATUS OF SHTS	
SH 1	SH 2
H	H

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT [illegible]
DOVER, NEW JERSEY 07801

PART NO. 8448549

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BARREL

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
RH	
RH	C26-32

NEXT ASSY	USED ON
	M16
F8448548	M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1° 0′
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO

DATE 27 APR 70
PREPARED
ENGINEER
SUBMITTED Loren F. Bunton
APPROVED

SIZE F | CODE IDENT NO 19204 | DRAWING NO 8448549

AMSWE Form 403F, 13 NOV 70

EDITION OF 29 JUL 70 MAY BE USED

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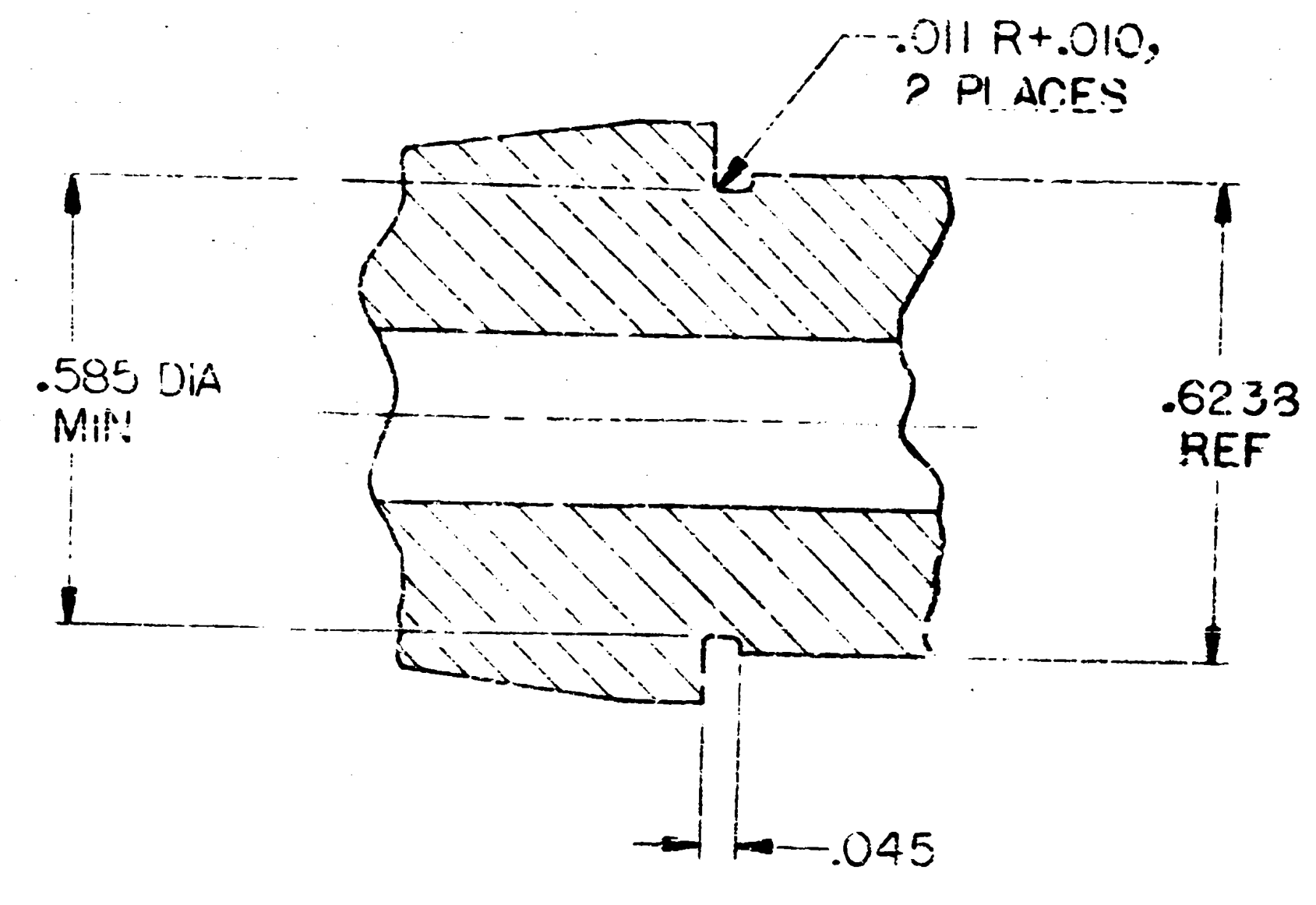
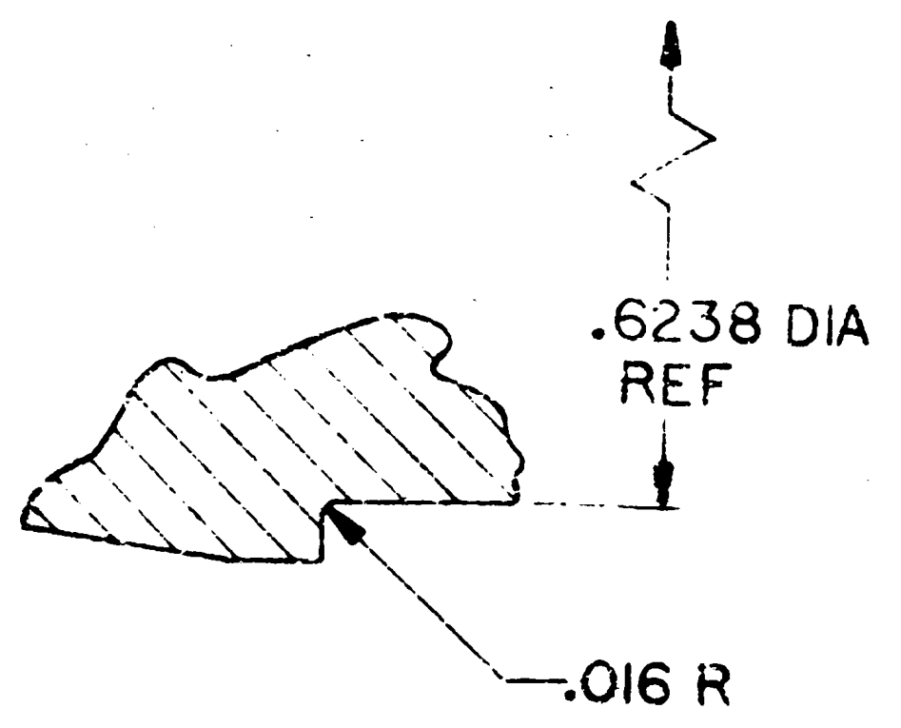
REVISIONS

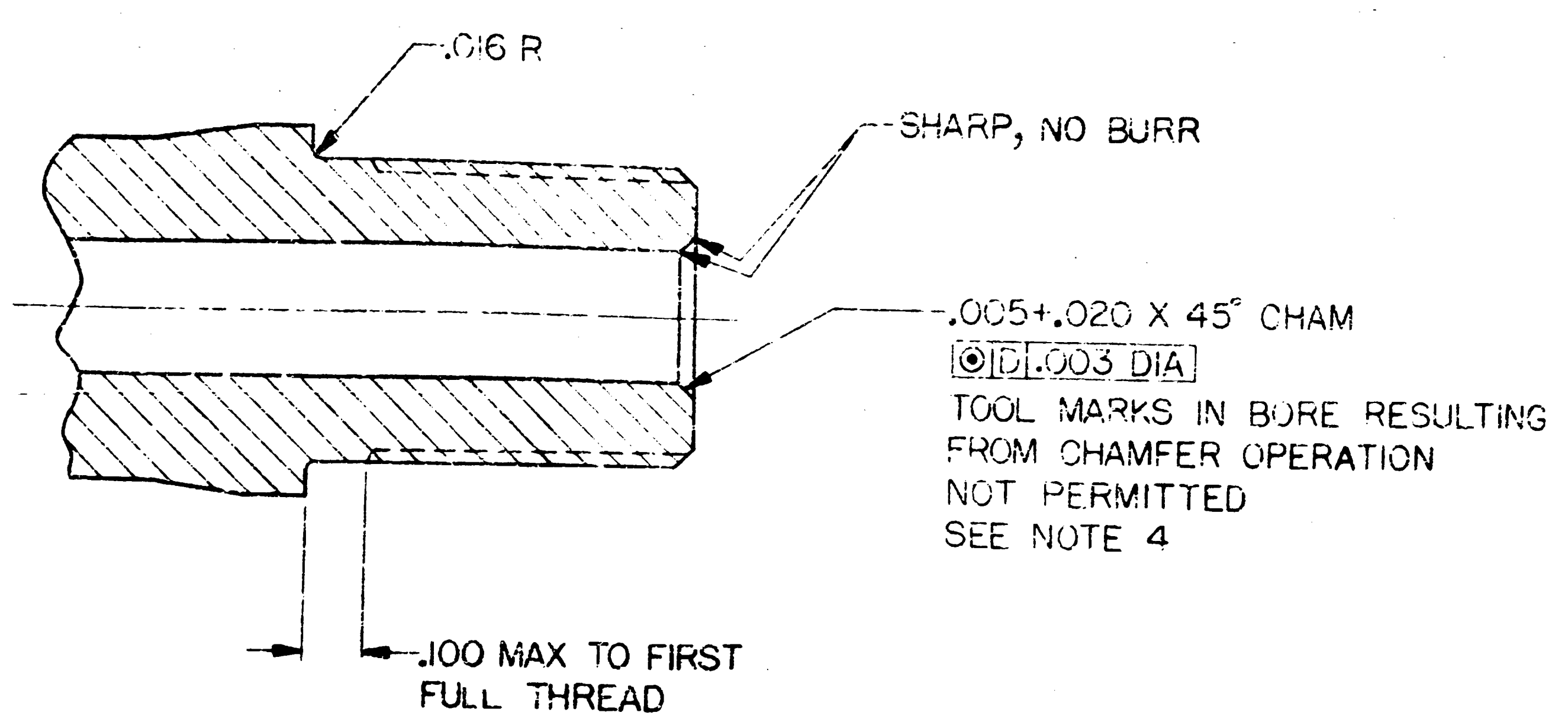
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		D	REPLACES REV C W/CHANGE SEE ERR HQR 20827	14 DEC 72	
		E	(2) SEE ERR HQR 30645	2 MAR 73	
		F	(1) SEE NOR 77E0005-0000	26 JAN 77	
		G	[illegible]	[illegible]	
		H	NOR G7S3121/870923	880923	


.011 R+.010, 2 PLACES
.585 DIA MIN
.6238 DIA REF
.045

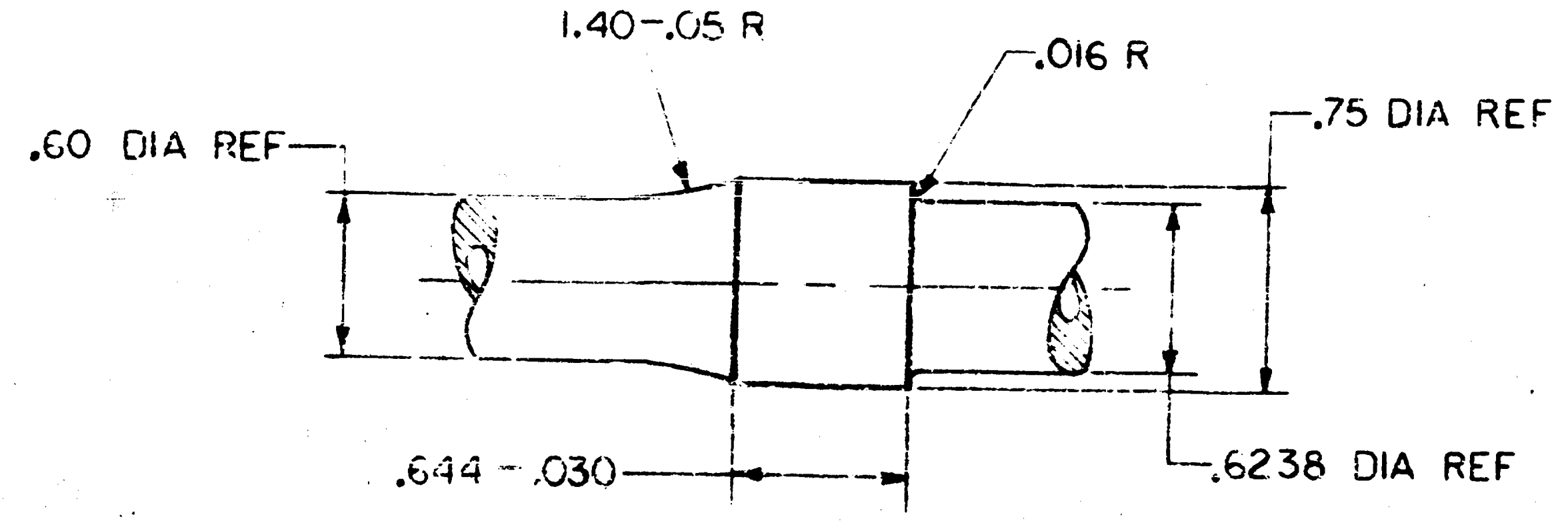
VIEW R
SCALE 5/1


.6238 DIA REF
.016 R

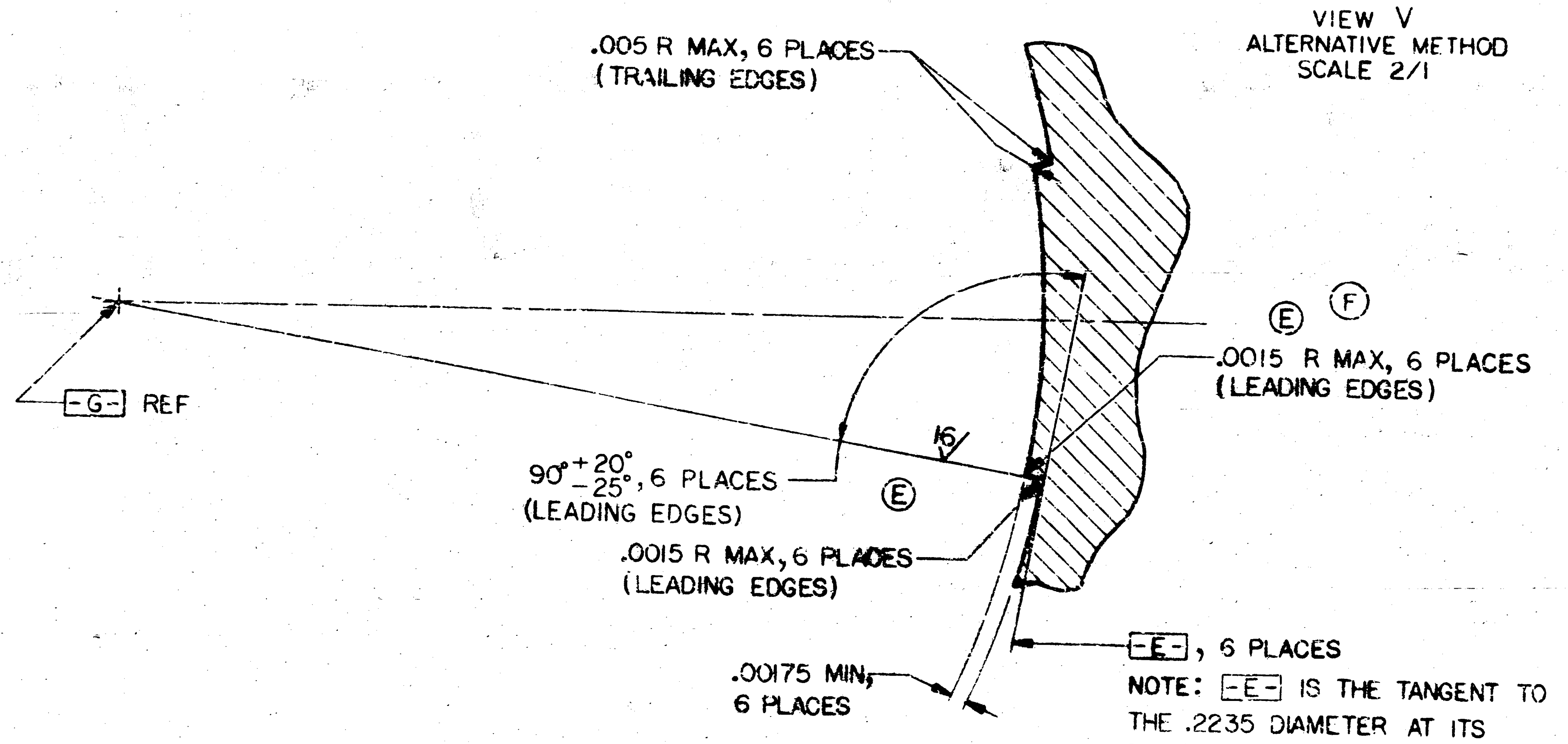
VIEW R
ALTERNATIVE DESIGN
SCALE 5/1


.016 R
SHARP, NO BURR
.005+.020 X 45° CHAM
◎ D .003 DIA
TOOL MARKS IN BORE RESULTING FROM CHAMFER OPERATION NOT PERMITTED
SEE NOTE 4
.100 MAX TO FIRST FULL THREAD

VIEW S
SCALE 5/1

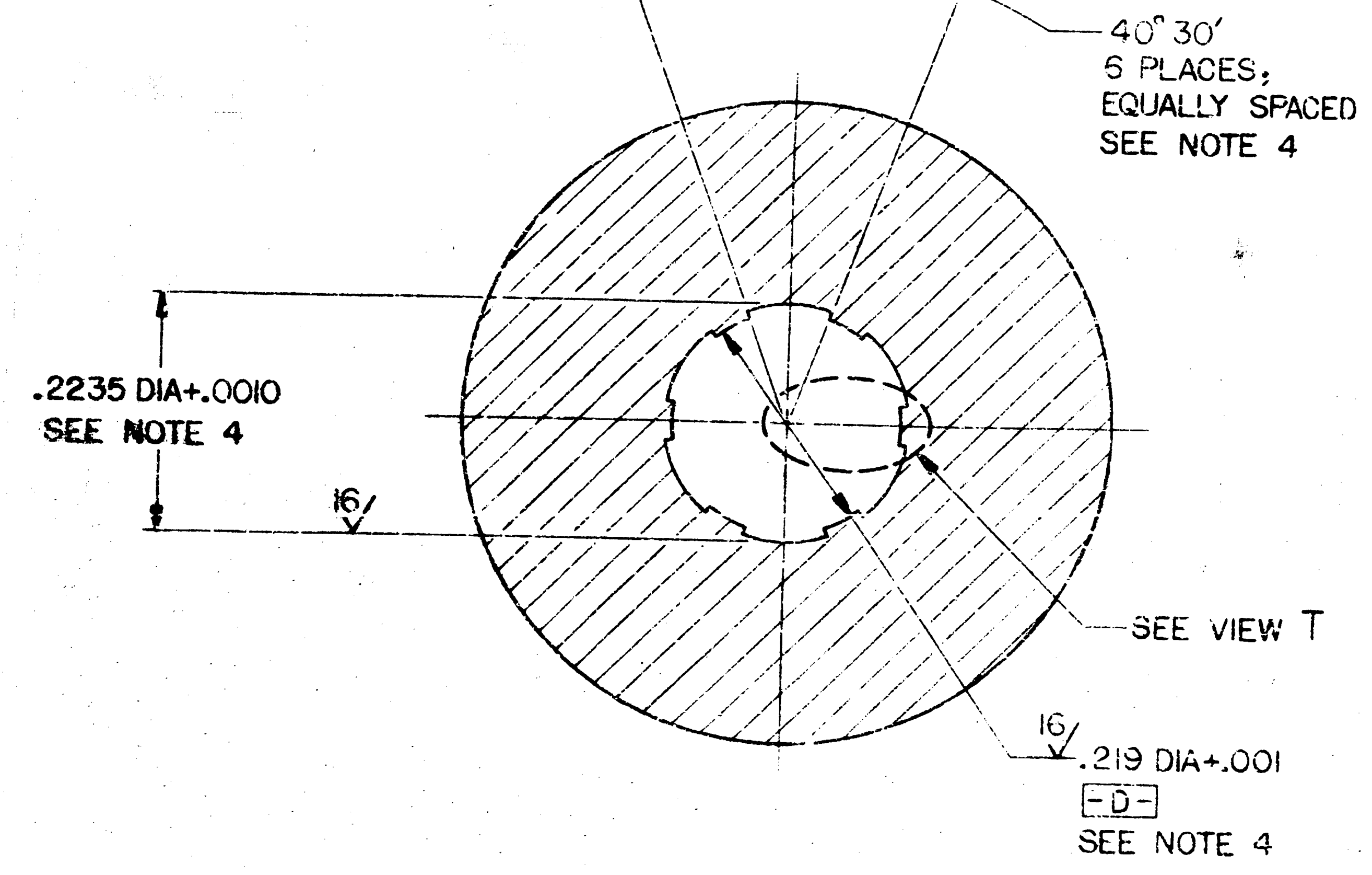

1.40-.05 R
.016 R
.60 DIA REF
.75 DIA REF
.644 - .030
.6238 DIA REF

VIEW V
ALTERNATIVE METHOD
SCALE 2/1


.005 R MAX, 6 PLACES (TRAILING EDGES)
E
F
.0015 R MAX, 6 PLACES (LEADING EDGES)
-G- REF
16/
90°+20° -25°, 6 PLACES (LEADING EDGES)
E
.0015 R MAX, 6 PLACES (LEADING EDGES)
.00175 MIN, 6 PLACES
-E-, 6 PLACES

NOTE: -E- IS THE TANGENT TO THE .2235 DIAMETER AT ITS THEORETICAL INTERSECTION WITH THE LEADING EDGE OF THE LAND

VIEW T
SCALE 100/1
NOTE 4 APPLIES TO ALL DIMENSIONS IN THIS VIEW


40° 30'
6 PLACES, EQUALLY SPACED
SEE NOTE 4
.2235 DIA+.0010
SEE NOTE 4
16/
SEE VIEW T
16/
.219 DIA+.001
-D-
SEE NOTE 4

SECTION U-U
RIFLING DETAIL
SCALE 10/1

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
VH	

NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± 1°0'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01
MATERIAL
FINAL PROTECTIVE FINISH

CONTRACT NO
DATE 27 APR 70
PREPARED
CHECKED
ENGINEER
SUBMITTED Loran F. Bunton
APPROVED R. S. Koury

CURRENT DESIGN ACTIVITY [illegible]
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT [illegible]
DOVER NEW JERSEY 07801
PART NO. 8448549
DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BARREL

SIZE F
CODE IDENT NO 19204
DRAWING NO 8448549
SCALE 1/1
SHEET 2 OF 2

EDITION OF 29 JUL 70 MAY BE USED

AMSWE Form 403F, 13 NOV 70

E 8448549

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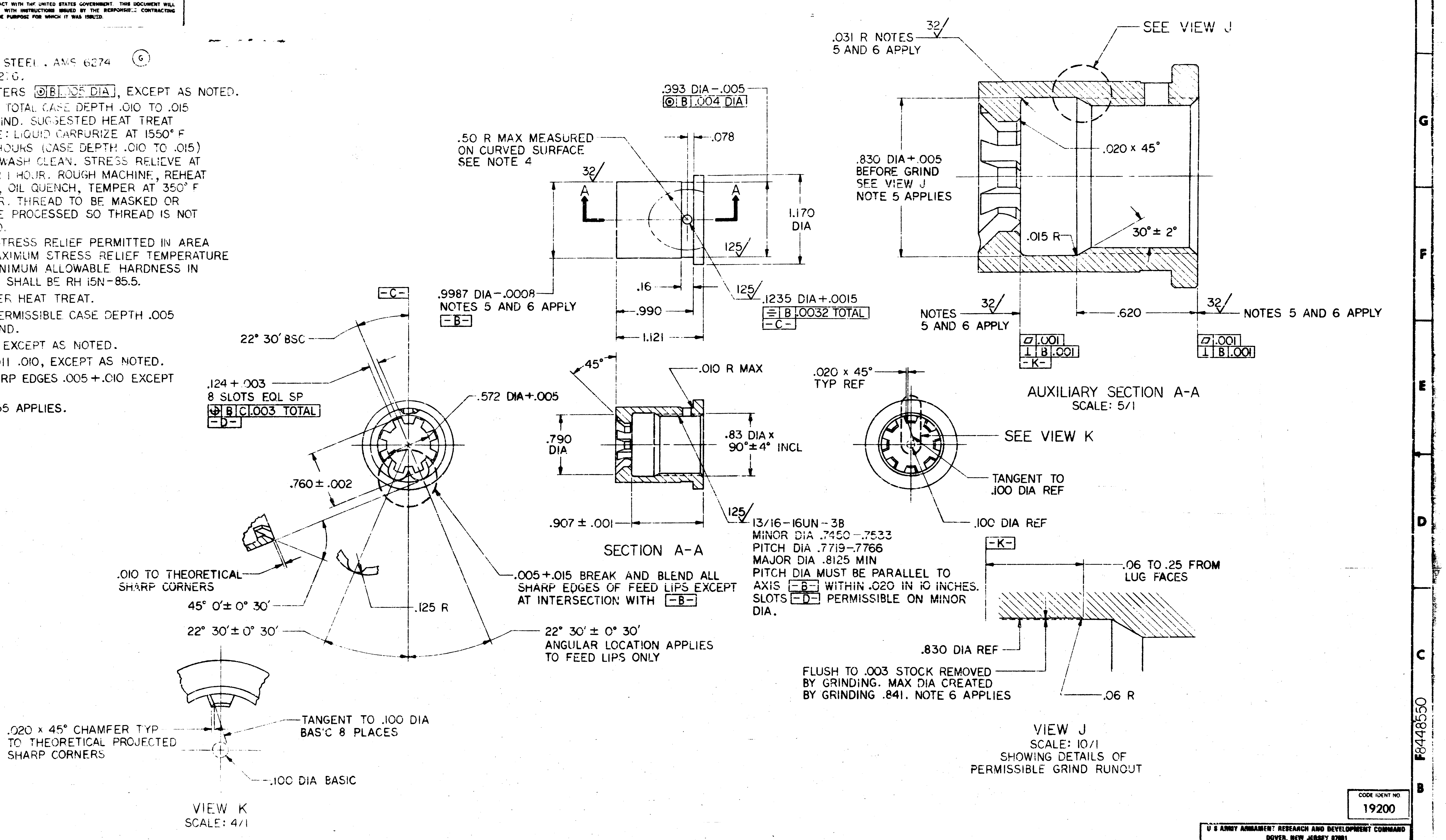
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		F	REPLACES REV E W/CHANGE SEE ERR HQR 30759	12 NOV 73	
		G	(I) SEE NOR 76E5001-0000	4 NOV 76	
		H	NOR W9S2009 8C-02-13	80-05-16	

NOTES:

1. SAE 8620 STEEL, AMS 6274 OR AMS 6276. Ⓖ
2. ALL DIAMETERS ◎|B|.005 DIA, EXCEPT AS NOTED.
3. CARBURIZE TOTAL CASE DEPTH .010 TO .015 BEFORE GRIND. SUGGESTED HEAT TREAT PROCEDURE: LIQUID CARBURIZE AT 1550° F FOR 1 1/4 HOURS (CASE DEPTH .010 TO .015) AIR COOL, WASH CLEAN. STRESS RELIEVE AT 850° F FOR 1 HOUR. ROUGH MACHINE, REHEAT TO 1450° F, OIL QUENCH, TEMPER AT 350° F FOR 1 HOUR. THREAD TO BE MASKED OR PART TO BE PROCESSED SO THREAD IS NOT CARBURIZED.
4. OPTIONAL STRESS RELIEF PERMITTED IN AREA SHOWN. MAXIMUM STRESS RELIEF TEMPERATURE 900° F. MINIMUM ALLOWABLE HARDNESS IN THIS AREA SHALL BE RH 15N-85.5.
5. GRIND AFTER HEAT TREAT.
6. MINIMUM PERMISSIBLE CASE DEPTH .005 AFTER GRIND.
7. FINISH 63/√ EXCEPT AS NOTED.
8. FILLET RADII .010, EXCEPT AS NOTED.
9. BREAK SHARP EDGES .005 + .010 EXCEPT AS NOTED.
10. MIL-W-13855 APPLIES.


8
7
6
5
4
3
2
1
H
G
F
E
D
C
B
A
.993 DIA -.005
◎|B|.004 DIA
.50 R MAX MEASURED ON CURVED SURFACE SEE NOTE 4
.078
32/
A
A
1.170 DIA
125/
.9987 DIA -.0008 NOTES 5 AND 6 APPLY
-B-
.16
.990
1.121
125/
.1235 DIA + .0015
⌯|B|.0032 TOTAL
-C-
-C-
22° 30' BSC
.124 + .003
8 SLOTS EQL SP
⌖|B|C|.003 TOTAL
-D-
.572 DIA + .005
.760 ± .002
.010 TO THEORETICAL SHARP CORNERS
45° 0' ± 0° 30'
.125 R
22° 30' ± 0° 30'
.005 + .015 BREAK AND BLEND ALL SHARP EDGES OF FEED LIPS EXCEPT AT INTERSECTION WITH -B-
22° 30' ± 0° 30' ANGULAR LOCATION APPLIES TO FEED LIPS ONLY
45°
.010 R MAX
.790 DIA
.83 DIA x 90° ± 4° INCL
.907 ± .001
125/
SECTION A-A
13/16-16UN-3B
MINOR DIA .7450-.7533
PITCH DIA .7719-.7766
MAJOR DIA .8125 MIN
PITCH DIA MUST BE PARALLEL TO AXIS -B- WITHIN .020 IN 10 INCHES.
SLOTS -D- PERMISSIBLE ON MINOR DIA.
.031 R NOTES 5 AND 6 APPLY
32/
SEE VIEW J
.830 DIA + .005 BEFORE GRIND SEE VIEW J NOTE 5 APPLIES
.020 x 45°
.015 R
30° ± 2°
NOTES 5 AND 6 APPLY
32/
.620
32/
NOTES 5 AND 6 APPLY
⏥|.001
⊥|B|.001
-K-
⏥|.001
⊥|B|.001
AUXILIARY SECTION A-A
SCALE: 5/1
.020 x 45° TYP REF
SEE VIEW K
TANGENT TO .100 DIA REF
.100 DIA REF
-K-
.06 TO .25 FROM LUG FACES
.830 DIA REF
FLUSH TO .003 STOCK REMOVED BY GRINDING. MAX DIA CREATED BY GRINDING .841. NOTE 6 APPLIES
.06 R
VIEW J
SCALE: 10/1
SHOWING DETAILS OF PERMISSIBLE GRIND RUNOUT
.020 x 45° CHAMFER TYP TO THEORETICAL PROJECTED SHARP CORNERS
TANGENT TO .100 DIA BASIC 8 PLACES
.100 DIA BASIC
VIEW K
SCALE: 4/1

F8448550

CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

PART NO. 8448550

MECHANICAL PROPERTIES					
YS MIN					
YS MAX					
EL 2					
RA	-	F9327056	M 231		
BH	—	F8448548	M16		
		F8448549	M16A1		
RH	15N 89-91	NEXT ASSY	USED ON		
SEE NOTE 4		APPLICATION			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON ANGLES ± 1° DECIMALS .XX ± .01 .XXX ± .005
MATERIAL SEE NOTE 1
HEAT TREATMENT SEE NOTES 3, 4, 5, AND 6
FINAL PROTECTIVE FINISH

ORIGINAL DATE OF DRAWING 27 APR 70
DRAWN Blenkow
CHECKED Alan Kedeh
ENGINEER R. Elbe
SUBMITTED Loren F. Brunton
APPROVED R S Henry

~~DEPT OF THE ARMY~~
~~ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201~~

EXTENSION, BARREL

DWG SIZE F | CODE IDENT NO. ~~19200~~ | 8448550
SCALE 2/1 | UNIT WT | SHEET 1 OF 1

5 4 3 2 1

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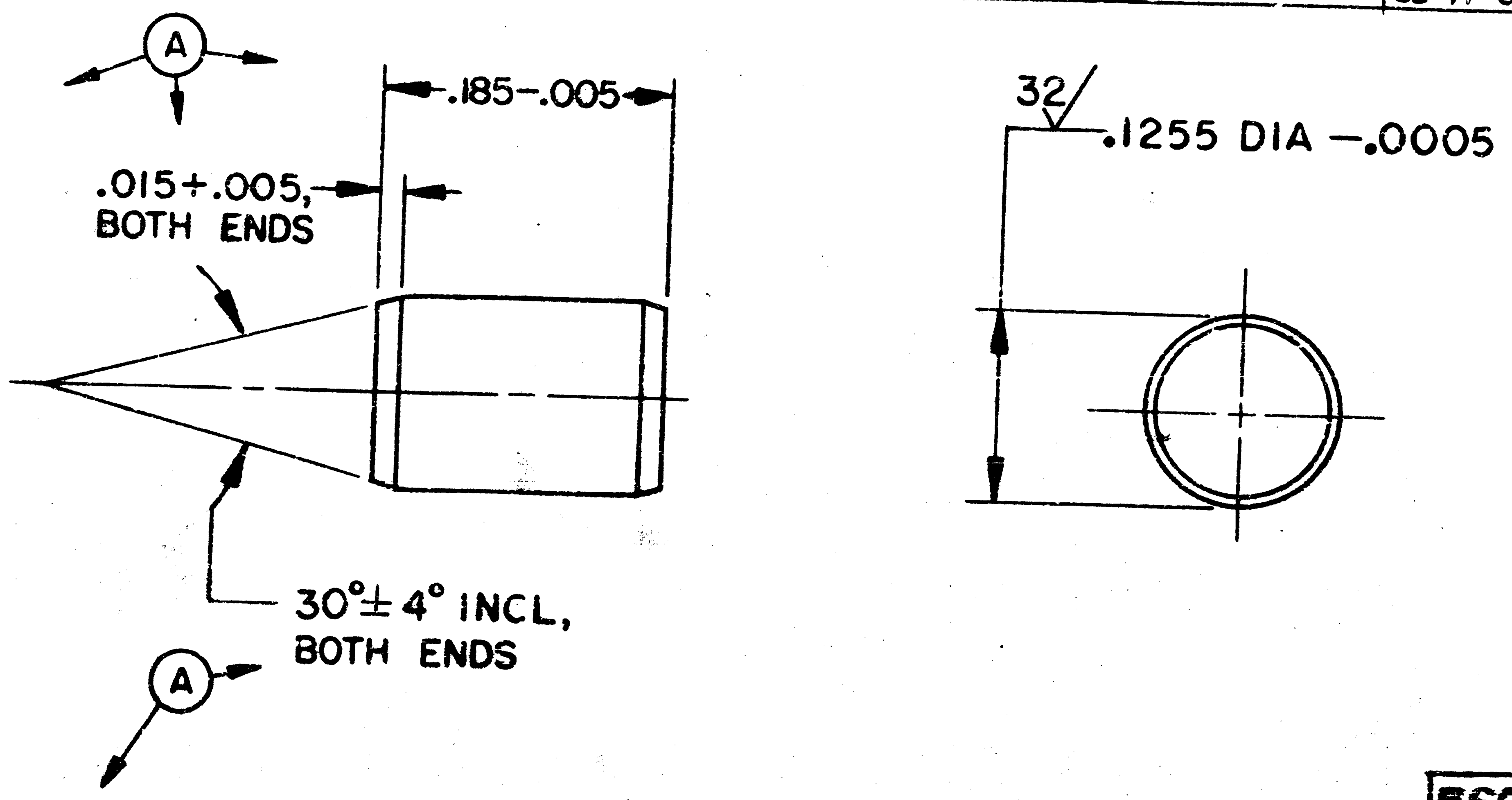
REVISIONS					
MF	ZONF	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61671 REVISION B	27 APR 70	
M		A	(2) SEE ERR HQR 10906	15 DEC 71	LB
M		B	(4) SEE ERR HQR 20827	14 DEC 72	RE
		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W3S3133/83-08-25	83-11-04	

NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 MAX.
3. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓑ
4. ~~STEEL, CARBON,~~ CMPSN 1137, 11L37 OR 1141, 11L41, SPEC ASTM A108-81.
5. ~~MIL-W-13855~~ APPLIES.



CURRENT

FSCM NO. 19200

Ⓑ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		F9327056	M231
EL 2			M16
RA		F8448548	M16A1
BH		NEXT ASSY	USED ON
RH	15N 78.5-80.5	APPLICATION	

Ⓑ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——

MATERIAL
SEE NOTE 4

FINAL PROTECTIVE FINISH
——

CONTRACT NO:
DATE 27 APR 1970
PREP RGA
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, BARREL INDEXING

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448551

SCALE 10/1 SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

8448551

8 7 6 5 4 3 2 1

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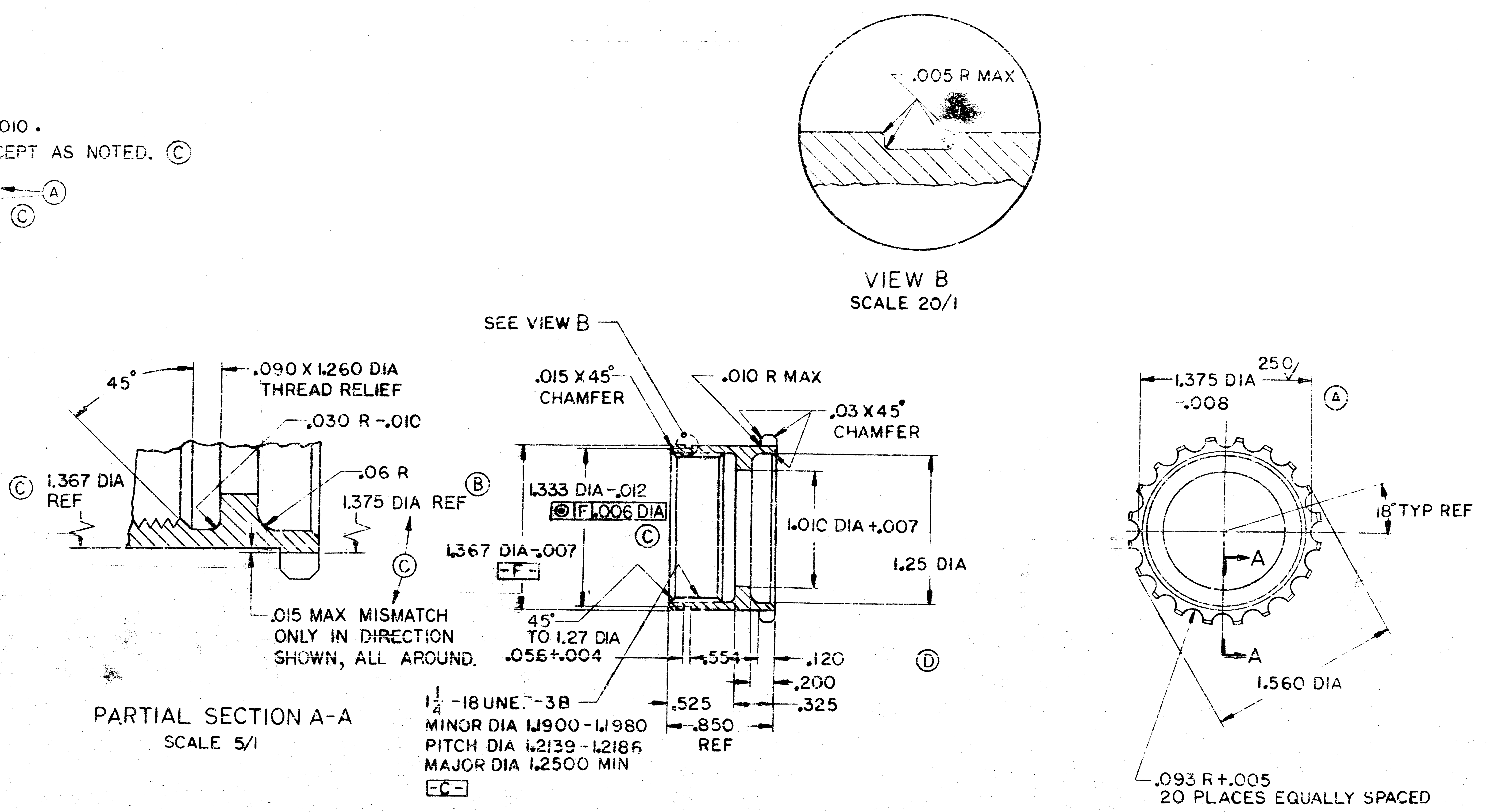
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D 61902 RE / A	27 APR 70	
		A	(3) SEE HQ 0639	26APR 71	B
		B	SEE ERR HQR 20700	5 JUN 72	B
		C	(5) SEE ERR HQR 20827	4 DEC 72	
		D	(2) SEE ERR HQR 30791	15 JAN 74	B
		E	NOR W9S2009 80-02-13	80-05-16	

NOTES:

1. STEEL, 413 . ANNEALED, COLD FINISHED, SPEC MIL-S-6758.
2. FINISH 125/ EXCEPT AS NOTED.
3. ALL EDGES SHALL BE BROKEN .005+.010.
4. ALL DIAMETERS ◎ C .006 DIA, EXCEPT AS NOTED. Ⓒ
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓐ Ⓒ
7. MIL-W-13855 APPLIES.



.005 R MAX
SEE VIEW B
.015 X 45° CHAMFER
.010 R MAX
.03 X 45° CHAMFER
45°
.090 X 1.260 DIA THREAD RELIEF
.030 R -.010
.06 R
Ⓒ 1.367 DIA REF
1.375 DIA REF Ⓑ
Ⓒ
.015 MAX MISMATCH ONLY IN DIRECTION SHOWN, ALL AROUND.
1.333 DIA -.012
◎ F .006 DIA
Ⓒ
1.367 DIA -.007
-F-
45° TO 1.27 DIA
.055+.004
1.010 DIA +.007
1.25 DIA
.554
.120
.200
.325
.525
.850 REF
Ⓓ
1¼ -18 UNEF -3B
MINOR DIA 1.1900-1.1980
PITCH DIA 1.2139-1.2186
MAJOR DIA 1.2500 MIN
-C-
1.375 DIA -.008
250/
Ⓐ
18° TYP REF
A
A
1.560 DIA
.093 R+.005
20 PLACES EQUALLY SPACED

VIEW B
SCALE 20/1

PARTIAL SECTION A-A
SCALE 5/1

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO Ⓓ 19200

Ⓐ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		B8448552	M 231
BH		B8448552	M16
		B8448552	M16A1
Rh	C26-32	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± 2°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO

DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED R J Henry

~~DEPT OF THE ARMY~~
~~ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 6120~~

NUT, BARREL

SIZE D
CODE IDENT NO ~~19204~~
DRAWING NO 8448553
SCALE 2/1
SHEET 1 OF 1

CD1

D8448553

AMSWE Form 403D 29 Jul 69

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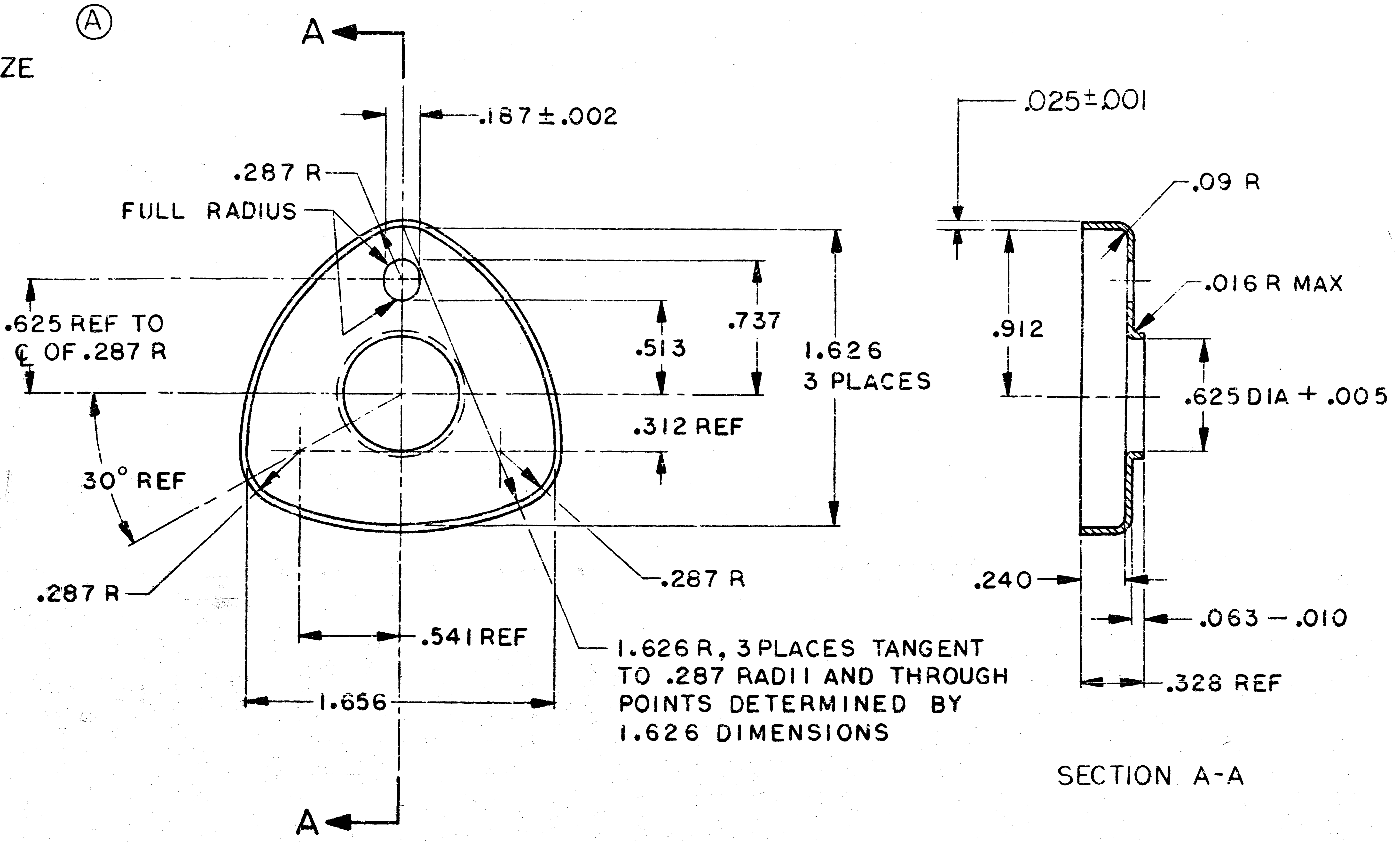
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62087 REVISION A	27APR 70	
M		A	(3) SEE ERR HQR 20827	14 DEC 72	RE
		B	NOEW2S0026 82-05-21	83-02-03	

NOTE:

1. STEEL, CMPSN 1045 THRU 1070, COLD ROLLED, SPHEROIDIZE ANNEALED, SPEC QQ-S-700. Ⓐ
2. FINISH 125/√.
3. BREAK SHARP EDGES .010 R MAX.
4. FINISH 5.3.1.2 OF MIL-STD-171.
5. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓐ
6. MIL-W-13855 APPLIES.


A
A
.187 ± .002
.287 R
FULL RADIUS
.625 REF TO ℄ OF .287 R
.513
.737
1.626 3 PLACES
.312 REF
30° REF
.287 R
.287 R
.541 REF
1.656
1.626 R, 3 PLACES TANGENT TO .287 RADII AND THROUGH POINTS DETERMINED BY 1.626 DIMENSIONS
.025 ± .001
.09 R
.016 R MAX
.912
.625 DIA + .005
.240
.063 − .010
.328 REF
SECTION A-A

C8448564

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

Ⓐ

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL 2			
RA			
BH		F8448601	M16
		F8448522	M16A1
RH	15N 79.5-81.5		
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTE 4

CONTRACT NO:

DATE 27 APR 1970

PREPARED
CHECKED
ENGINEER D. Smart D. Billet
SUBMITTED F. P. Gilliody
APPROVED R. S. Kenny

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

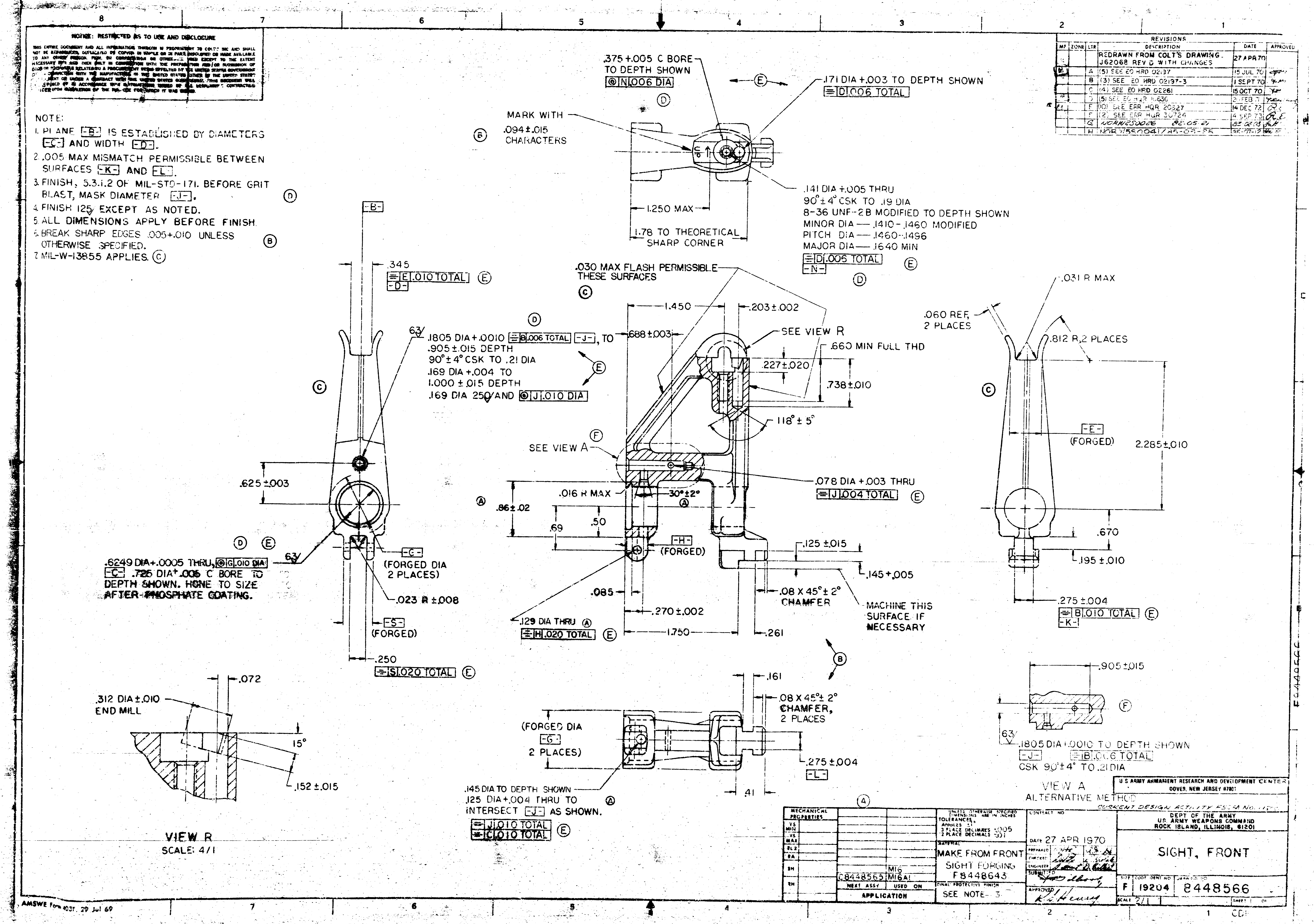
CAP., HANDGUARD

SIZE	CODE IDENT NO	DRAWING NO.
C	19204	8448564

SCALE 2/1 SHEET 1 OF 1

AMSWE Form 403C, 29 Jul 69

CDI


.375±.005 C BORE TO DEPTH SHOWN
⊚ N .006 DIA
MARK WITH .094±.015 CHARACTERS
.171 DIA +.003 TO DEPTH SHOWN
⌯ D .006 TOTAL
1.250 MAX
1.78 TO THEORETICAL SHARP CORNER
.141 DIA +.005 THRU
90°±4° CSK TO .19 DIA
8-36 UNF-2B MODIFIED TO DEPTH SHOWN
MINOR DIA — .1410-.1460 MODIFIED
PITCH DIA — .1460-.1496
MAJOR DIA — .1640 MIN
⌯ D .005 TOTAL
-N-
-B-
.345
⌯ E .010 TOTAL
-D-
.030 MAX FLASH PERMISSIBLE THESE SURFACES
.1805 DIA+.0010 ⌯ B .006 TOTAL -J-, TO
.905±.015 DEPTH
90°±4° CSK TO .21 DIA
.169 DIA +.004 TO
1.000±.015 DEPTH
.169 DIA 250 AND ⊚ J .010 DIA
1.450
.203±.002
.688±.003
SEE VIEW R
.660 MIN FULL THD
.227±.020
.738±.010
118°±5°
SEE VIEW A
.625±.003
.016 R MAX
30°±2°
.86±.02
.50
.69
-H- (FORGED)
.078 DIA +.003 THRU
⌯ J .004 TOTAL
.6249 DIA+.0005 THRU, ⊚ G .010 DIA
-C- .725 DIA+.005 C BORE TO DEPTH SHOWN. HONE TO SIZE AFTER PHOSPHATE COATING.
-C- (FORGED DIA 2 PLACES)
.023 R ±.008
-S- (FORGED)
.250
⌯ S .020 TOTAL
.085
.129 DIA THRU
⌯ H .020 TOTAL
.270±.002
1.750
.261
.125±.015
.145+.005
.08 X 45°±2° CHAMFER
MACHINE THIS SURFACE IF NECESSARY
.031 R MAX
.060 REF, 2 PLACES
.812 R, 2 PLACES
-E- (FORGED)
2.265±.010
.670
.195±.010
.275±.004
⌯ B .010 TOTAL
-K-
.072
.312 DIA±.010 END MILL
15°
.152±.015
VIEW R
SCALE: 4/1
.161
.08 X 45°±2° CHAMFER, 2 PLACES
(FORGED DIA -G- 2 PLACES)
.275±.004
-L-
.41
.145 DIA TO DEPTH SHOWN
.125 DIA+.004 THRU TO INTERSECT -J- AS SHOWN.
⌯ J .010 TOTAL
⌯ C .010 TOTAL
.905±.015
.1805 DIA+.0010 TO DEPTH SHOWN
-J- ⌯ B .006 TOTAL
CSK 90°±4° TO .21 DIA
VIEW A
ALTERNATIVE METHOD
63

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NOTE:

1. PLANE -B- IS ESTABLISHED BY DIAMETERS -C- AND WIDTH -D-.
2. .005 MAX MISMATCH PERMISSIBLE BETWEEN SURFACES -K- AND -L-.
3. FINISH, 5.3.1.2 OF MIL-STD-171. BEFORE GRIT BLAST, MASK DIAMETER -J-. Ⓓ
4. FINISH 125 EXCEPT AS NOTED.
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED. Ⓑ
7. MIL-W-13855 APPLIES. Ⓒ

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62068 REV D WITH CHANGES	27 APR 70	
		A	(5) SEE EO HRD 02197	15 JUL 70	
		B	(3) SEE EO HRD 02197-3	1 SEPT 70	
		C	(4) SEE EO HRD 02261	15 OCT 70	
		D	(5) SEE EO HQR 10636	2[illegible] FEB 71	
		E	(10) SEE ERR HQR 20327	14 DEC 72	
		F	(2) SEE ERR HQR 30724	4 SEP 73	R.E.
		G	NORW2S0026 82-05-21	83-02-03	
		H	NOR W5S0041/85-03-25	85-07-12	

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT DESIGN ACTIVITY FSCM No. [illegible]

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			MI6
RH		C8448565	MI6AI
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
MAKE FROM FRONT SIGHT FORGING F8448643

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO

DATE 27 APR 1970

PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SIGHT, FRONT

SIZE	CODE IDENT NO	DRAWING NO
F	19204	8448566

SCALE 2/1
SHEET 1 OF

AMSWE Form 1037, 29 Jul 69

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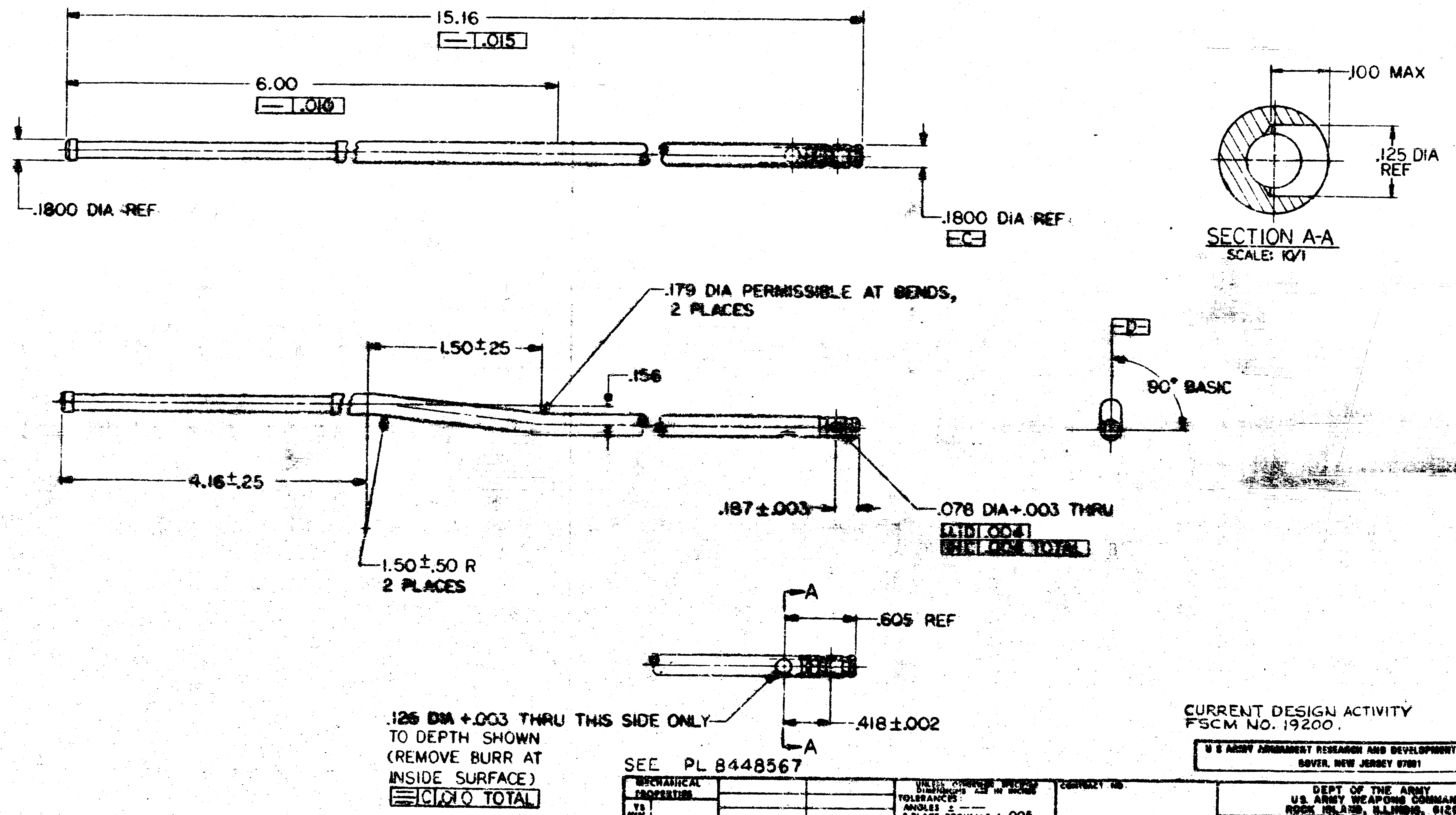
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D61645 REV B	27 APR 70	
M		A	(1) SEE EO HRD 02197-3	15 JUL 70	
	-	B	(3) SEE ERR HGR 20778	6 OCT 72	R.E.
		C	NOR W1S2037 82-02-16	83-12-09	
		D	NOR W2S3258 / 82-12-30	84-09-04	R
		E	NOR G8S3007/880301	881003	

NOTE

1. MAKE FROM GAS TUBE AND PLUG ASSEMBLY -- 8448568.
2. FINISH 125√.
3. MIL-W-13855 APPLIES.


15.16
⏤ .015
6.00
⏤ .010
.1800 DIA REF
.1800 DIA REF
C
.100 MAX
.125 DIA REF
SECTION A-A
SCALE: 10/1
.179 DIA PERMISSIBLE AT BENDS, 2 PLACES
1.50±.25
.156
D
90° BASIC
4.16±.25
.187±.003
.078 DIA+.003 THRU
⊥ D .004
⌰ C .004 TOTAL
1.50±.50 R
2 PLACES
A
.605 REF
.125 DIA +.003 THRU THIS SIDE ONLY
TO DEPTH SHOWN
(REMOVE BURR AT INSIDE SURFACE)
⌰ C .010 TOTAL
.418±.002
A

CURRENT DESIGN ACTIVITY
FSCM NO. 19200.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL 8448567

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL 2			
RA			
BH		C8448565	M16 M16A2
BH			
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ---
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
5.4.1 OF MIL-STD-171

CONTRACT NO.

DATE 27 APR 1970

PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

GAS TUBE ASSEMBLY

SIZE D | CODE IDENT NO. 19204 | DRAWING NO. 8448567

SCALE 2/1 | SHEET | OF

CDI

AMSWE Form 4030, 29 Jul 69

D8448567

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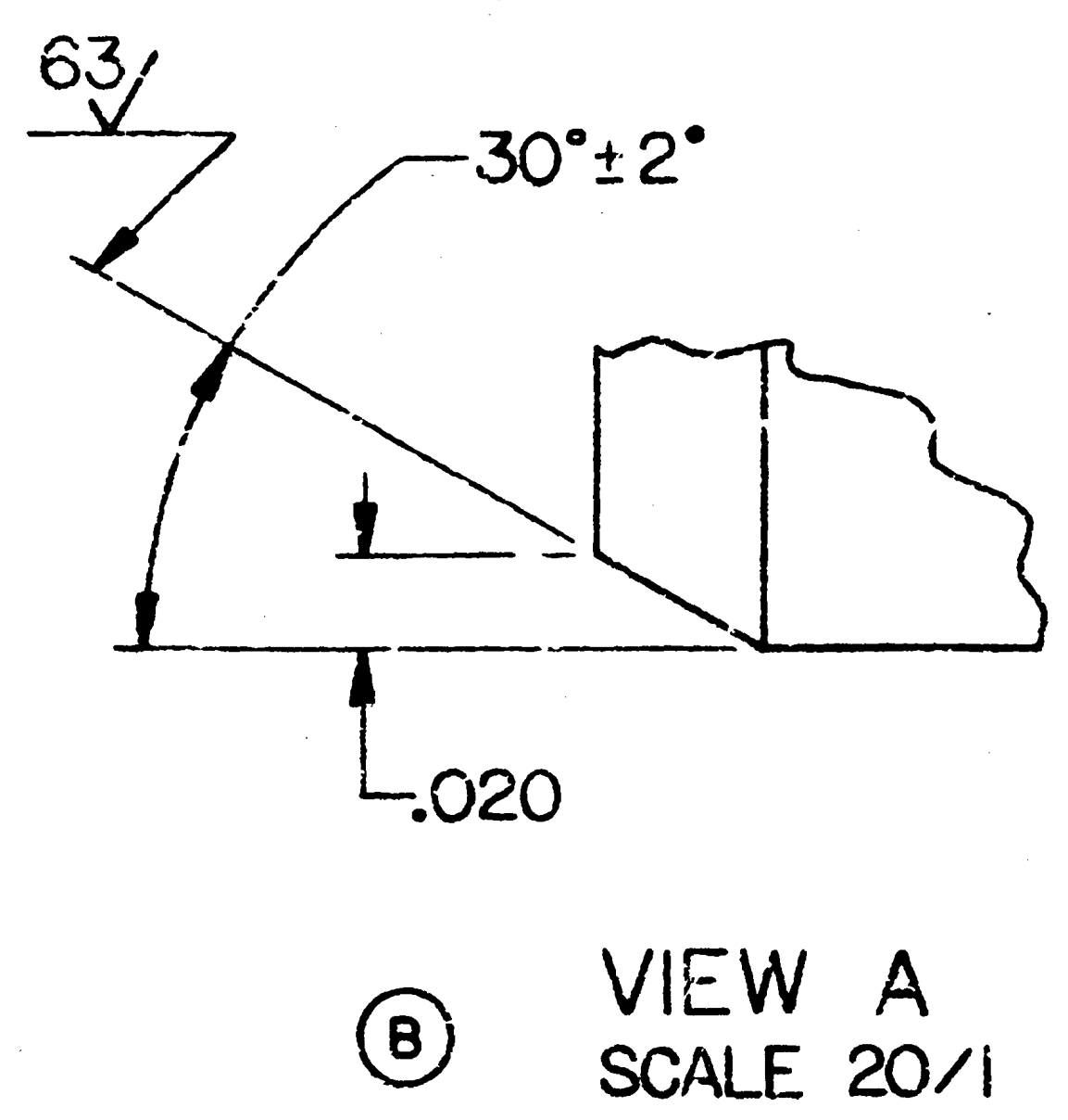
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D61643 REV A	27 APR 70	
		A	(1) SEE EO HRD 02197-3	15 JULY 70	
		B	(3) SEE HQR 10721	17 MAY 71	J. B.
		C	NORWE80026 82-05-21	83-02-05	

NOTE:

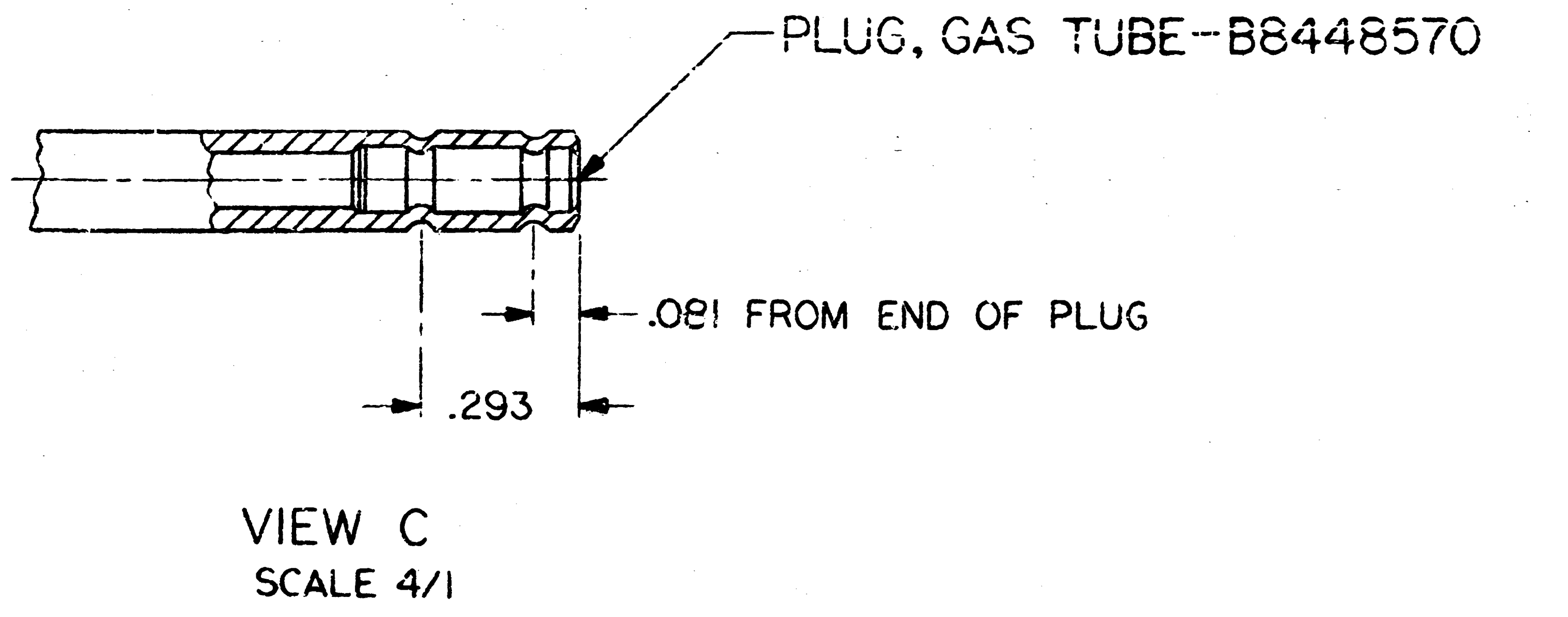
Ⓐ

1. INSERT PLUG, GAS TUBE, B8448570 AS SHOWN FLUSH WITH END OF TUBE, GAS, B8448569 WITHIN ±.010 PRIOR TO FURTHER MACHINING. SECURELY CRIMP ENTIRE PERIPHERY 2 PLACES AS SHOWN.
2. FACE BOTH ENDS TO BRING TO 15.17 LENGTH.
3. MIL-W-13855 APPLIES.

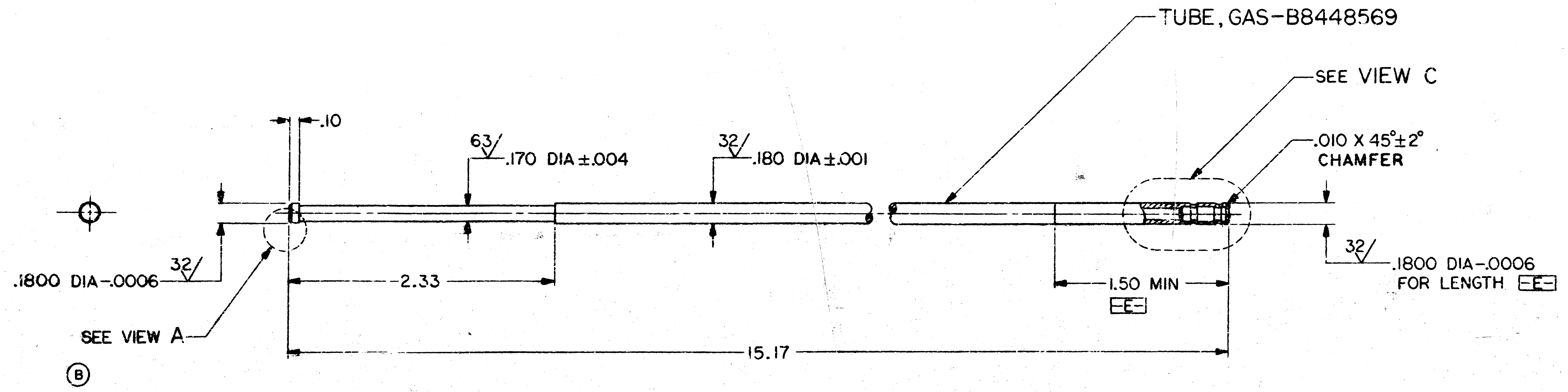
Ⓑ



VIEW A
SCALE 20/1



VIEW C
SCALE 4/1



D8448568

SEE EPL-8448568

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
D8448567	M16 M16A1

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
—

FINAL PROTECTIVE FINISH
—

CONTRACT NO:

DATE 27 APR 1970

PREPARED	MSC	A. J. H.
CHECKED		
ENGINEER		

SUBMITTED F. P. Gilbert

APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

GAS TUBE AND
PLUG ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448568

SCALE 2/1 SHEET OF

CDI

AMSWE Form 4030, 29 Jul 69

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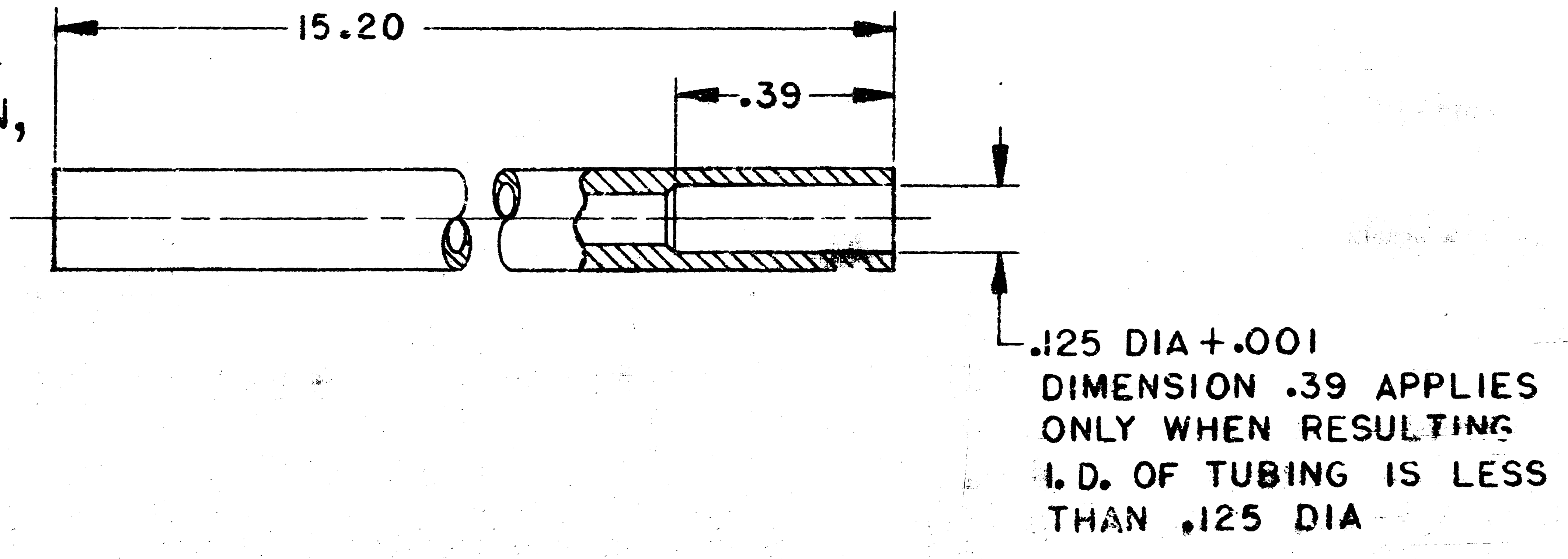
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B61789 REVISION A	27 APR 70	
M		A	(1) SEE EO HRD 02197-3	15 JULY 70	
M		B	(2) SEE ERR HQR 20778	6 OCT 72	R.C.
		C	NOR W280026 82-05-21	83-02-03	

NOTES:

1. TUBING, STEEL, CORROSION-RESISTANT (304), TYPE I, ROUND, .187 O.D. +.005, .0350 ± .0055 WALL THICKNESS, 1/2 H-COLD DRAWN, SPEC MIL-T-5695. Ⓑ
2. FINISH $\sqrt[125]{}$.
3. ~~MIL-W-13855~~ APPLIES. Ⓑ


15.20
.39
.125 DIA + .001
DIMENSION .39 APPLIES ONLY WHEN RESULTING I.D. OF TUBING IS LESS THAN .125 DIA

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL 2			M16
RA		D8448568	M16A1
BH			
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ± .01
MATERIAL
SEE NOTE 1
FINAL PROTECTIVE FINISH

CONTRACT NO
DATE 27 APR 1970
PREP RGA
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

TUBE, GAS

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448569

SCALE 4/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

CDI

B 8448569

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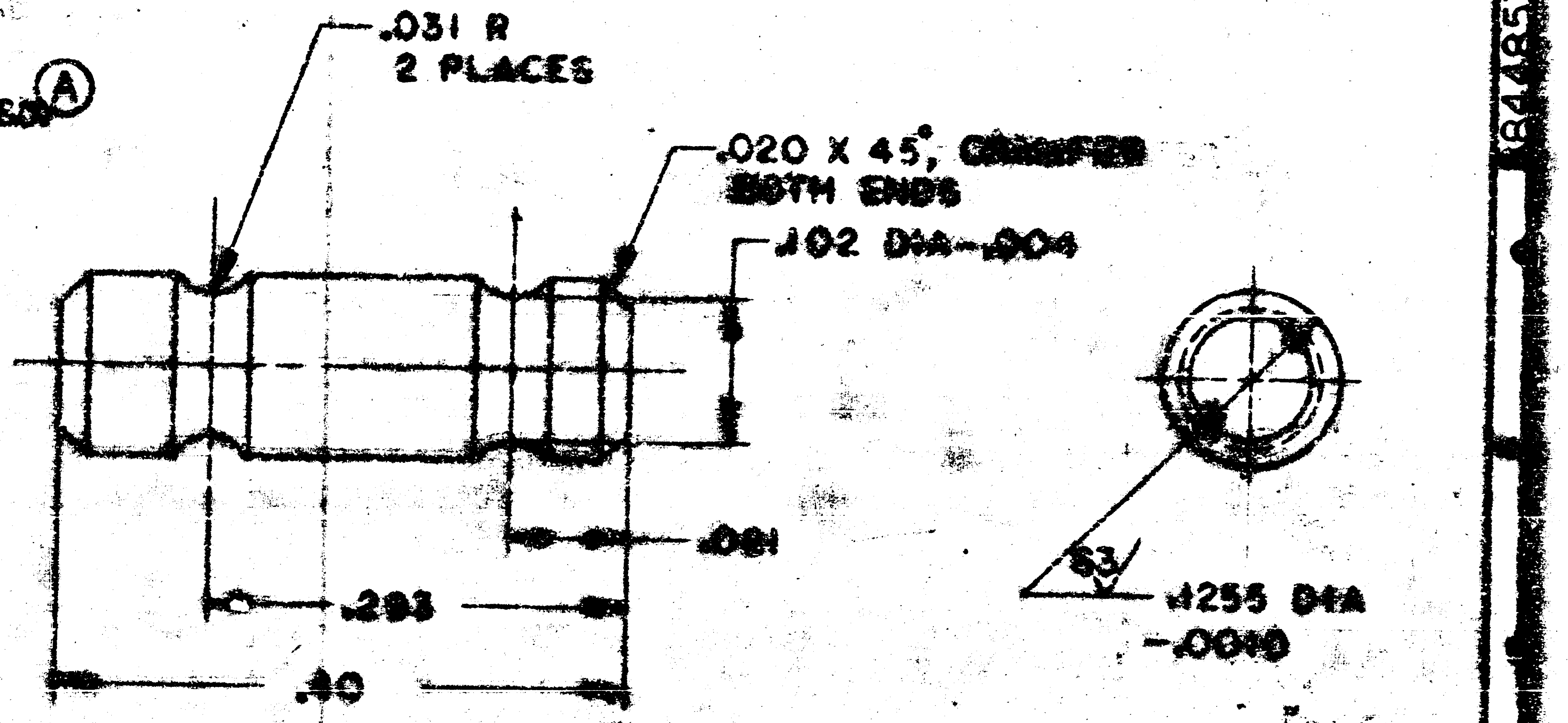
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
Ⓜ			REDRAWN FROM COLT'S DRAWING C61644 REVISION A	27 APR 70	
M	.	A	(2) SEE ERR HQR 20778	6 OCT 72	R.C.
		B	[illegible] 88-05-21	88-02-08	[illegible]
		C	HQR 68S2007/ 880329	880926	[illegible]

NOTES:

1. WIRE, STEEL, CORROSION RESISTING, CMPSN 302, 304 OR 321, CONDITION A, SPEC ASTM-A580 Ⓐ
2. FINISH $^{125}\surd$ EXCEPT AS NOTED.
3. FINISH 5.4.1 OF MIL-STD-171.
4. MIL-I-45208 APPLIES. Ⓐ



CURRENT DESIGN ACTIVITY FSCM NO.19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

APPLICATION	
NEXT ASSY	USED ON
	M16
D8448568	M16A1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±2°
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL
SEE NOTE 1

FINAL PROT. FOR FINISH
SEE NOTE 3

CONTRACT NO.
DATE 27 APR 1970
PREP R.G.D. Q.C.
CHK
ENGR
SUBMITTED
APPROVED R. J. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PLUG, GAS TUBE

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	6448570

SCALE 10/1 SHEET OF

CD1

AMSWE Form 4038, 29 Jul 69

6448570

4 3 2 1

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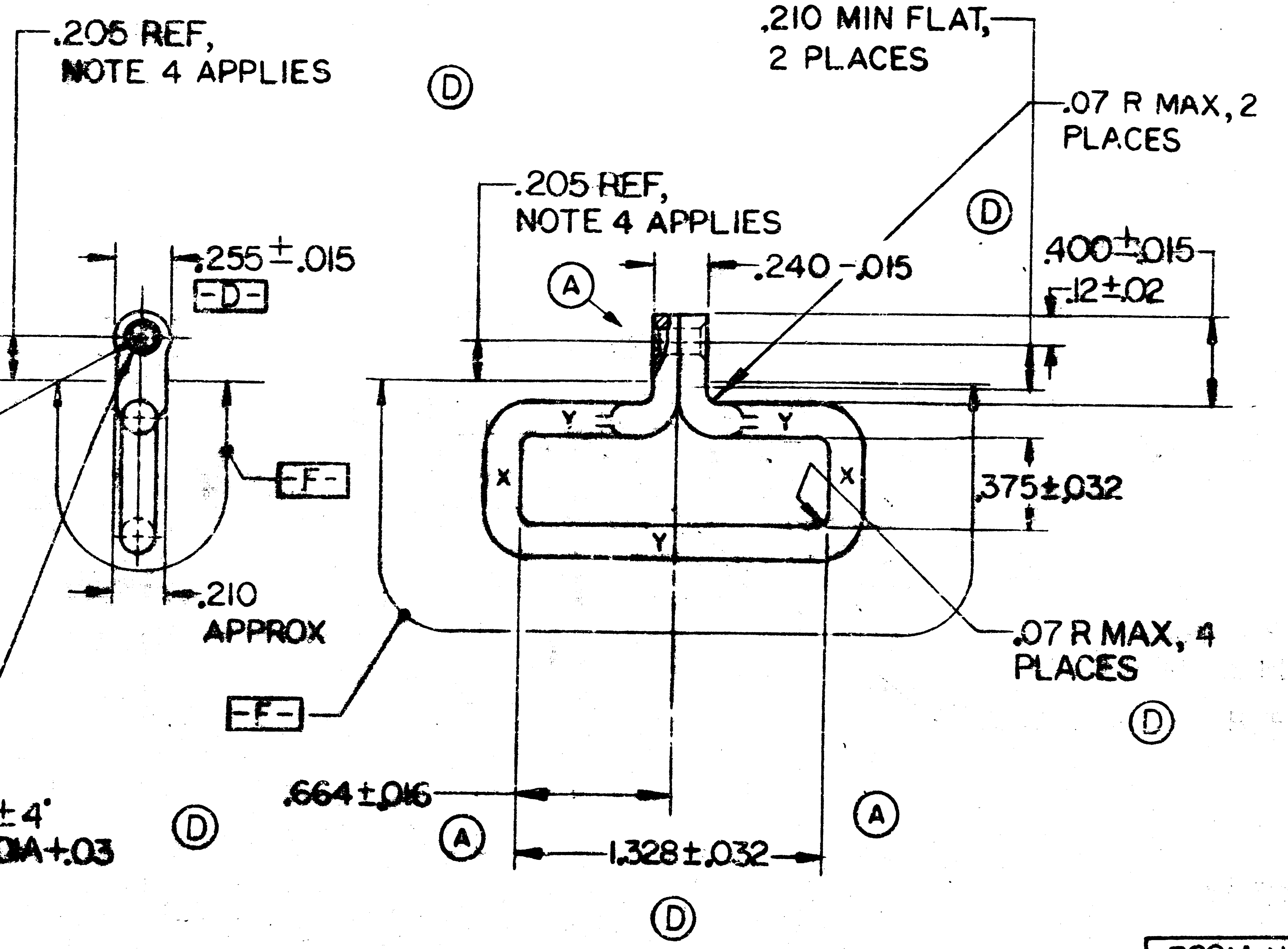
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING D62280 REV B	27 APR 70	
M		A	(4) SEE EO HRD-02197	15 JULY 70	
M		B	(2) SEE EO HRD 02197-3	1 SEPT 70	
		C	SEE ERR HQR 10822	9 AUG 71	LB
		D	(6) SEE ERR HQR 20652	9 APR 72	LB
M		E	(2) SEE ERR HQR 20827	14 DEC 72	RE
M		F	NOR W9S2009 80-02-13	80-05-16	
		G	NOR W4S 0024/84-10-17	85-01-25	SB

1. WIRE, STEEL, CMPSN 1010 OR 1018, .156 DIA, ASTM A545. Ⓔ
2. FINISH 63√.
3. APPLY PROVIDENCE CHEMICAL DIV, WHITTACKER CORP., ADHESIVE PRIMER COMPOUND NO. R-8064 OR D224 OR EQUIV., TO ALL SURFACES RECEIVING PLASTIC COATING. THEN DIP COAT ALL AREAS INDICATED BY -F- WITH FLAT BLACK CHEM-O-SOL, PROVIDENCE CHEMICAL DIV., WHITTACKER CORP, COMPOUND NO. R-8461 OR EQUIV.
4. CHEM-O-SOL COAT ALL SURFACES TO WITHIN .205±.025 OF MOUNTING HOLE CENTER. AREA AROUND MOUNTING HOLE MUST BE FREE OF COATING. PLASTIC COATED DIA TO BE .165+.040 (2) VERT LEGS (X) .165+.060 ON (3) HORIZONTAL SECTIONS (Y). Ⓑ Ⓓ
5. FINISH 5.3.1.3 OF MIL-STD-171 BEFORE FINISH SPECIFIED IN NOTE 3.
6. TOOL AND FORMING MARKS PERMISSIBLE PRIOR TO CHEM-O-SOL COATING, PROVIDED COATING IS NOT DEGRADED TO THE EXTENT OF SURFACE DISCONTINUITIES.
7. MIL-W-13855 APPLIES.



.123 DIA+.004 THRU
IN LINE WITHIN .005, 90°±4°
C'SINK ONE SIDE TO .15 DIA+.03
(OPTIONAL BOTH SIDES) Ⓓ
⌯ D .04 TOTAL Ⓔ

FSCM NO.
19200

Ⓑ Ⓐ Ⓒ

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		C8448565	M16
RH		C8448565	M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTES 3,4 AND 5

CONTRACT NO:
DATE 27 APR 1970
PREPARED
CHECKED
ENGINEER
SUBMITTED F P Gilhooly
APPROVED R.S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801
~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

SWIVEL, SLING

SIZE C | CODE IDENT NO. 19204 | DRAWING NO. 8448571
SCALE 2/1 | SHEET | OF

CDI

AMSWE Form 403C, 29 Jul 69

C8448571

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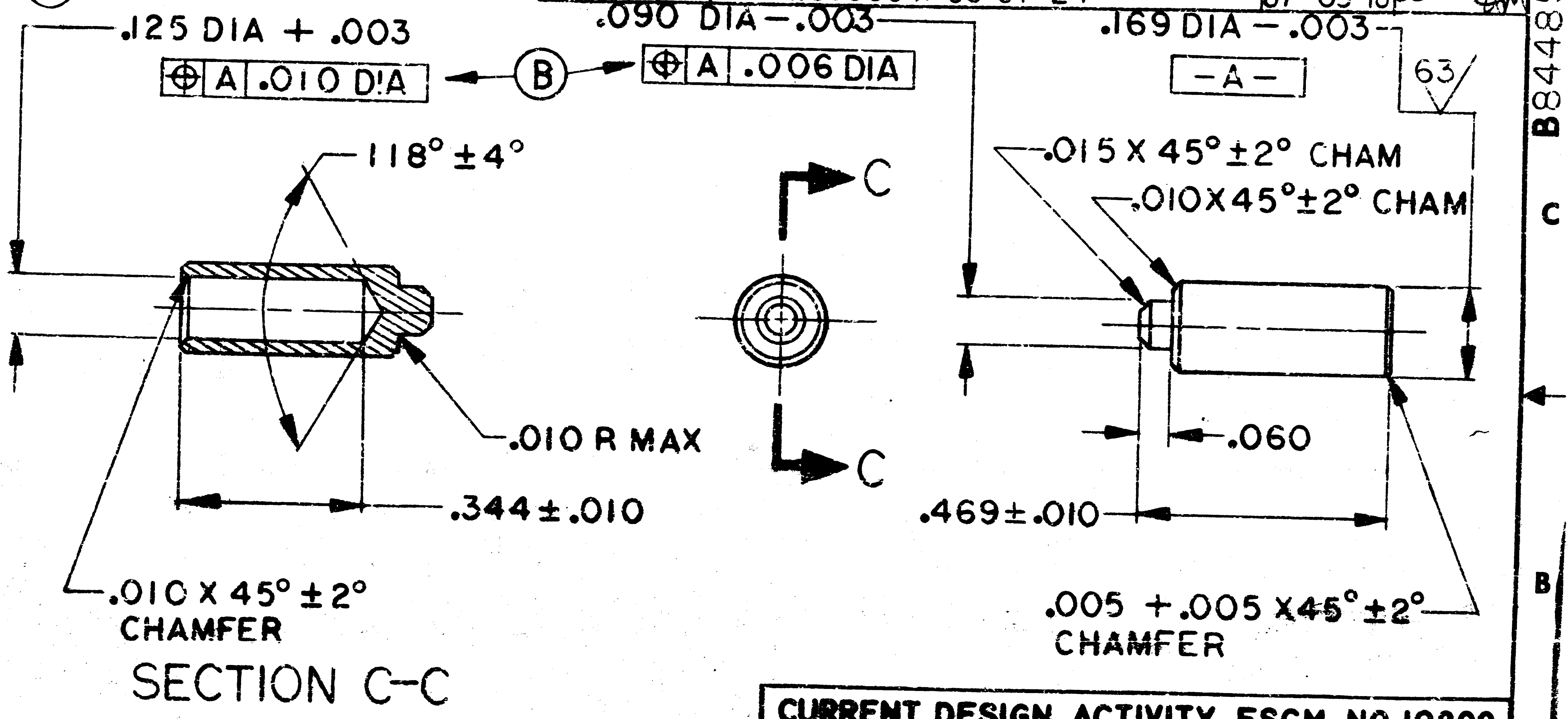
REVISIONS					
M.F	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C61705 REVISION C	27APR. 70	
		A	(1) SEE EO HRD 02197-3	15 JUL 70	
M		B	(4) SEE ERR HQR 20827	14 DEC 72	R.E.
M		C	NOR W9S2009 80-02-13	80-05-16	
		D	NOR W3S0059/ 83-11-04	84-02-02	
		E	NOR W6S0084/86-07-24	87-05-18	

B8448573

NOTES:

1. FINISH 125/√ EXCEPT AS NOTED.
2. FINISH 5.3.1.2 OF MIL-STD-171.
3. BREAK SHARP EDGES .005+.010.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. Ⓑ
5. MIL-W-13855 APPLIES. Ⓑ



SECTION C–C

CURRENT DESIGN ACTIVITY FSCM NO.19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

Ⓑ

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA		F8448601	M16	
BH		F8448522	M16A1	
RH	15N 72.5–76	NEXT ASSY	USED ON	
		APPLICATION		

Ⓑ

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± ——
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± ——

MATERIAL
WIRE, CMPSN 4130, ASTM A322 OR A331

FINAL PROTECTIVE FINISH
SEE NOTE 2

CONTRACT NO.	
DATE	27 APR 1970
PREP	
CHK	
ENGR	
SUBMITTED	
APPROVED	R. S. Henry

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

DETENT,
FRONT SIGHT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448573

SCALE 4/1 SHEET 1 OF 1

CD1

AMSWE Form 403B, 29 Jul 69

5 4 3 2 1

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M-		B	REPLACES REV A W/CHANGE SEE ERR HQR 20827	14 DEC 72	LB
		C	NORW2S0011 / 82-04-13 (ECP W250034 / 82-07-15) (ECP W353120 / 83-07-07)	83-11-04	

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0180 ± .0005
COIL DIAMETER (O.D)	.115 ± .003
FREE LENGTH	.75 REF
TOTAL COILS	20 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .557 AFTER SET	1.78 LB ± .18 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	
SOLID LENGTH	.390 MAX
TYPE OF ENDS	CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631 (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDTN CH900. HOLD AT 900° F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003+.012 .

~~CURRENT DESIGN ACTIVITY~~
~~FSCM NO. 19200~~

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448574

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		F8448601	M16
BH		F8448522	M16 A1
RH	15N 84.5 MIN	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: 5.4.1 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 70
PREP P. Vernon Y. Gutman
CHK J. Donaldson D. Kudek
ENGR R. Elbe L. Brunton
SUBMITTED A. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, FRONT SIGHT DETENT

SIZE B | CODE IDENT NO. 19204 | DRAWING NO. 8448574

SCALE — | SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

8448574

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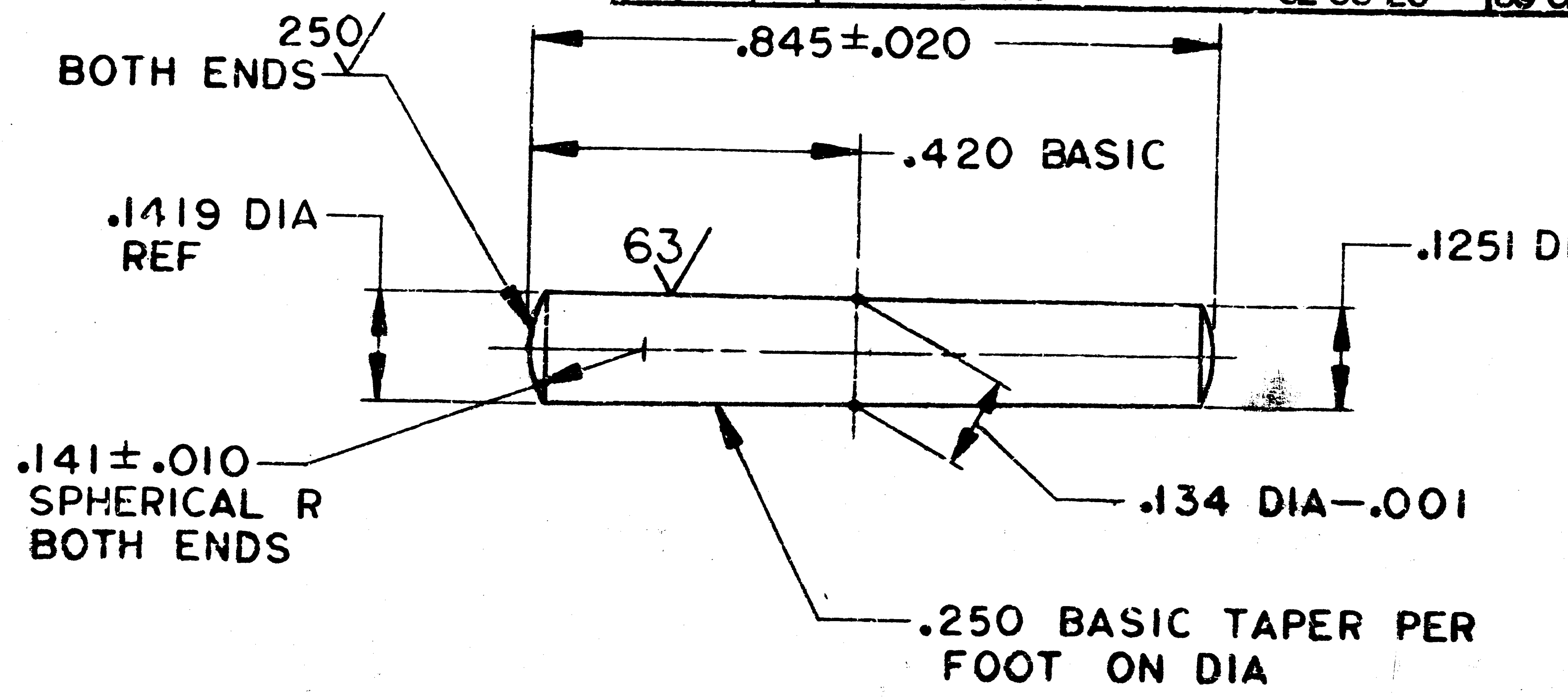
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING C62086 REVISION B	27 APR 70	
		A	SEE ERR HQR 20714	13 JUL 72	LB
M	-	B	(2) SEE ERR HQR 20827	14 DEC 72	RE
		C	(1) SEE ERR HQR 50625	18 MAR 75	LB
M		D	NOR W9S2009 80-02-13	80-05-16	
		E	NORW2S2015 82-08-20	83-02-03	

NOTE:

1. SUGGESTED HEAT TREAT: LIQUID CARBURIZE AT 1550°F TO OBTAIN A TOTAL CASE DEPTH OF .010/.015.
2. BREAK SHARP EDGES .005+.010.
3. STEEL, CMPSN 4027, 4028, AND 4037, SPEC ASTM A304 OR STEEL, CMPSN 1030, 1033, 1035, AND 1037, SPEC ASTM A108.
4. MIL-W-13855 APPLIES.



CURRENT

CODE IDENT NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

~~US ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX			
EL 2		F8448601	M16
RA		F8448522	M16A1
BH			
RH	15N 89-91	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ±
MATERIAL
FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

CONTRACT NO:
DATE 27 APR 1970
PREP RGA
CHK
ENGR
SUBMITTED
APPROVED R. S. Henry

PIN, TAPER,
FRONT SIGHT

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448575

SCALE 5/1 SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

8448575

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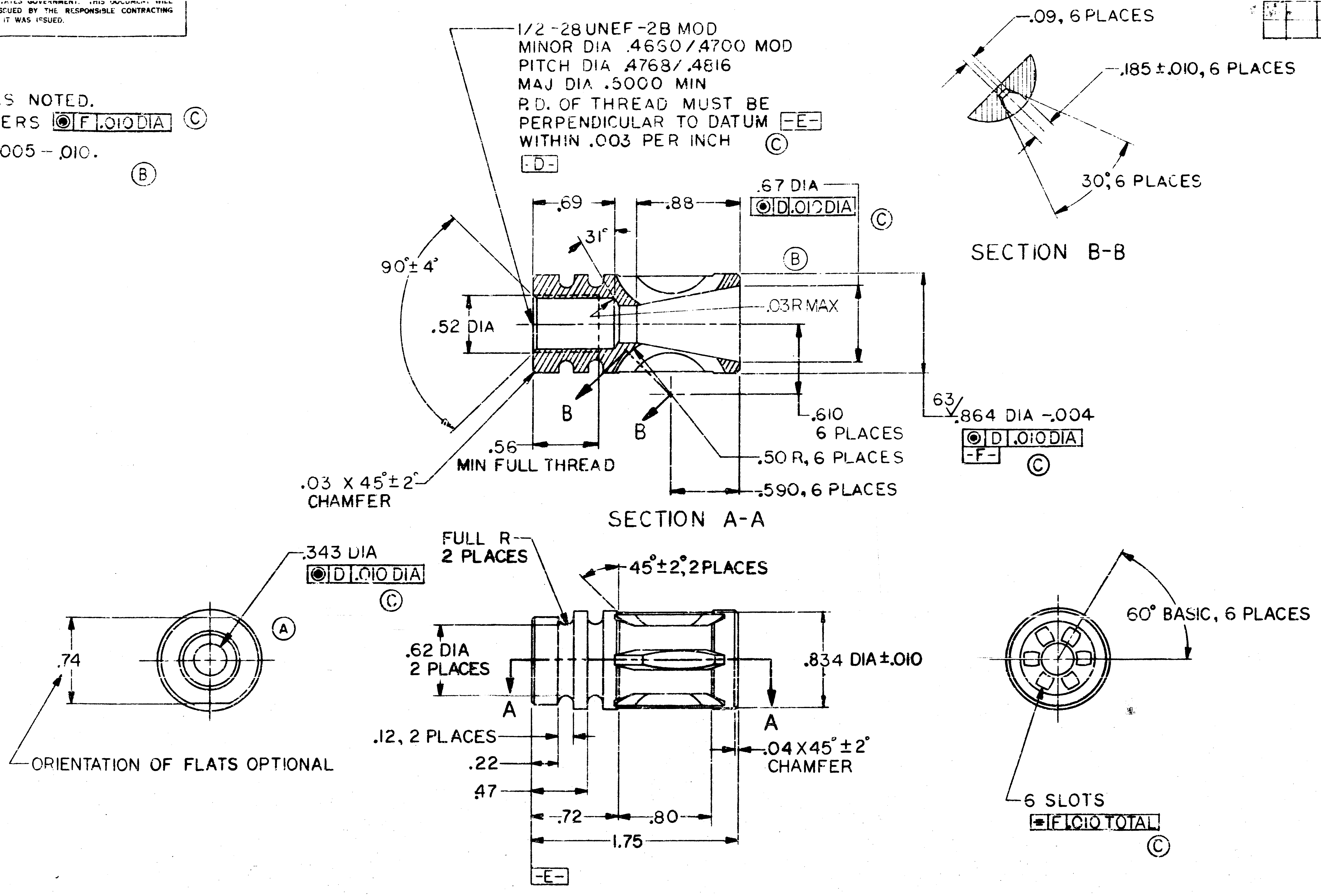
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
✓			REDRAWN FROM COLT'S DRAWING D62348 REV A	27APR70	
		A	(2)SEE EO HRD 02197-3	15JUL70	
		B	(2) SEE EO HQR 10627	20 FEB71	
		C	(6) SEE ERR HQR 20775	6OCT 72	R.E.
		D	NOR W9S2009 80-02-13	80-05-16	

NOTE:

1. FINISH 125√ EXCEPT AS NOTED.
2. ALL OUTSIDE DIAMETERS ◎ F .010 DIA Ⓒ
3. BREAK SHARP EDGES .005 – .010.
4. MIL-W-13855 APPLIES. Ⓑ


1/2-28 UNEF-2B MOD
MINOR DIA .4660/.4700 MOD
PITCH DIA .4768/.4816
MAJ DIA .5000 MIN
P.D. OF THREAD MUST BE PERPENDICULAR TO DATUM -E- WITHIN .003 PER INCH Ⓒ
-D-
.69
.88
.67 DIA
◎ D .010 DIA
Ⓒ
31°
Ⓑ
90°±4°
.52 DIA
.03R MAX
B
B
.56
MIN FULL THREAD
.03 X 45°±2° CHAMFER
.610
6 PLACES
.50 R, 6 PLACES
.590, 6 PLACES
63/
.864 DIA -.004
◎ D .010 DIA
-F-
Ⓒ
SECTION A-A
.09, 6 PLACES
.185±.010, 6 PLACES
30°, 6 PLACES
SECTION B-B
.343 DIA
◎ D .010 DIA
Ⓒ
Ⓐ
.74
ORIENTATION OF FLATS OPTIONAL
FULL R
2 PLACES
45°±2°, 2 PLACES
.62 DIA
2 PLACES
A
A
.834 DIA ±.010
.12, 2 PLACES
.22
.47
.72
.80
1.75
.04 X 45°±2°
CHAMFER
-E-
60° BASIC, 6 PLACES
6 SLOTS
◎ F .010 TOTAL
Ⓒ

D 8448576

Ⓐ

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200

~~DEPT OF THE ARMY~~
~~US ARMY WEAPONS COMMAND~~

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA		F9327227	M231
BH		F8448601	M16
		F8448522	M16A1
RH	C26-32	NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
STEEL AISI 4130 OR 41L30

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO

DATE 27APR 1970
PREPARED
CHECKED
ENGINEER B. Billiet
SUBMITTED F. P. McElroy
APPROVED R. J. Henry

SUPPRESSOR, FLASH

SIZE D
CODE IDENT NO ~~19204~~
DRAWING NO. 8448576
SCALE 2/1
SHEET OF

CDI

AMSWE Form 403D, 29 Jul 69

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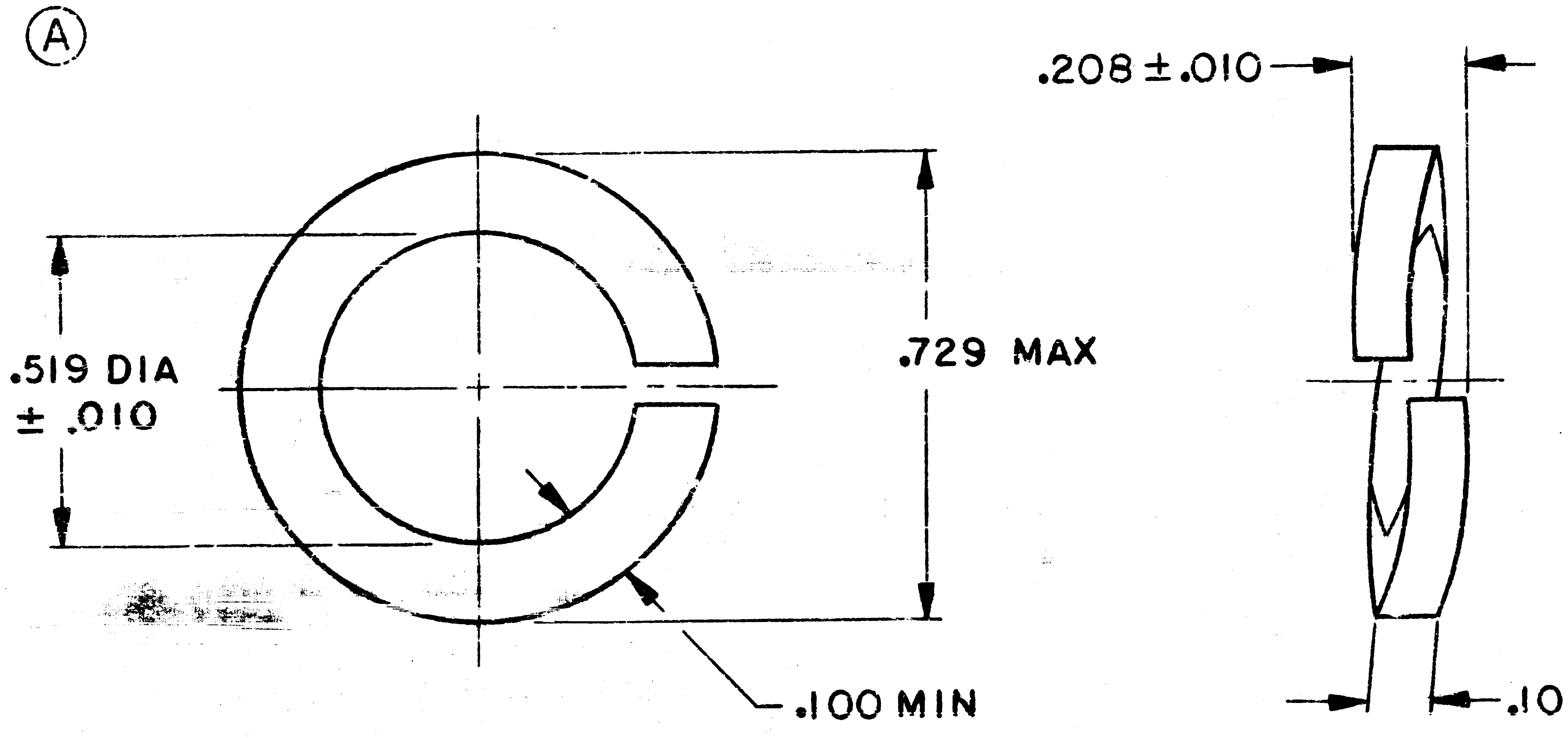
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REDRAWN FROM COLT'S DRAWING B 62126 REVISION A	27APR 70	
M		A	(2) SEE ERR HQR 20778	6 OCT 72	R.E.
		B	NOR W9S2009 80-02-13	80-05-16	

B8448577

NOTE:

1. STEEL, CMPSN 1060 THRU 1080, ASTM A322. Ⓐ
2. FINISH $\overset{125}{\surd}$.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. MAY BE PURCHASED FROM LOCK RINGS, INC. 1302 NO. CONANT ST. MAUMEE, OHIO 43537.
5. MIL-W-13855 APPLIES. Ⓐ



CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX		F 9327227	M 231
EL 2		F8448601	M16
RA		F8448522	M16A1
BH			
RH	C45 - 53	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTE 3

CONTRACT NO
DATE 27 APR 1970
PREP R.J.H.
CHK
ENGR D. Billiet
SUBMITTED F. P. Gilhooly
APPROVED R.S. Henry

WASHER, LOCK

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448577

SCALE 4/1
SHEET 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

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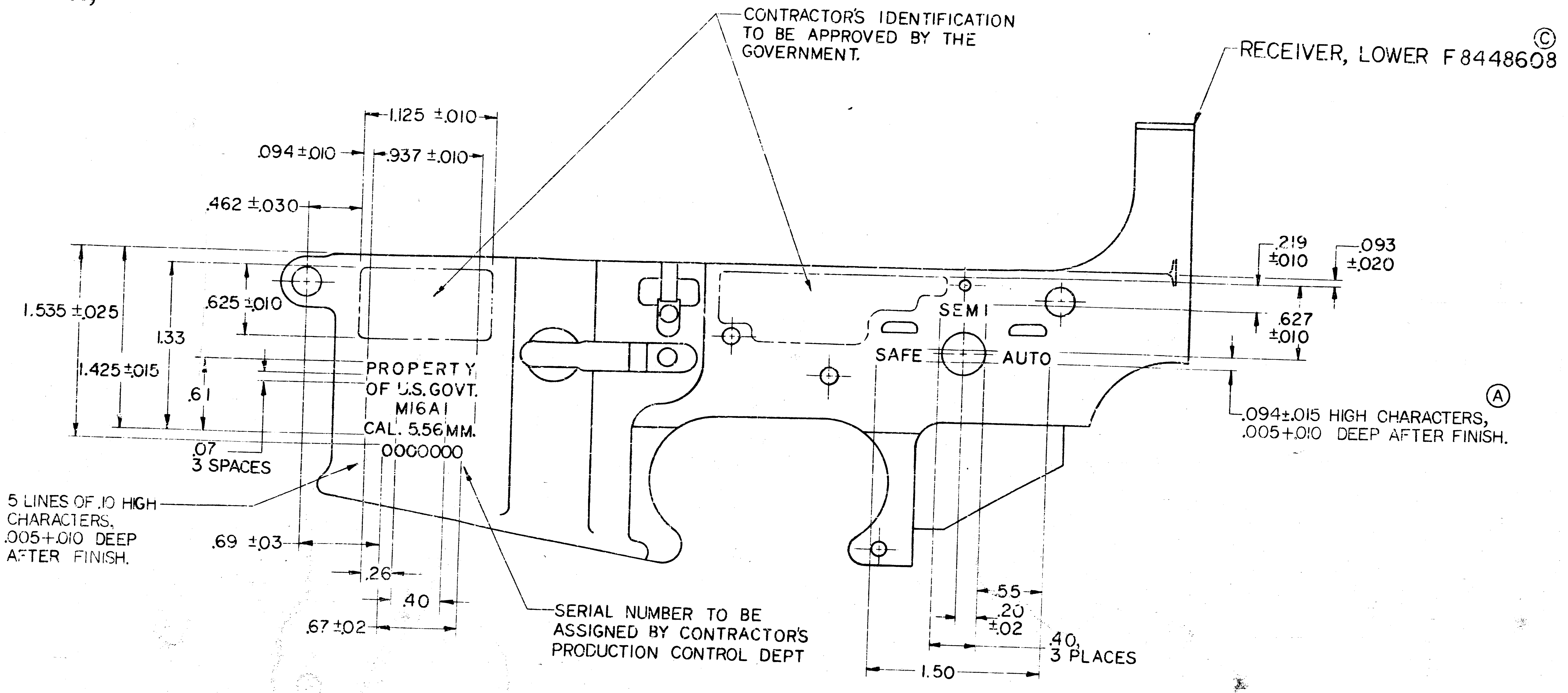
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62222 REV C	27 APR 70	
		A	(3) SEE ERR HQR 10628	20 FEB 71	
		B	SEE ERR HQR 20778	3 OCT 72	R.E.
		C	SEE NOR 7SE 0012-0001	16 APR 76	
		D	NOR W2S0026 82-05-21	83 02 03	

NOTE:

1. GRIT BLAST BEFORE FINISH TO PRODUCE NON-REFLECTIVE MATTE SURFACE AFTER FINAL FINISH.
2. FINISH MIL-A-8625, TYPE III, CLASS 2. FILM THICKNESS .0010 ±.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL. Ⓑ
3. MIL-W-13855 APPLIES. Ⓐ



CONTRACTOR'S IDENTIFICATION TO BE APPROVED BY THE GOVERNMENT.

RECEIVER, LOWER F8448608

.094±.015 HIGH CHARACTERS, .005+.010 DEEP AFTER FINISH.

5 LINES OF .10 HIGH CHARACTERS, .005+.010 DEEP AFTER FINISH.

SERIAL NUMBER TO BE ASSIGNED BY CONTRACTOR'S PRODUCTION CONTROL DEPT

Ⓒ SEE PL 8448580

CURRENT DESIGN ACTIVITY FSCM NO. 19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			
RH		C8448579	M16 A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
MAKE FROM RECEIVER, LOWER F8448608

FINAL PROTECTIVE FINISH
SEE NOTE 2

CONTRACT NO.

DATE 27 APR 1970
PREPARED CAR
CHECKED A. J. H. O. Kolak
ENGINEER
SUBMITTED F. P. Gilhooly
APPROVED R. S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RECEIVER, LOWER
MODEL M16A1

SIZE D
CODE IDENT NO. 19204
DRAWING NO. 8448580
SCALE 2/1
SHEET 1 OF 1

CDI

D 8448580

AMSWE Form 403D, 29 Jul 69

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REPLACES COLT'S DRAWING B90402 REV A	27 APR 70	
M		A	(1) SEE ERR HQR 20778	6 OCT 72	R.G.
M		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR W0S0032 80-08-14	81-09-15	JM

8448664

SAME AS MS16632-1012 EXCEPT FINAL PROTECTIVE FINISH TO BE 5.3.1.2 OF MIL-STD-171.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200

Ⓐ ALTERED ITEM DRAWING

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN			
YS MAX		D9327228	M 231
EL 2		D8448602	M16
RA		D8448523	M16A1
BH			
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± ——
3 PLACE DECIMALS ± ——
2 PLACE DECIMALS ± ——

MATERIAL ——

FINAL PROTECTIVE FINISH
SEE NOTE

CONTRACT NO	
DATE	27 APR 1970
PREP	ECL A.J.H.
CHK	
ENGR	
SUBMITTED	F. A. Gelbuhy
APPROVED	R. L. Henry

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

RING, RETAINING, COVER HINGE PIN

SIZE	CODE IDENT NO.	DRAWING NO.
B	~~19204~~	8448664

SCALE NONE SHEET OF

CDI

AMSWE Form 403B, 29 Jul 69

4 3 2 1

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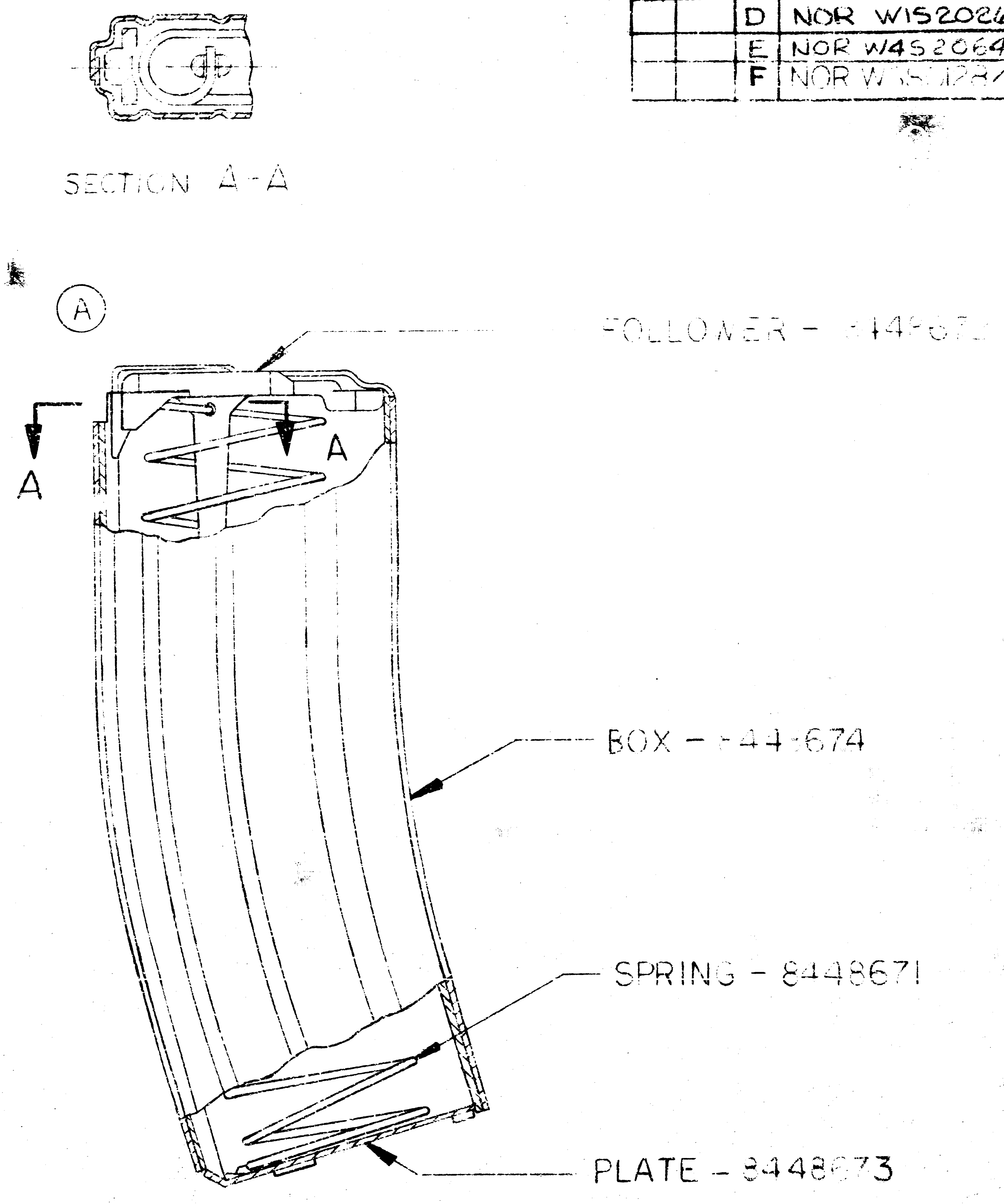
REVISIONS

LTR	DESCRIPTION	DATE	APPROVED
	REDRAWN FROM [illegible] DRAWING [illegible], REV A	[illegible] JUN 70	
A	SEE E.O. HRD 02227	19AUG70	[illegible]
B	(2) SEE ERR HQR 10799	6 JULY 71	[illegible]
C	SEE ERR HQR 30584	27 APR 73	[illegible]
D	NOR W1S2026 82-01-28	82-03-06	[illegible]
E	NOR W4S2064/84-10-17	84-12-13	[illegible]
F	NOR W[illegible]128/87[illegible]	88-01-26	ORFI-VZ

NOTE:

1. MIL-[illegible]-13[illegible] APPLIES.
2. SPRING FORCE WITH FOLLOWER DEPRESSED .250 INCH SHALL BE 3.0 LBS. ± .5 LB. (B)
3. EACH MAGAZINE ASSEMBLY SHALL BE CAPABLE OF WITHSTANDING A 30 ROUND FUNCTION FIRING TEST WHEN FIRED IN THE M16A2 OR M16A1 (9349000 OR 8448500) UTILIZING THE BOLT CATCH CONFIGURATION OF DRAWING D8448628 REV A OR LATER, AND THE M231 FPW (9327045) UTILIZING THE BOLT CATCH CONFIGURATION OF DRAWING D9327059, WITHOUT MALFUNCTION. AFTER FIRING THE 30TH ROUND FROM THE MAGAZINE, THE MAGAZINE FOLLOWER SHALL ACTUATE THE WEAPONS BOLT CATCH TO HOLD THE BOLT IN THE OPEN POSITION.



SEE [illegible] 8448670 (3)

CURRENT DESIGN ACTIVITY FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

[illegible] THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, [illegible]

MAGAZINE ASSY,
30 ROUND

MECHANICAL PROPERTIES	NEXT ASSY	USED ON
YS MIN		
YS MAX		
EL 2		
RA	9349000	M16A2
	9327045	M231 FPW
BH	[illegible]	M16
RH	8448500	M16A1
	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±

MATERIAL

FINAL PROTECTIVE FINISH

DATE 5 JUN 70
PREPARED E.R. Lindquist R. Vassig
CHECKED J. Barclay [illegible]
ENGINEER D. Billeit D. Krolak
SUBMITTED F. Billhooly
APPROVED R.S. Henry

SIZE C
CODE IDENT NO 19204
DRAWING NO **8448670**
SCALE 1/1
SHEET 1

ASWL Form 403C, 29 Jul 69

DRAWING SIZE D

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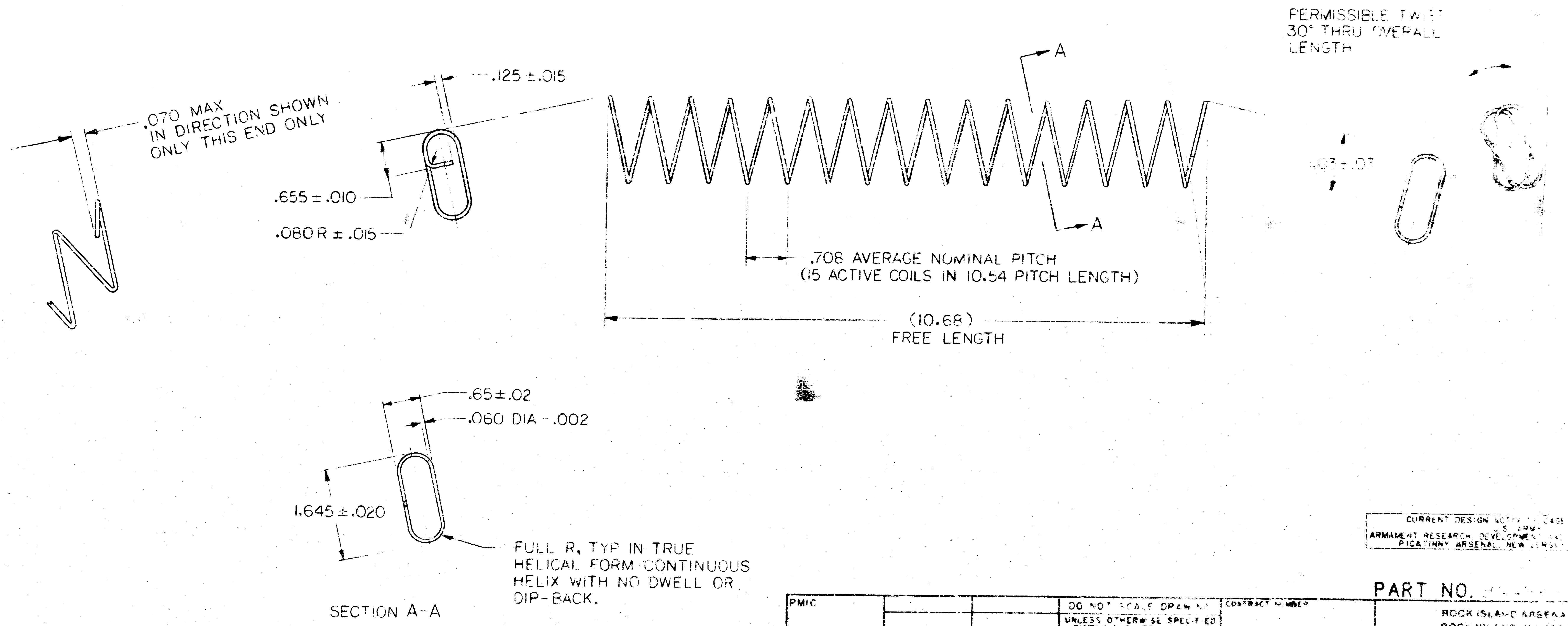
NOTES:

1. MATERIAL: WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313
2. FINISH: $\overset{125}{\checkmark}$
3. FINAL PROTECTIVE FINISH: FINISH 5.4.1 OF MIL-STD-171.
4. HEAT TREAT PER MIL-H-6875 EXCEPT AGING OPTIONAL.
5. MIL-W-13855 APPLIES.
6. LOAD HEIGHT REQUIREMENTS:
   - LOAD AT 6.565" = 3.1 LB. ± .4 LB.
   - LOAD AT 1.500" = 6.3 LB. ± .7 LB.

   SET SPRING TO SOLID HEIGHT THREE TIMES BEFORE MEASURING LOADS.



.070 MAX
IN DIRECTION SHOWN
ONLY THIS END ONLY
.125 ± .015
.655 ± .010
.080 R ± .015
A
A
.708 AVERAGE NOMINAL PITCH
(15 ACTIVE COILS IN 10.54 PITCH LENGTH)
(10.68)
FREE LENGTH
PERMISSIBLE TWIST
30° THRU OVERALL
LENGTH
.65 ± .02
.060 DIA - .002
1.645 ± .020
FULL R, TYP IN TRUE
HELICAL FORM-CONTINUOUS
HELIX WITH NO DWELL OR
DIP-BACK.
SECTION A-A

CURRENT DESIGN ACTIVITY CAGE
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT
PICATINNY ARSENAL, NEW JERSEY

PART NO.

PMIC		
MECHANICAL PROPERTIES		
YP		
TS		
EL2		30 ROUND
RA	8443670	MAGAZINE
BH	NEXT ASSY	USED ON
RH 15N 84.5 MIN	APPLICATION	

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
ANGLES FRACTION
2 PL ±
3 PL ±
THIRD ANGLE PROJECTION
MATL ENGR

CONTRACT NUMBER
CONTRACTOR
DRAWN BY DATE
CHECKED

ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS

SIZE CODE IDENT NO
D 19204
SCALE SHEET

SMCAR FORM 68, 1 DEC 87(TEMP) REPLACES SMCAR FORM 68, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED.

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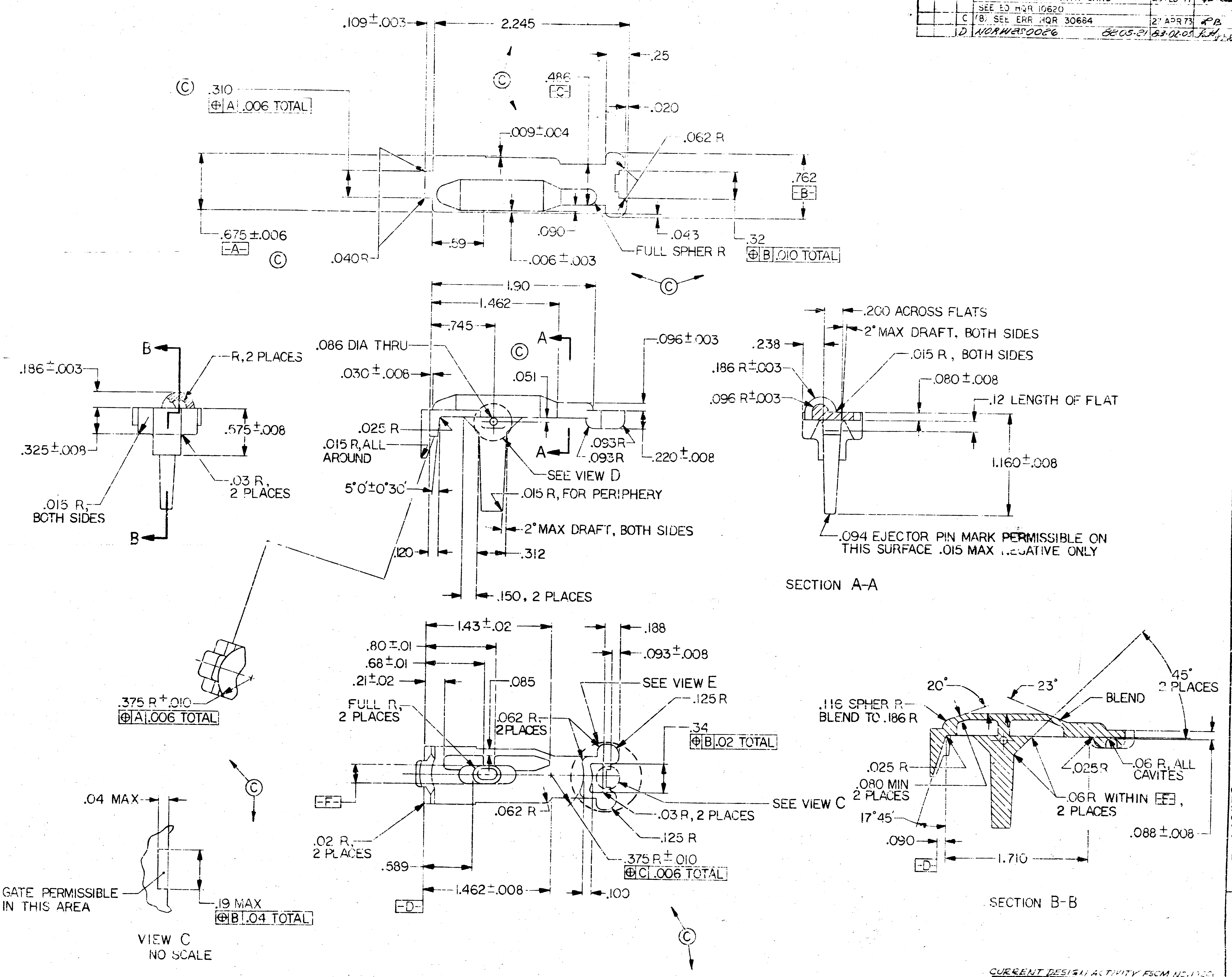
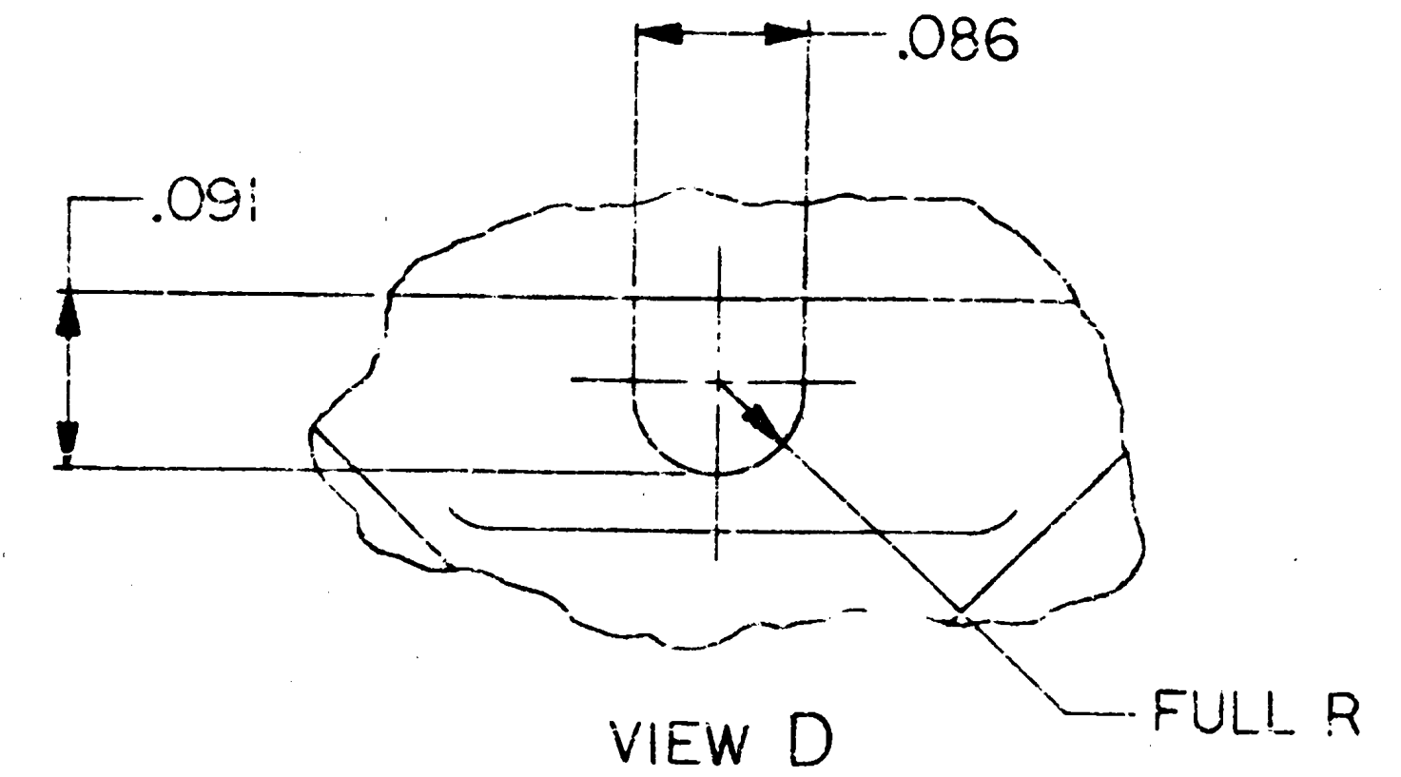
NOTES:

1. NYLON 6/6, TYPE I, GRADE B, CLASS I, PER SPEC L-P-395. COLOR SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595. Ⓒ
2. FINISH $\sqrt{125}$.
3. FILLET AND EDGE RADII SHALL BE .010 R EXCEPT AS NOTED.
4. MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV A WITH CHNG SEE ED HQR 10620	23 FEB 71	
		C	(8) SEE ERR HQR 30684	27 APR 73	LB
		D	NORWES0026 8205-21	83-02-05	

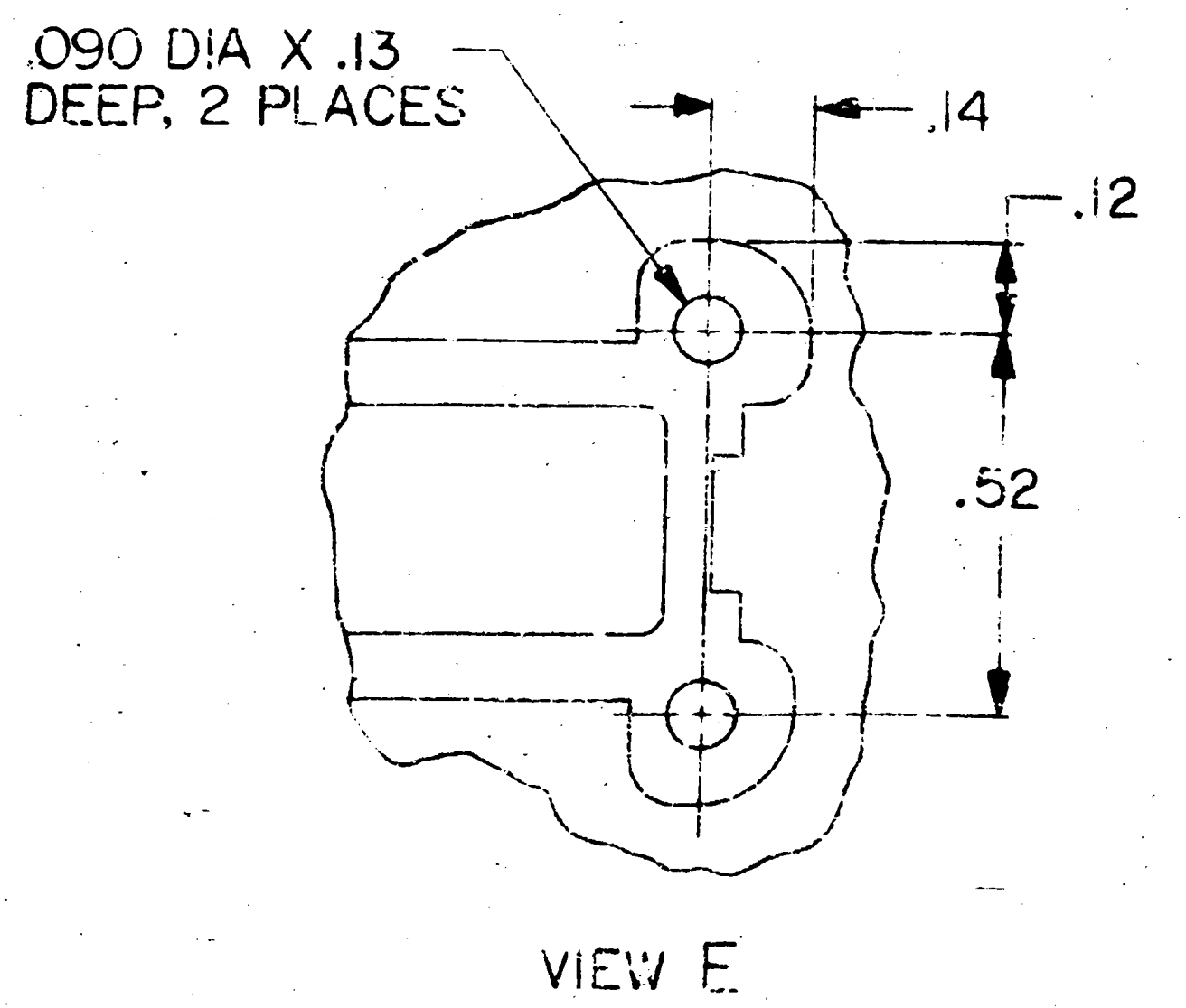


.109±.003
2.245
.25
.486
C
.020
Ⓒ .310
⊕ A .006 TOTAL
.009±.004
.062 R
.762
B
.675±.006
A
.040R
.59
.090
.043
.32
.006±.003
FULL SPHER R
⊕ B .010 TOTAL
Ⓒ
1.90
1.462
.745
.086 DIA THRU
.030±.006
A
.051
.096±.003
.025 R
.015 R, ALL AROUND
.093R
.093R
.220±.008
SEE VIEW D
5°0'±0°30'
.015 R, FOR PERIPHERY
2° MAX DRAFT, BOTH SIDES
.120
.312
.150, 2 PLACES
B
R, 2 PLACES
.186±.003
.575±.008
.325±.008
.03 R, 2 PLACES
.015 R, BOTH SIDES
B
.200 ACROSS FLATS
.238
2° MAX DRAFT, BOTH SIDES
.015 R, BOTH SIDES
.186 R±.003
.080±.008
.096 R±.003
.12 LENGTH OF FLAT
1.160±.008
.094 EJECTOR PIN MARK PERMISSIBLE ON THIS SURFACE .015 MAX NEGATIVE ONLY
SECTION A-A
1.43±.02
.188
.80±.01
.093±.008
.68±.01
.21±.02
.085
SEE VIEW E
.125 R
FULL R, 2 PLACES
.062 R, 2 PLACES
.34
⊕ B .02 TOTAL
.375 R±.010
⊕ A .006 TOTAL
F
.062 R
.03 R, 2 PLACES
SEE VIEW C
.125 R
.02 R, 2 PLACES
.375 R±.010
⊕ C .006 TOTAL
.589
D
1.462±.008
.100
.04 MAX
GATE PERMISSIBLE IN THIS AREA
.19 MAX
⊕ B .04 TOTAL
VIEW C
NO SCALE
20°
23°
45° 2 PLACES
.116 SPHER R-BLEND TO .186 R
BLEND
.025 R
.025R
.06 R, ALL CAVITES
.080 MIN 2 PLACES
.06R WITHIN E, 2 PLACES
17°45'
.090
.088±.008
D
1.710
SECTION B-B



.086
.091
FULL R

VIEW D
ALTERNATIVE DESIGN
SCALE: 10/1



.090 DIA X .13 DEEP, 2 PLACES
.14
.12
.52

VIEW E
ALTERNATIVE DESIGN
SCALE: 4/1

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES ± 1°0' 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01	CONTRACT NO DATE 5 JUN 70	DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201
YS MIN			MATERIAL SEE NOTE 1	PREPARED	FOLLOWER, MAGAZINE
YS MAX				CHECKED	
EL 2				ENGINEER	
RA		30 ROUND		SUBMITTED	
BH	C8448670	MAGAZINE			SIZE F · CODE IDENT NO 19204 · DRAWING NO 8448672
RH	NEXT ASSY	USED WITH	FINAL PROTECTIVE FINISH	APPROVED	SCALE 2/1 · SHEET 1 OF 1
	APPLICATION				

F 8448672

AMSWE Form 403F, 29 Jul 69

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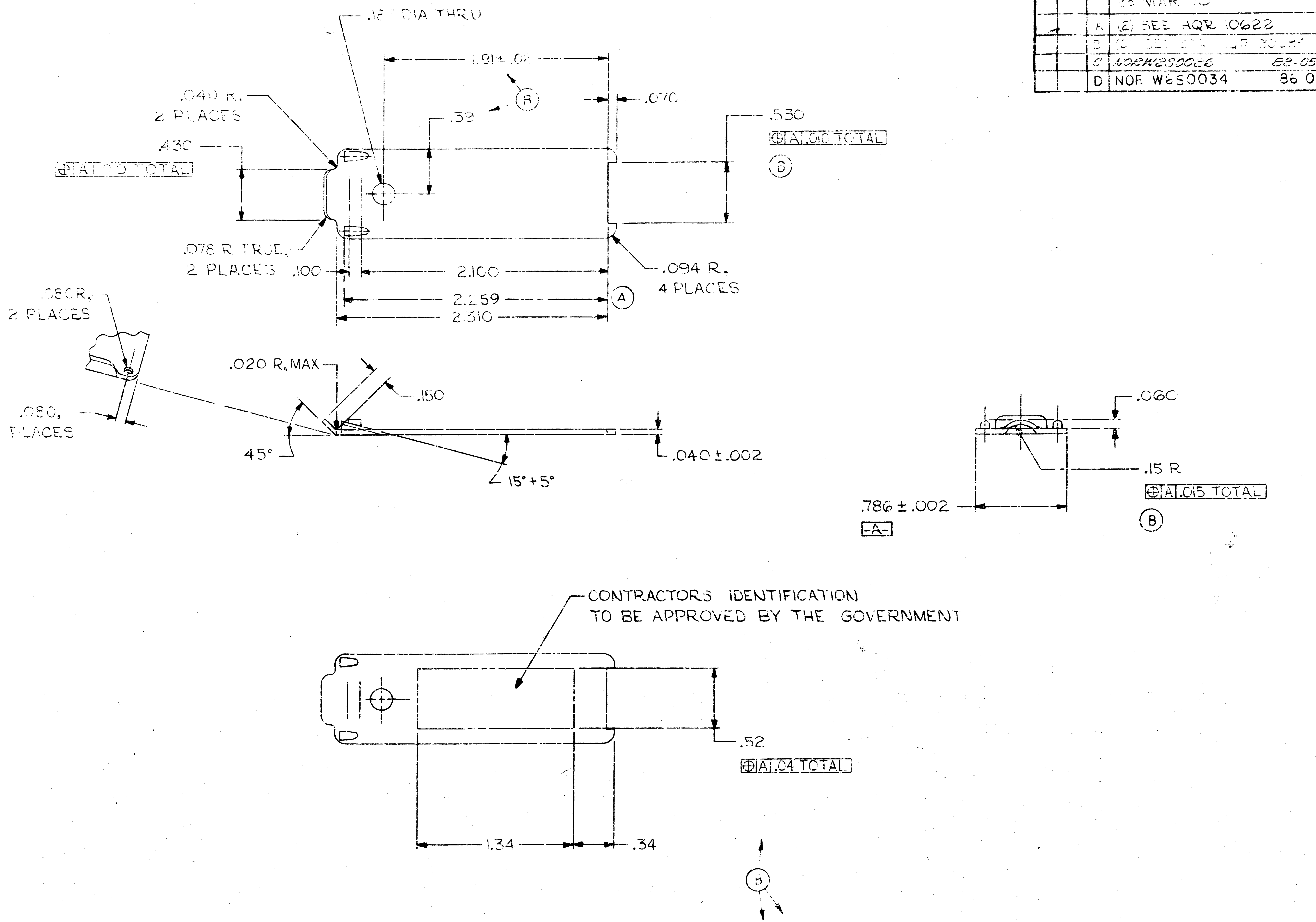
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62668, DATED 23 MAR 70		
		A	(2) SEE AQR 10622	[illegible]	
		B	[illegible]	27 APR 73	
		C	NORW290026 82-05-21	83-02-03	
		D	NOR W6S0034 86 03 25	870204	

NOTES:
1. ALUMINUM ALLOY, 2024, [illegible] QQ-A-250/[illegible]. Ⓑ
2. FINISH 125/.
3. [illegible] .010 ± .005
4. ALL DIMENSIONS APPLY BEFORE FINISH.
5. [illegible] TREAT [illegible] PER [illegible] Ⓑ
6. ETCH [illegible] NON REFLECTIVE MATTE FINISH. [illegible] SHALL BE [illegible], APPROX BLACK, NO. [illegible], TABLE IV BUT NOT LIGHTER THAN [illegible], NO. 36076, TABLE VIII OF FED-STD-595. AND SEAL. Ⓐ
7. MIL-W-13855 APPLIES.


.125 DIA THRU
1.91 ± .02
Ⓑ
.39
.070
.040 R. 2 PLACES
.430
⌖ A .015 TOTAL
.530
⌖ A .010 TOTAL
Ⓑ
.078 R TRUE, 2 PLACES
.100
2.100
2.259
2.310
Ⓐ
.094 R. 4 PLACES
.060 R. 2 PLACES
.020 R. MAX
.150
.080, 2 PLACES
45°
15° ± 5°
.040 ± .002
.060
.15 R
.786 ± .002
-A-
⌖ A .015 TOTAL
Ⓑ
CONTRACTOR'S IDENTIFICATION TO BE APPROVED BY THE GOVERNMENT
.52
⌖ A .04 TOTAL
1.34
.34
Ⓑ

CURRENT DESIGN ACTIVITY FSCM NO.19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
8448670	30 ROUND MAGAZINE

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTE

CONTRACT NO
DATE 5 JUN [illegible]
PREPARED: T. Wilson / T. Fassig
CHECKED: J. Barclay / J. Dunning
ENGINEER: J. Elliott / [illegible]
SUBMITTED: J. McElhose
APPROVED: R. S. Henry

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PLATE, BOTTOM, MAGAZINE

SIZE: D
CODE IDENT NO: 19204
DRAWING NO: 8448673
SCALE
SHEET OF

D 8448673

AMSWE Form 403D, 29 Jul 69

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NOTES: Ⓓ

[illegible]

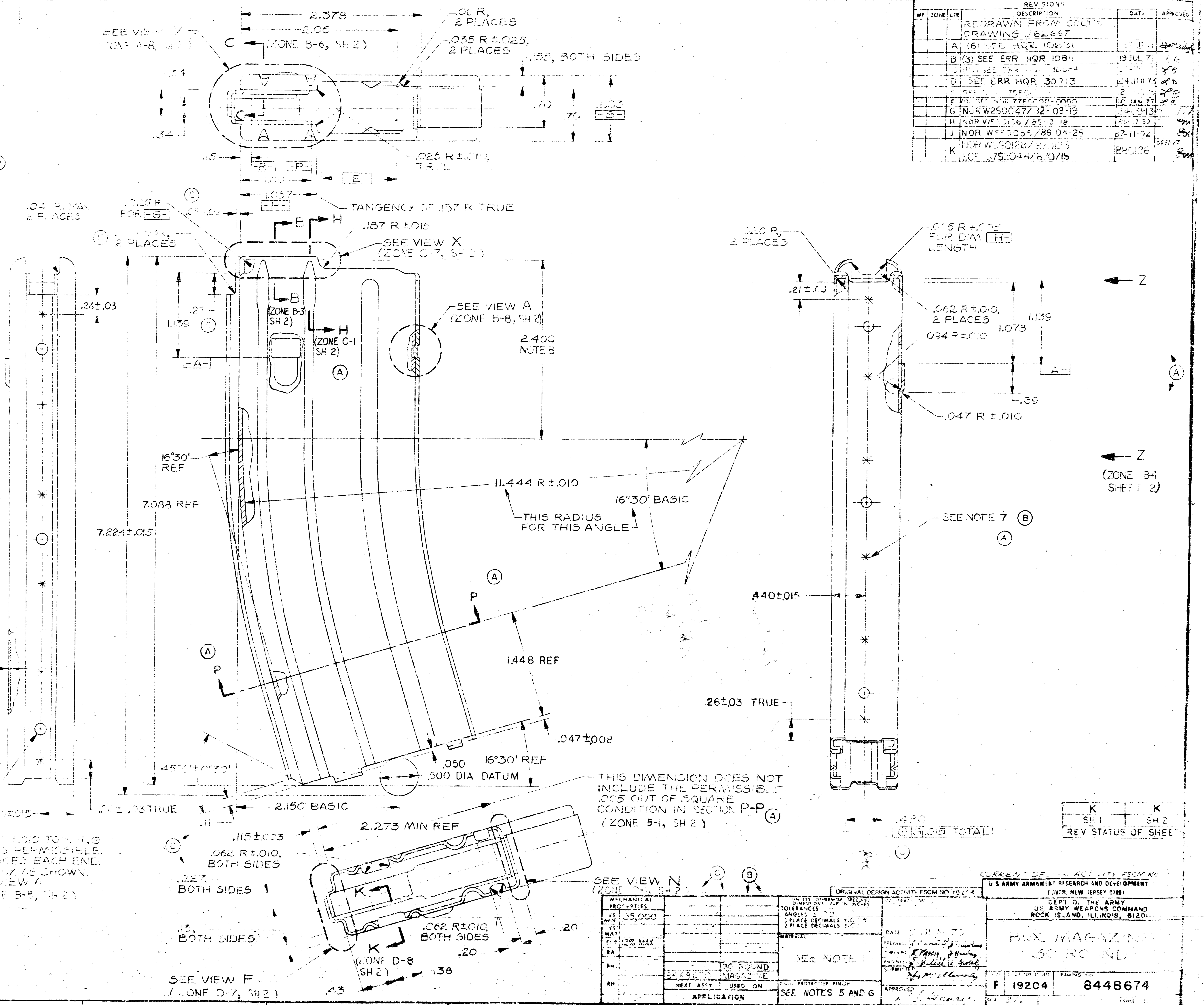
[illegible]

- FIN [illegible]
- ALL DIMENSIONS APPLY BEFORE FINISH.
- HEAT TREAT TO TEMPER T[illegible] PER AMS2770, PARA 3.2.8.5.2 EXCEPT AGING TIME AND TEMPERATURE ARE OPTIONAL. SEE NOTE 6. QUENCHANT TEMPERATURE SHALL START AT 115°F OR LESS AND RISE TO A 135°F MAXIMUM. MINIMUM BRINELL 80 (10MM BALL 500 KG LOAD) OR EQUIVALENT (BARCOL 76 MINIMUM). Ⓒ
- MIL-A-8625, TYPE [illegible], CLASS [illegible], FILM THICKNESS [illegible]
- [illegible] LUBRICANT [illegible] MIL-L-[illegible] OR MIL-L-46010, FILM THICKNESS .0002 TO .0004. CAUTION: THE [illegible] CURING OF MIL-L-46010 SHALL BE CONCURRENT WITH THE [illegible] TEMPER [illegible] PROVIDED THE CONTRACTOR HAS BEEN [illegible] PRIOR TO APPLICATION OF LUBRICANT. Ⓑ Ⓐ Ⓔ

7.- SPOT WELD TWELVE SPACES, PER MIL-W-45210, SIX WELDS, EQUALLY SPACED TO ±.03, BOTH ENDS EXCEPT WELD BUTTON DIAMETER SHALL BE .10 MIN. EACH WELD SHALL SUPPORT A STATIC COMPRESSIVE LOAD OF 100LBS APPLIED WITHIN LENGTH -L- OPPOSITE EACH WELD IN THE DIRECTION OF -M- Ⓒ

8.- FLATNESS REQUIRED BY .883 DIMENSION APPLIES THIS LENGTH ONLY.

9.- MIL-W-13855 APPLIES.



SEE VIEW Y (ZONE A-8, SH 2)
C (ZONE B-6, SH 2)
2.378
2.06
.06 R, 2 PLACES
.035 R ±.025, 2 PLACES
.155, BOTH SIDES
.025 R ±.010, TRUE
TANGENCY OF .187 R TRUE
.04 R MAX 2 PLACES
.025 R FOR -G-
.187 R ±.015
SEE VIEW X (ZONE C-7, SH 2)
B (ZONE B-3 SH 2)
H (ZONE C-1 SH 2)
SEE VIEW A (ZONE B-8, SH 2)
2.400 NOTE 8
1.139
.27
.26±.03
16°30' REF
11.444 R ±.010
16°30' BASIC
THIS RADIUS FOR THIS ANGLE
7.083 REF
7.224±.015
P
1.448 REF
.047±.002
.050
16°30' REF
.500 DIA DATUM
.44±.015
.26±.03 TRUE
2.150 BASIC
2.273 MIN REF
.115±.003
.062 R±.010, BOTH SIDES
.227, BOTH SIDES
.13, BOTH SIDES
.062 R±.010 BOTH SIDES
.20
.38
.43
K (ZONE D-8 SH 2)
SEE VIEW F (ZONE D-7, SH 2)
SEE VIEW N (ZONE D-1, SH 2)
THIS DIMENSION DOES NOT INCLUDE THE PERMISSIBLE .005 OUT OF SQUARE CONDITION IN SECTION P-P (ZONE B-1, SH 2)
.020 R, 2 PLACES
.015 R ±.005 FOR DIM -H- LENGTH
.21±.03
.062 R ±.010, 2 PLACES
.094 R ±.010
1.073
1.139
.39
.047 R ±.010
Z
(ZONE B4 SHEET 2)
SEE NOTE 7
.440±.015
.26±.03 TRUE
.490
.015 TOTAL
-A-

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING J62667		
		A	(6) SEE HQR 10681	[illegible]	
		B	(3) SEE ERR HQR 10811	19 JUL 71	
		C	(10) SEE ERR HQR 30094	[illegible]	
		D	SEE ERR HQR 30713	24 JUL 73	
		E	SEE [illegible] 75E0[illegible]	12 [illegible]	
		F	(6) SEE NOR 77E0000-0000	10 JAN 77	
		G	NOR W2S0047/82-08-19	84-09-13	
		H	NOR W2S0136/85-2-18	86-07-30	
		J	NOR W2S0055/86-04-25	87-11-02	
		K	NOR W2S0128/870123 ECP 752044/870715	880126	OFF 1-12

K	K
SH 1	SH 2

REV STATUS OF SHEETS

MECHANICAL PROPERTIES	
YS MIN	35,000
YS MAX	
EL 2	12% MAX
RA	
RH	
RH	

NEXT ASSY	USED ON
8448670	30 ROUND MAGAZINE

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1°00'
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH
SEE NOTES 5 AND 6

ORIGINAL DESIGN ACTIVITY FSCM NO 19204

CURRENT DESIGN ACTIVITY FSCM NO

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT
DOVER, NEW JERSEY 07801

CONTRACT NO

DATE [illegible] JUN 70
PREPARED
CHECKED K. Parsis J. Burley
ENGINEER
SUBMITTED
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BOX, MAGAZINE 30 ROUND

SIZE F | CODE IDENT NO 19204 | DRAWING NO 8448674

SCALE 2/1 | SHEET

DA Form 4034, 29 Jul 69

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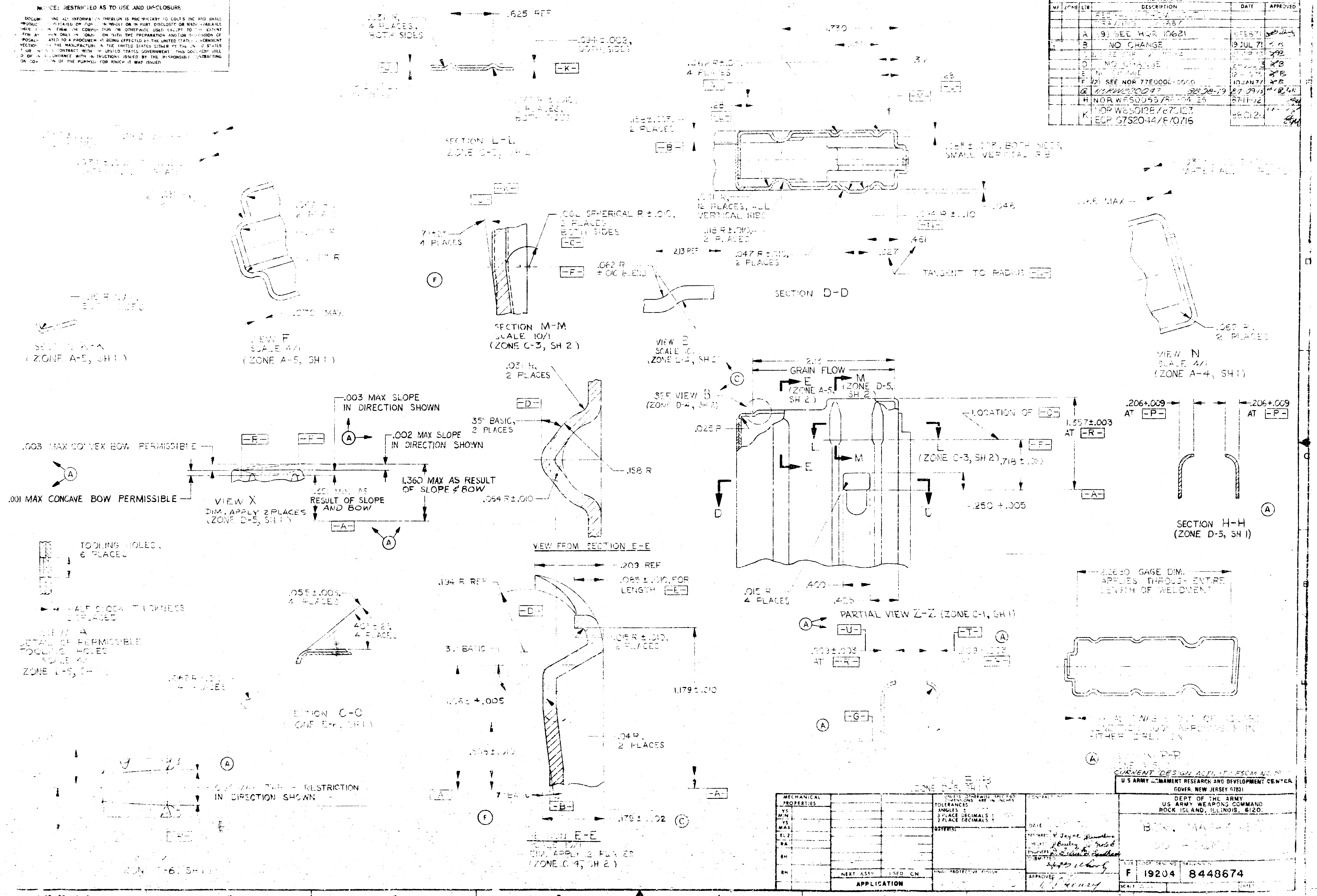
REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			[illegible]		
			DRAWING [illegible]667		
		A	(9) SEE HQR 10621	[illegible]FEB71	[illegible]
		B	NO CHANGE	19 JUL 71	[illegible]
		C	[illegible]	[illegible]	[illegible]
		D	NO CHANGE	[illegible]	[illegible]
		E	NO CHANGE	12 [illegible] 75	[illegible]
		F	(2) SEE NOR 77E0000-0000	10 JAN 77	[illegible]
		G	NOR W80047 [illegible] 98-19	87-09-[illegible]	[illegible]
		H	NOR W8S0055/8[illegible]-04-25	87-11-02	[illegible]
		K	NOR W8S0128/870123 ECP G7S2044/870716	880124	[illegible]


.625 REF
.094±.002, BOTH SIDES
SECTION L-L
.062 SPHERICAL R ±.010, 2 PLACES BOTH SIDES
.062 R ±.010 BLEND
SECTION M-M SCALE 10/1 (ZONE C-3, SH 2)
VIEW F SCALE 4/1 (ZONE A-5, SH 1)
.730
SECTION D-D
TANGENT TO RADIUS
.047 R ±.010, 2 PLACES
.060 R, 2 PLACES
VIEW N SCALE 4/1 (ZONE A-4, SH 1)
.206+.009 AT -P-
SECTION H-H (ZONE D-5, SH 1)
1.357±.003 AT -R-
GRAIN FLOW
SEE VIEW B (ZONE D-4, SH 2)
LOCATION OF
(ZONE C-3, SH 2)
.718 ±.010
.250 ±.005
.015 R 4 PLACES
PARTIAL VIEW Z-Z (ZONE C-1, SH 1)
.003 MAX SLOPE IN DIRECTION SHOWN
.002 MAX SLOPE IN DIRECTION SHOWN
.003 MAX CONVEX BOW PERMISSIBLE
.001 MAX CONCAVE BOW PERMISSIBLE
1.360 MAX AS RESULT OF SLOPE & BOW
VIEW X DIM. APPLY 2 PLACES (ZONE D-5, SH 1)
RESULT OF SLOPE AND BOW
35° BASIC, 2 PLACES
.158 R
.064 R ±.010
VIEW FROM SECTION E-E
.203 REF
.194 R REF
.065 ±.010, FOR LENGTH
.015 R ±.010, 4 PLACES
1.179 ±.010
.04 R, 2 PLACES
.178 ±.002
SECTION E-E
DIM. APPLY 2 PLACES (ZONE C-4, SH 2)
TOOLING HOLES, 6 PLACES
HALF STOCK THICKNESS
DETAIL OF PERMISSIBLE TOOLING HOLES
.055 ±.005, 4 PLACES
SECTION C-C (ZONE E-6, SH 1)
RESTRICTION IN DIRECTION SHOWN
2.2830 GAGE DIM. APPLIES THROUGH ENTIRE LENGTH OF WELDMENT
EITHER DIRECTION
SECTION P-P
(ZONE D-5, SH 1)
-A-
-B-
-D-
-E-
-F-
-G-
-K-
-P-
-R-
-T-
-U-
(A)
(C)
(F)
8
7
6
5
4
3
2

CURRENT DESIGN ACTIVITY FSCM NO. [illegible]

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES ± 3 PLACE DECIMALS ± 2 PLACE DECIMALS ±	CONTRACT NO.
YS MIN			MATERIAL	DATE
YS MAX				PREPARED Y. Jayne
EL 2				CHECKED J. Baxley
RA				ENGINEER
BH				SUBMITTED
RH	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED
	APPLICATION			

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 6120[illegible]

BOX, MAGAZINE
[illegible]

SIZE	CODE IDENT NO.	DRAWING NO.
F	19204	8448674

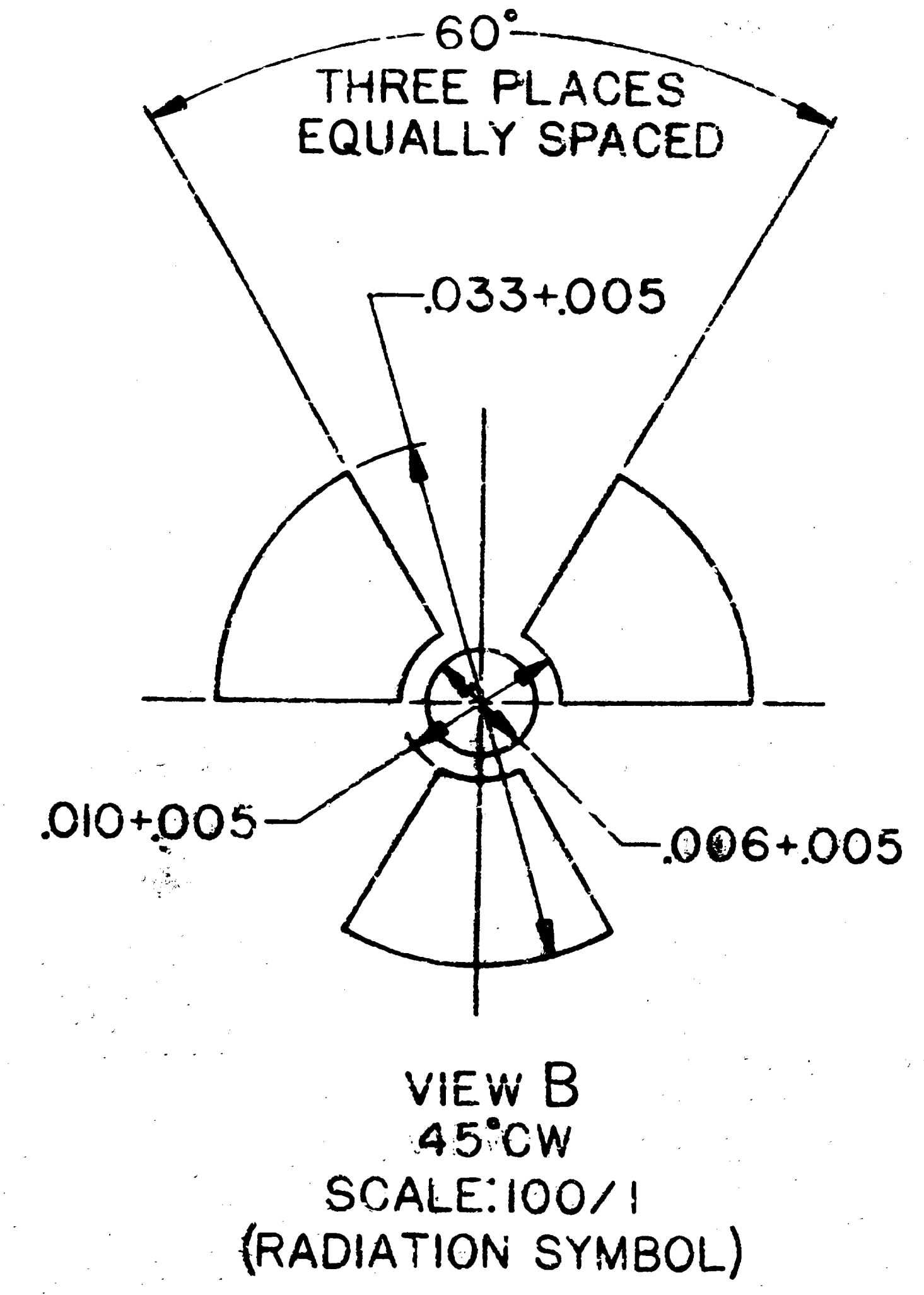
SCALE [illegible] SHEET [illegible]

[illegible] 4 3F 29 Jul 69

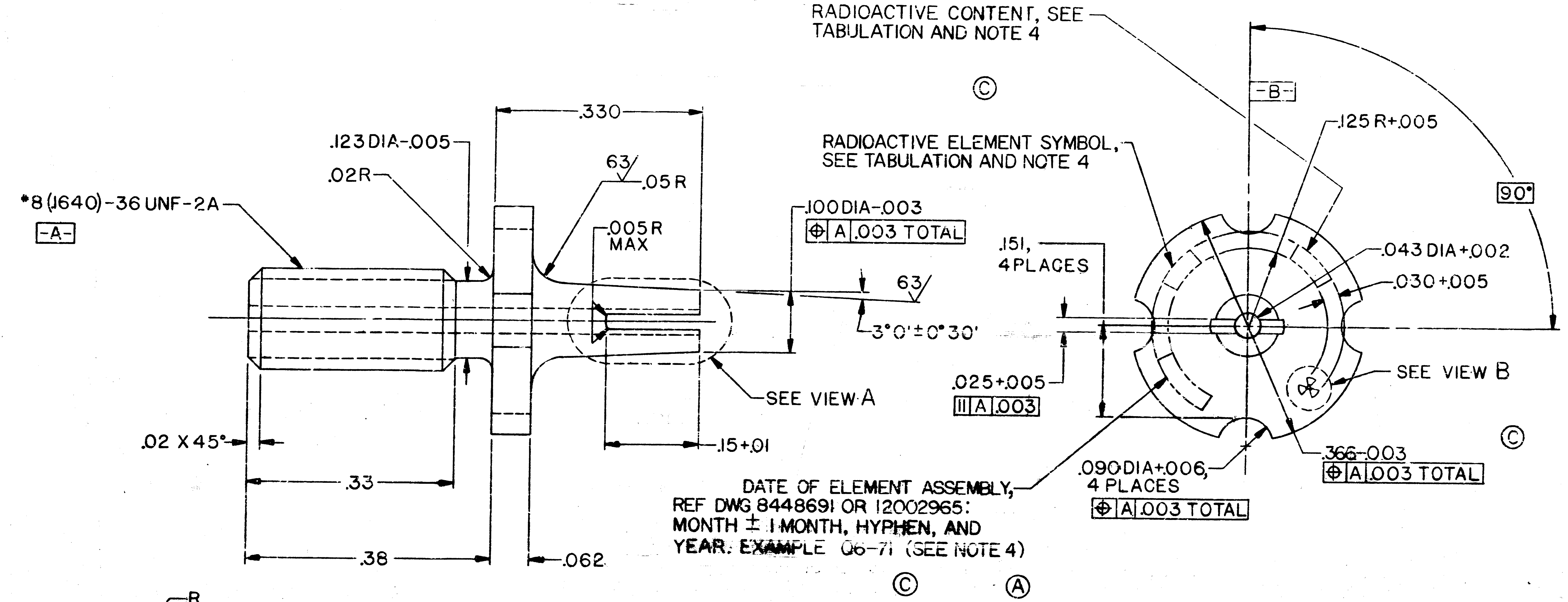
NF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	(1) SEE ERR HQR 10911	22 DEC 71	YB
		B	SEE ERR HQR 20839	25 JAN 73	YB
		C	(5) SEE ERR HQR 30689	5 MAY 73	YB
		D	NOR W3S 2064 / 83-10-28	84-02-21	[illegible]
		E	NOR W9S2029 80 05 30	850823	YB

NOTES:

1. FINISH $\overset{125}{\surd}$ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. STEEL, CARBON, COND CD, CMPSN 1137, SPEC ASTM-A108.
4. SYMBOL, LETTERS, AND NUMBERS TO BE .005+.005 DEEP.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.

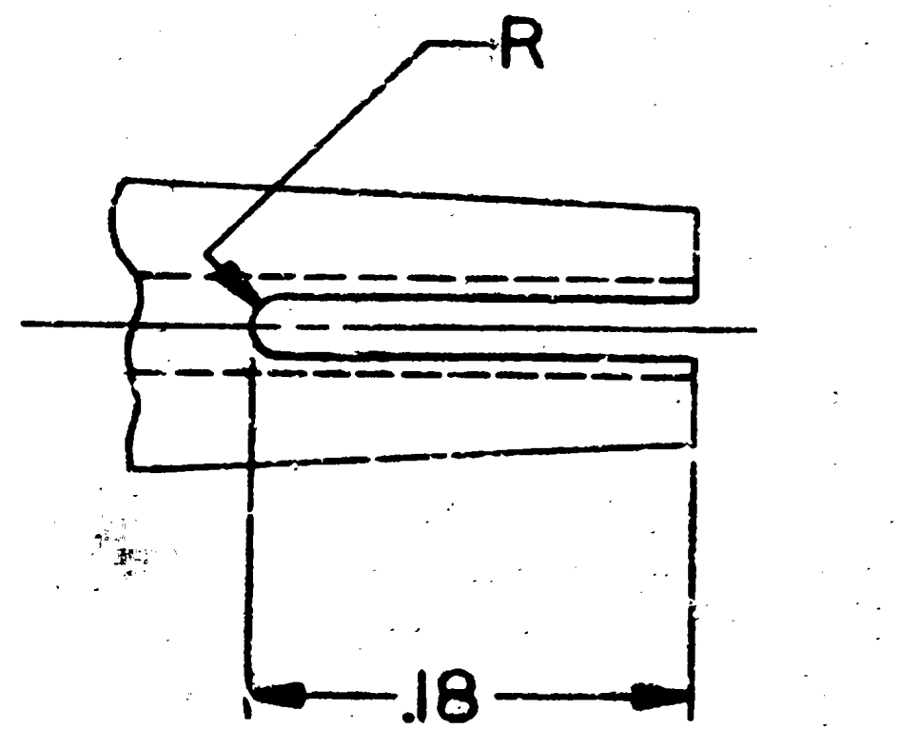

60°
THREE PLACES
EQUALLY SPACED
.033+.005
.010+.005
.006+.005

VIEW B
45°CW
SCALE: 100/1
(RADIATION SYMBOL)


.330
.123 DIA-.005
.02R
63/
.05R
*8 (.1640)-36 UNF-2A
-A-
.005R MAX
.100 DIA-.003
⊕ A .003 TOTAL
63/
3°0'±0°30'
SEE VIEW A
.15+.01
.02 X 45°
.33
.38
.062
RADIOACTIVE CONTENT, SEE TABULATION AND NOTE 4
Ⓒ
-B-
.125 R+.005
90°
RADIOACTIVE ELEMENT SYMBOL, SEE TABULATION AND NOTE 4
.151, 4 PLACES
.043 DIA+.002
.030+.005
.025+.005
∥ A .003
SEE VIEW B
Ⓒ
.366-.003
⊕ A .003 TOTAL
.090 DIA+.006, 4 PLACES
⊕ A .003 TOTAL
DATE OF ELEMENT ASSEMBLY, REF DWG 8448691 OR 12002965: MONTH ± 1 MONTH, HYPHEN, AND YEAR. EXAMPLE 06-71 (SEE NOTE 4)

Ⓒ Ⓐ

PART NO.	NEXT ASSY	RADIOACTIVE ELEMENT SYMBOL	RADIOACTIVE CONTENT
8448689-2	C12002965	H-3	9 MC



VIEW A
(ALTERNATIVE DESIGN)

Ⓑ Ⓒ

CURRENT DESIGN ACTIVITY FSCM NO.19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. SEE TABULATION

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

NEXT ASSY	USED ON
SEE TABULATION	LOW LIGHT LEVEL SIGHT KIT

APPLICATION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± 2°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL SEE NOTE 3

FINAL PROTECTIVE FINISH SEE NOTE 5

CONTRACT NO

DATE 25 JUN 71

PREPARED T.A. Wilson W.K. Spedhan
CHECKED D.J. Billiet S. Fritzinger
ENGINEER L. Brunton R. Ellis
SUBMITTED J. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

POST

SIZE D
CODE IDENT NO. 19204
DRAWING NO. 8448689
SCALE 10/1
SHEET 1 OF 1

AMSWE Form 403D, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	NOR W9S2009 80-02-13	80-05-16	
		B	NOR WIS0003/81-03-27	83-09-14	

NOTES:-
1. MIL-W-13855 APPLIES.

SAME AS MS16535-125 EXCEPT
FINAL PROTECTIVE FINISH TO BE
5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

CURRENT
FSCM NO.
19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

ALTERED ITEM DRAWING
PART NO. 8448697

MECHANICAL PROPERTIES		NEXT ASSY	USED ON
YS MIN		8448300	M203
YS MAX		C8448565	M16
EL 2			M16A1
RA		D8448663	M16
BH			M16A1
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —
MATERIAL
—
FINAL PROTECTIVE FINISH
SEE NOTE

CONTRACT NO.
DATE 11 APR 72
PREP
CHK
ENGR
SUBMITTED Loren F. Brunton
APPROVED

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

RIVET

SIZE	CODE IDENT NO	DRAWING NO.
B	19204	8448697
SCALE NONE		SHEET 1 OF 1

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

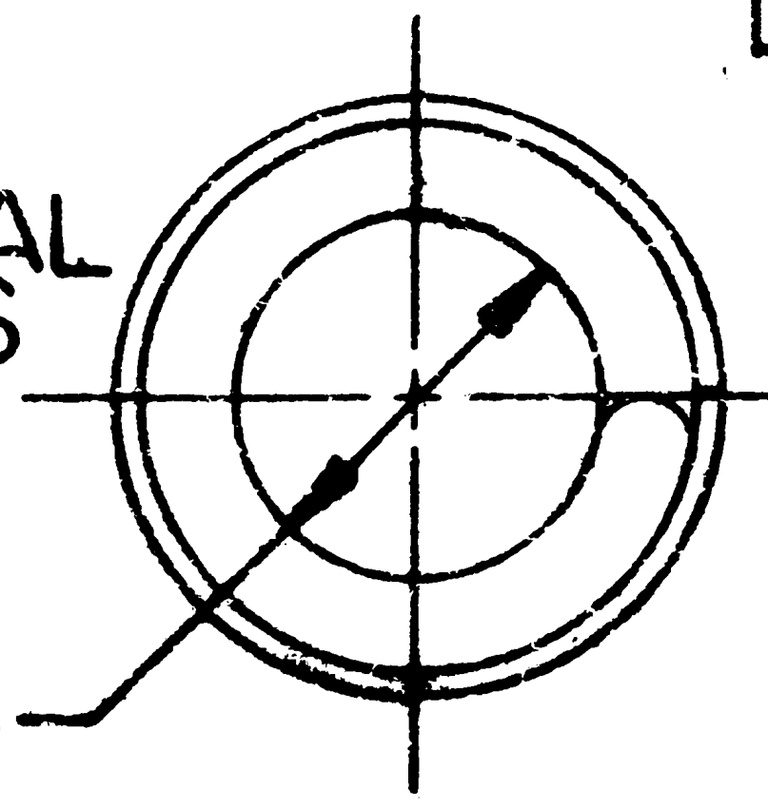
E	NOR G8S2005/880310	880927

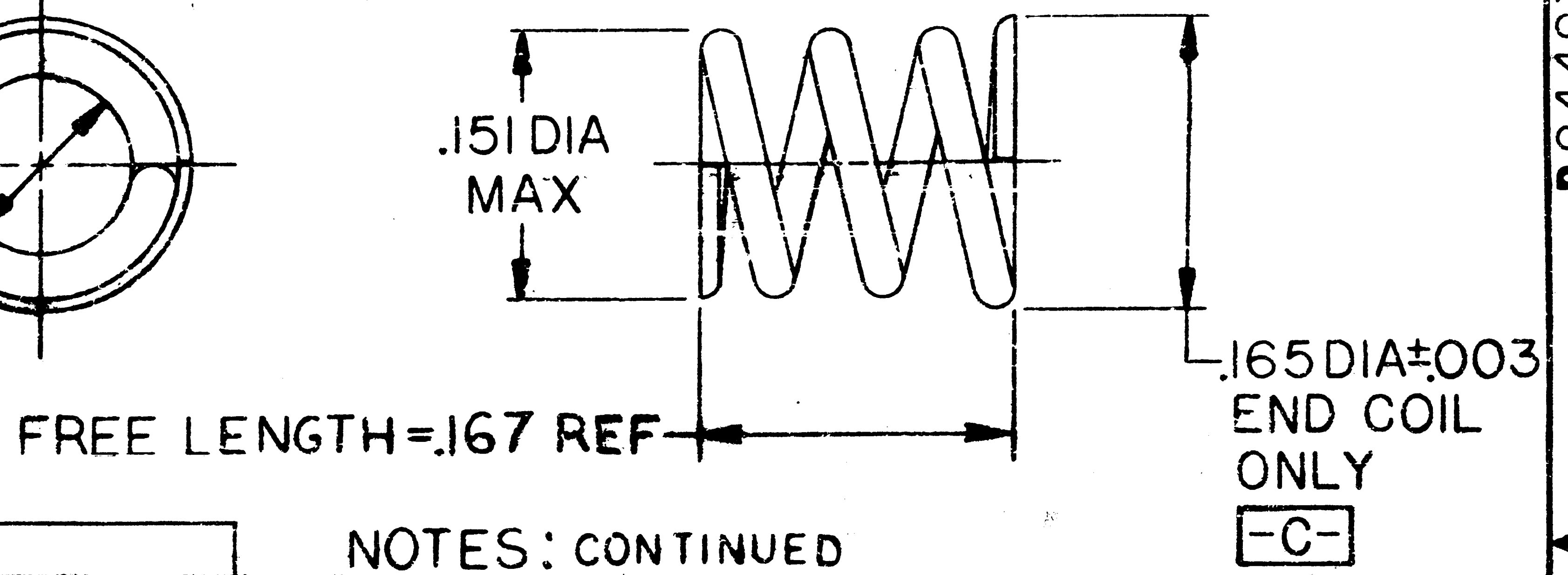
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	SEE ERR HQR 20778	6 OCT 72	
		B	NOR W9S2009 80-02-13	80-05-16	
		C	NOR W2S0011 /82-04-13 (ECP W3S3120 /83-07-07	83-11-04	
		D	NOR W6S3014/86-03-25 ECP W6S0106/86-10-09	87-02-17	

B8448753

NOTES:

1. WIRE, STEEL, MUSIC SPRING QUALITY PER ASTM-A228 TABLE I .022 SIZE EXCEPT TENSILE STRENGTH TO BE 363,000 TO 393,000 PSI.
2. STRESS RELIEVE-HOLD AT 450°F±25°F FOR 30 MIN.
3. SUGGESTED SOURCE OF SUPPLY: NATIONAL STANDARD, NILES, MICHIGAN 49120; MAPES PIANO STRING CO., ELIZABETHAN, TENN. 37644; JOHNSON WIRE & STEEL, WORCESTER, MASS.
4. MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572.
5. MIL-W-13855 APPLIES Ⓐ
6. BREAK SHARP EDGES .003+.012





SPRING DATA	
WIRE DIA	.0220
TOTAL COILS	4 REF
DIRECTION OF HELIX	OPTIONAL
* LOAD AT COMPRESSED LENGTH OF	.140 IN=2.0 LB±0.2 LB
* LOAD AT COMPRESSED LENGTH OF	.112 IN=4.2 LB±0.4 LB
ONE END EXPANDED TO DIM.	-C-
TYPE OF ENDS	CLOSED AND GROUND
SOLID LENGTH	.090 MAX

NOTES: CONTINUED

*7. PRESET-COMPRESS TO SOLID HEIGHT 3 TIMES PRIOR TO CHECKING LOADS.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448753

MECHANICAL PROPERTIES			
YS MIN			
YS MAX		B11828591	M231
EL 2		B8448755	M16
RA			M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE I

FINAL PROTECTIVE FINISH
—

CONTRACT NO.
DATE 4 NOV 71
PREP T.M. Wilson D. Krolek
CHK S. Fruitiger G. Druwellen
ENGR R. Ellbe L. Brunton
SUBMITTED A. A. Cole
APPROVED R. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, EXTRACTOR

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448753

SCALE 10/1 SHEET 1 OF 1

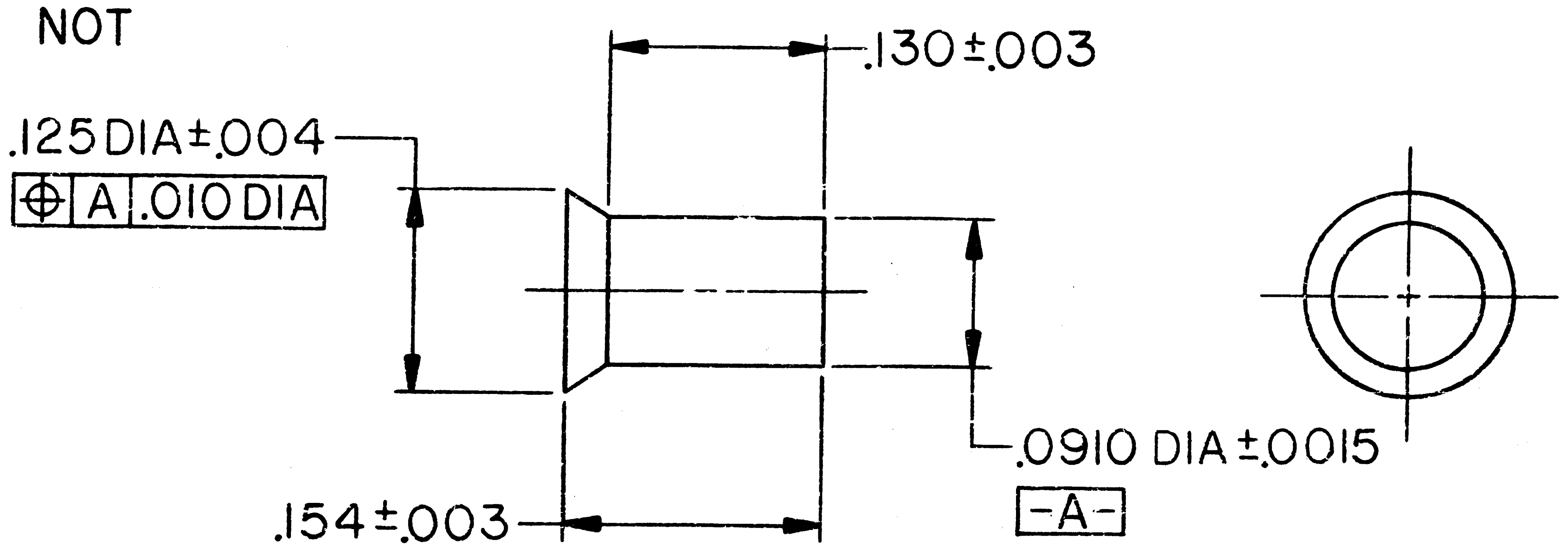
AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M-		A	SEE ERR HQR 30664	15 MAR 73	RE
		B	NORW2S0026 82-05-21	83-02-03	

NOTES:

1. RUBBER, FLUOROSILICONE, TYPE II, CLASS I, GRADE 60, SPEC MIL-R-25988 EXCEPT: TABLE II, AGING IN STAUFFER BLEND 7700 FLUID, COMPRESSION SET REQUIREMENTS SHALL NOT APPLY. Ⓐ
2. ALL EXTERIOR AND INTERIOR EDGES TO BE .005 R MAX.
3. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY
FSCM NO: 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448754

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		B8448755	M16
RA			M16A1
BH		NEXT ASSY	USED ON
RH		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL
SEE NOTE I

FINAL PROTECTIVE FINISH

CONTRACT NO:
DATE 4 NOV 71
PREP T. Watson D. Kolak
CHK S. Fruteger G. Dresselhaus
ENGR R. Elbe L. Brunton
SUBMITTED A. A. Cole
APPROVED L. S. Henry

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

INSERT, SPRING

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448754
SCALE 10/1
SHEET 1 OF 1

B8448754

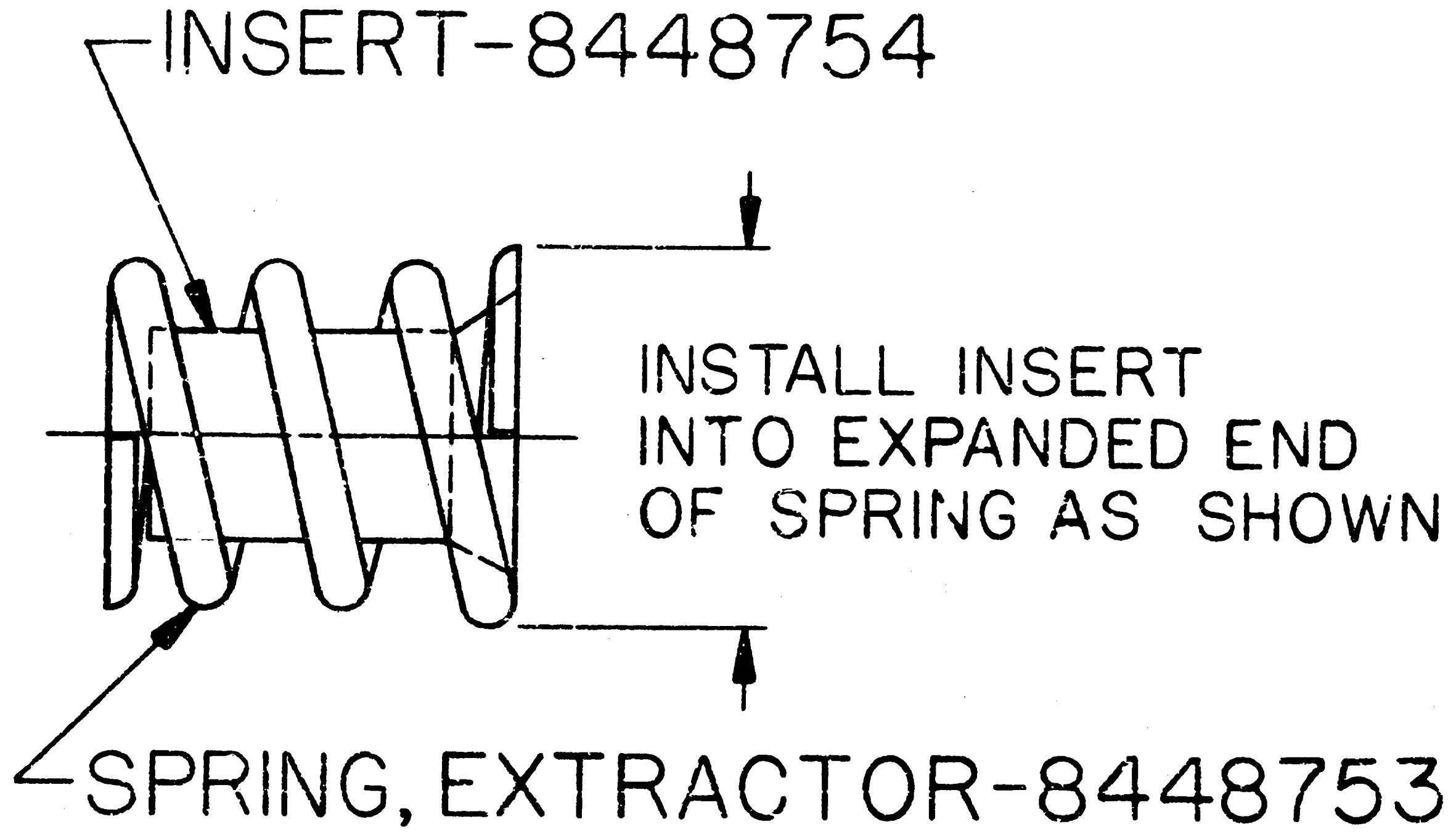
AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	NORN2S0026 82-05-21	83-02-03	

NOTE:
MIL-W-13855 APPLIES.

B8448755



INSTALL INSERT
INTO EXPANDED END
OF SPRING AS SHOWN

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL 8448755

PART NO. 8448755

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		C8448509	M16
RA			
BH			M16A1
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —
MATERIAL —
FINAL PROTECTIVE FINISH —

CONTRACT NO.
DATE 4 NOV 71
PREP T.R. Wilson D. Krolak
CHK S. Fritizin J. Dresselhaus
ENGR R. Elbe L. Brunton
SUBMITTED R. A. Cole
APPROVED R. S. Heney

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING ASSY,
EXTRACTOR

SIZE B
CODE IDENT NO. 19204
DRAWING NO. 8448755
SCALE 10/1
SHEET 1 OF 1

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

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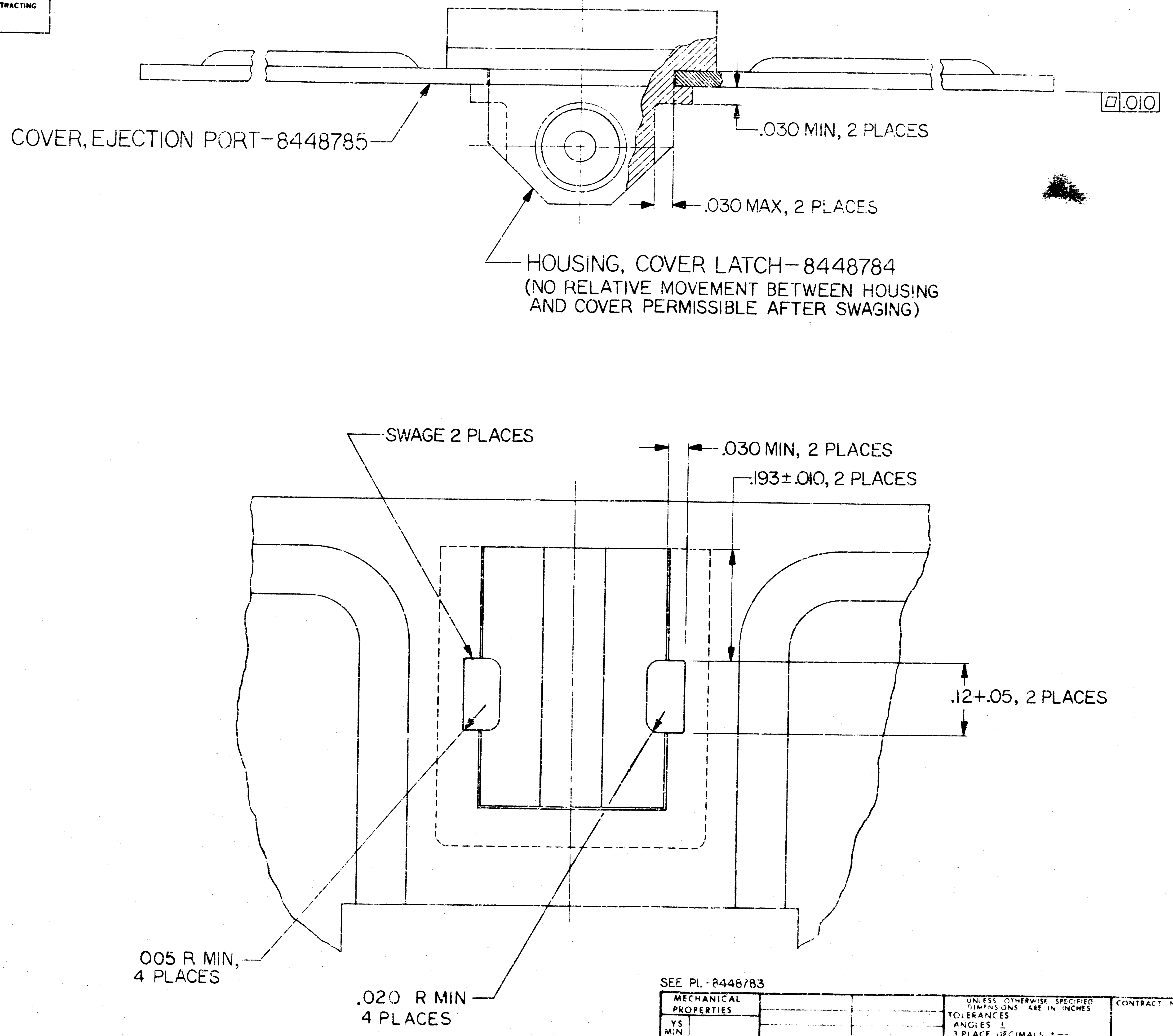
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	NOR W9S2009 80-02-13	80-05-16	
		B	NOR W3S 3123/83-07-07	83-08-16	

NOTES:

1. GRIT BLAST AFTER ASSEMBLY AND PRIOR TO FINISH TO PRODUCE NON-REFLECTIVE MATTE FINISH.
2. MIL-W-13855 APPLIES.



▱ .010
COVER, EJECTION PORT-8448785
.030 MIN, 2 PLACES
.030 MAX, 2 PLACES
HOUSING, COVER LATCH-8448784
(NO RELATIVE MOVEMENT BETWEEN HOUSING AND COVER PERMISSIBLE AFTER SWAGING)
SWAGE 2 PLACES
.030 MIN, 2 PLACES
.193±.010, 2 PLACES
.12+.05, 2 PLACES
005 R MIN, 4 PLACES
.020 R MIN 4 PLACES

D8448783

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT
PART NO. 8448783
CODE IDENT NO 19200

~~DEPT OF THE ARMY~~
~~US ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS 61201~~

SEE PL-8448783

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH		D8448525	M 231
RH		D8448525	M16/M16A1
		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±
3 PLACE DECIMALS ±—
2 PLACE DECIMALS ±—

MATERIAL
—

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

CONTRACT NO

DATE 15 SEPT 72
PREPARED E. Parry / P. Vernon
CHECKED / L. Korak
ENGINEER F. Buntin / R. Elbe
SUBMITTED Loren F. Buntin
APPROVED R. S. Henry

EJECTION PORT COVER AND LATCH HOUSING ASSY

SIZE D
CODE IDENT NO ~~19204~~
DRAWING NO 8448783
SCALE 10/1
SHEET 1 OF 1

EDITION OF 29 JUL 69 MAY BE USED

E Form 403D, 13 Nov 70

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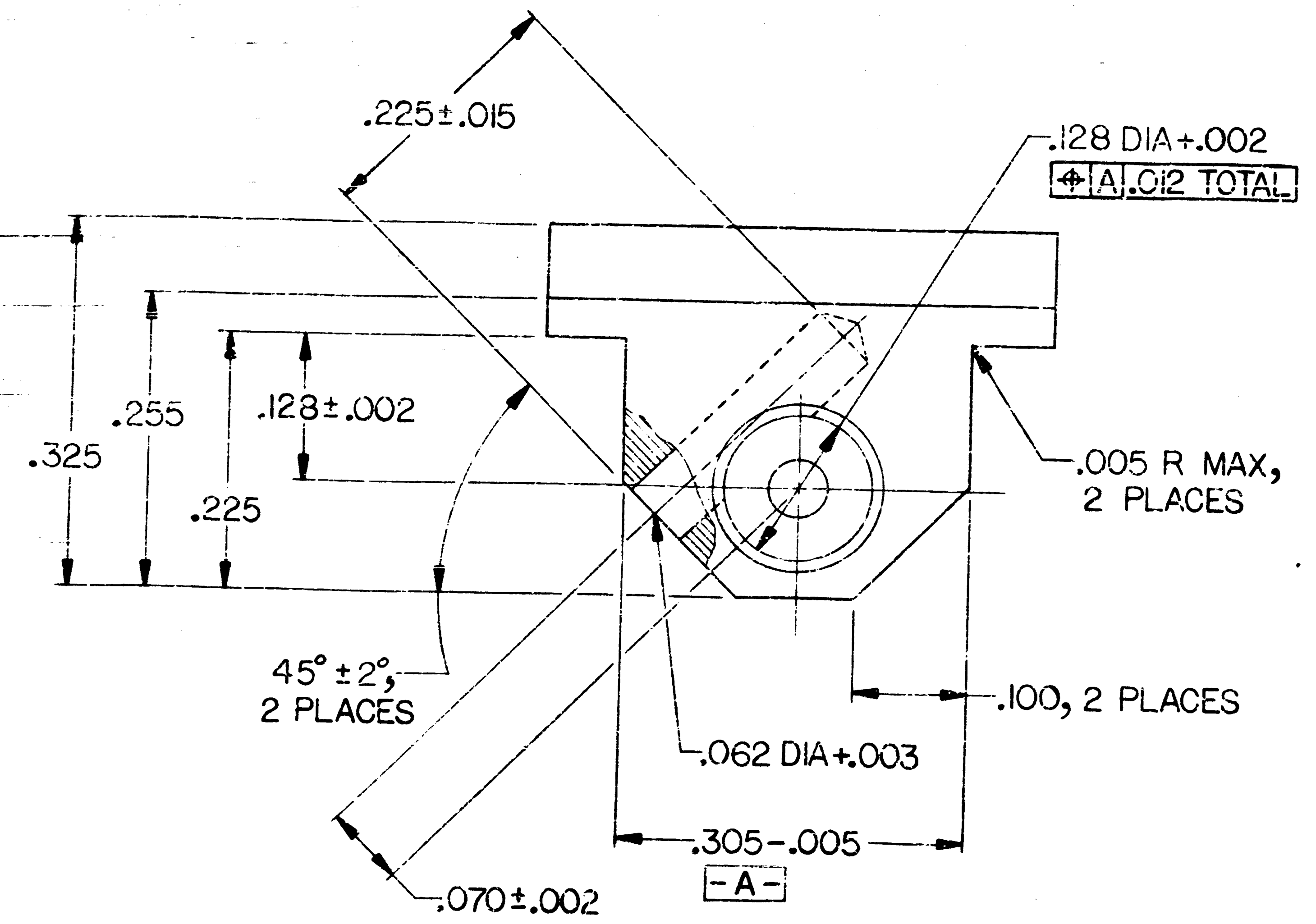
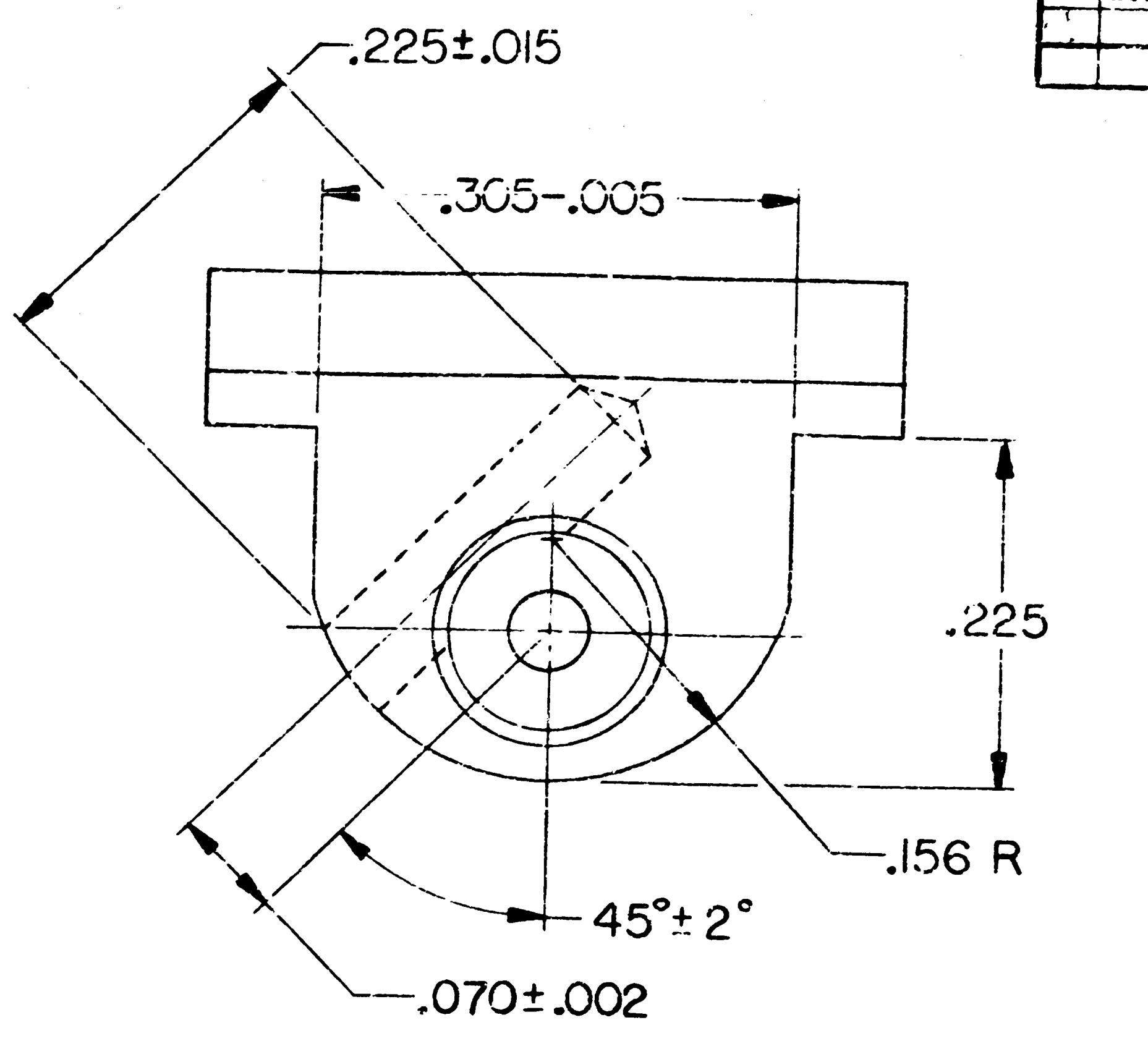
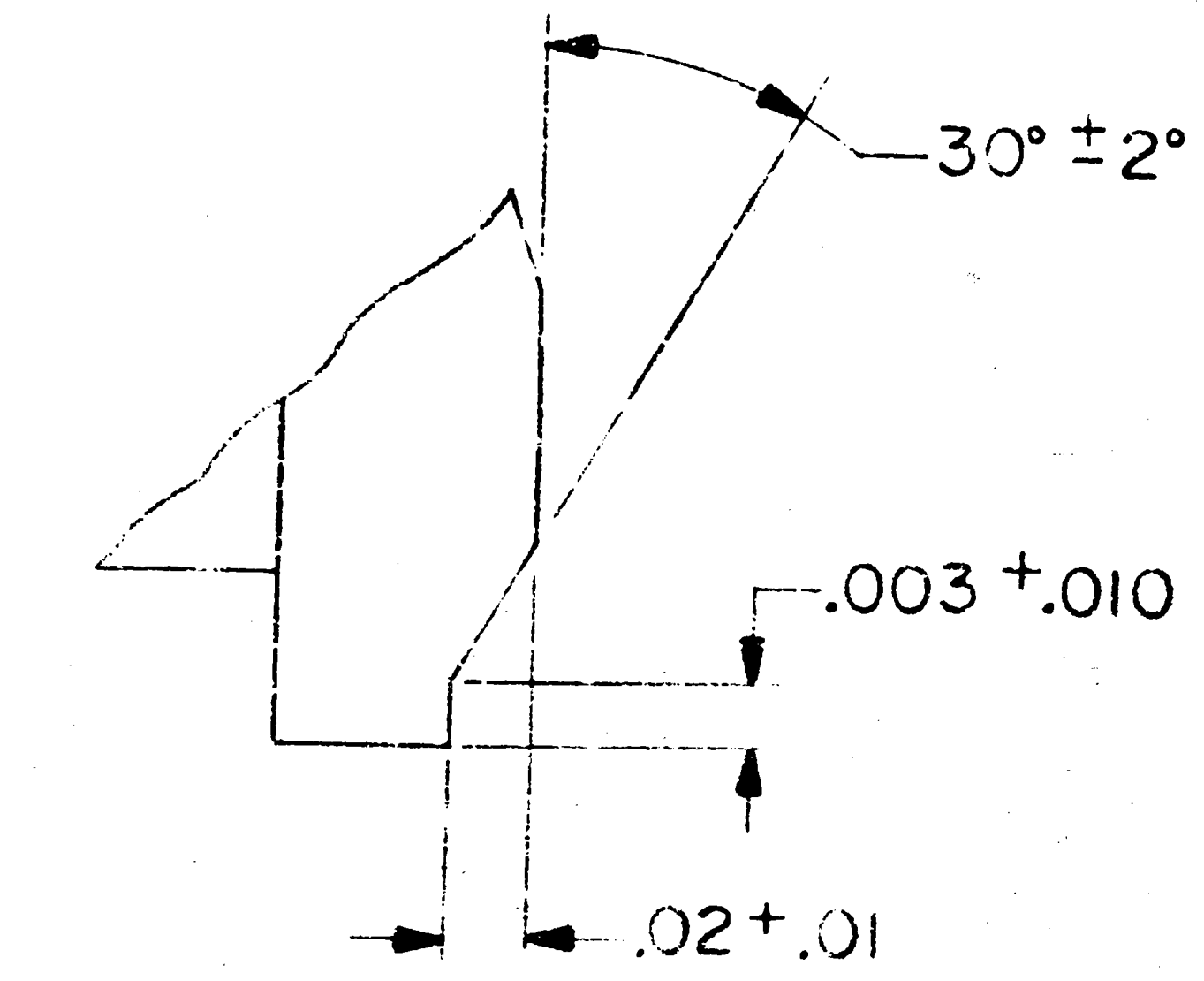
NOTES:

1. STEEL, CMPSN 1018 TO 1022, SPEC ASTM A108; OR SINTERED STEEL, GRADE I, CLASS A, DENSITY TYPE II PER ASTM B484-70. SINTERED MATL SHALL BE SEALED WITH POLYESTER RESIN. Ⓐ
2. FINISH $\sqrt{125}$.
3. BREAK ALL SHARP EDGES .005+.010 EXCEPT AS NOTED.
4. MIL-W-13855 APPLIES.

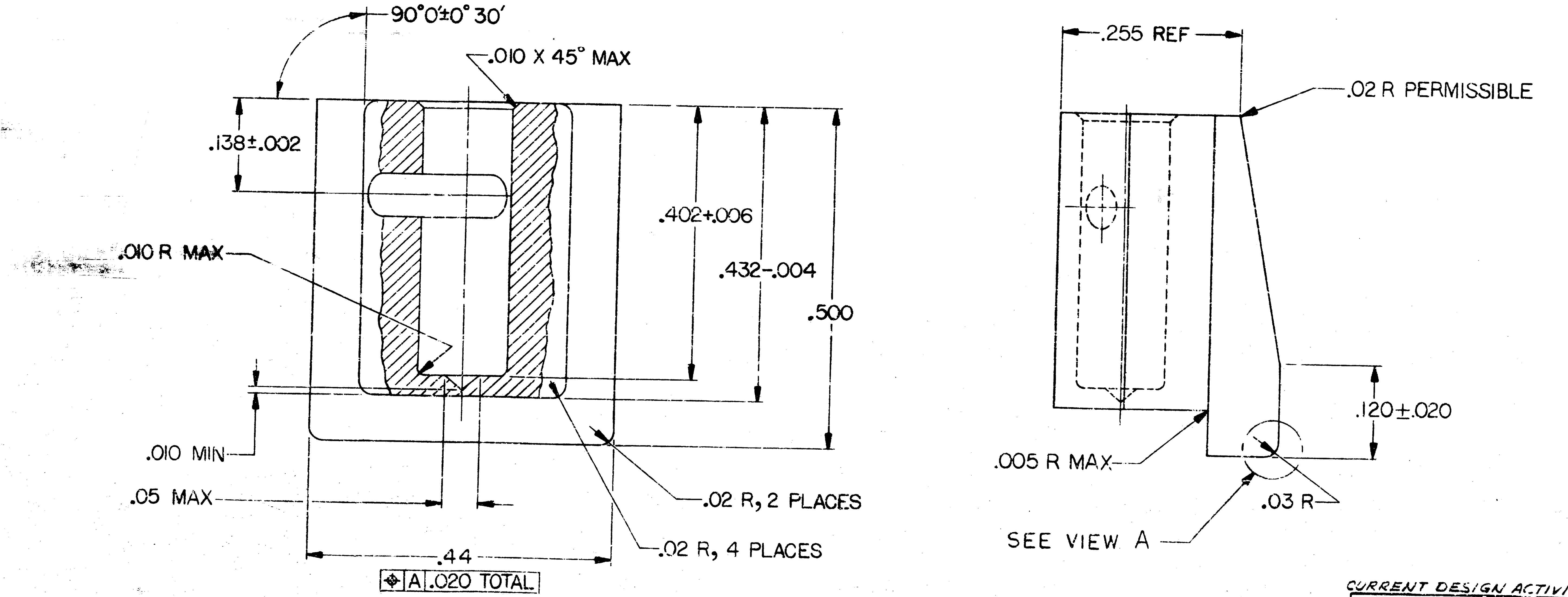

.225±.015
.128 DIA+.002
⌖ A .012 TOTAL
.325
.255
.128±.002
.225
.005 R MAX, 2 PLACES
45°±2°, 2 PLACES
.062 DIA+.003
.100, 2 PLACES
.305-.005
-A-
.070±.002


.225±.015
.305-.005
.225
.156 R
45°±2°
.070±.002

ALTERNATIVE DESIGN


30° ±2°
.003 +.010
.02 +.01

VIEW A
ALTERNATIVE CONFIGURATION
NOT TO SCALE


90°0'±0°30'
.010 X 45° MAX
.138±.002
.010 R MAX
.402+.006
.432-.004
.500
.010 MIN
.05 MAX
.02 R, 2 PLACES
.02 R, 4 PLACES
.44
⌖ A .020 TOTAL
.255 REF
.02 R PERMISSIBLE
.120±.020
.005 R MAX
.03 R
SEE VIEW A

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		A	SEE ERR HQR 50625	18 MAR 75	LB
		B	NOR W35 3139/83-08-05	84-01-27	

CURRENT DESIGN ACTIVITY FSCM No. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448784

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

D3448783	M16/M16A1
NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ± 1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
SEE NOTE 1

FINAL PROTECTIVE FINISH

CONTRACT NO

DATE 15 SEPT 72
PREPARED
CHECKED
ENGINEER
SUBMITTED Loren Brunton
APPROVED R. S. Henry

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HOUSING, COVER LATCH

SIZE D
CODE IDENT NO 19204
DRAWING NO 8448784
SCALE 10/1
SHEET 1 OF 1

EDITION OF 29 JUL 69 MAY BE USED

AMSWE Form 403D, 13 Nov 70

D 8448784

MF	ZONE	LTR	REVISIONS DESCRIPTION	DATE	APPROVED
		A	NOR W9S2009 80-02-13	80-05-16	

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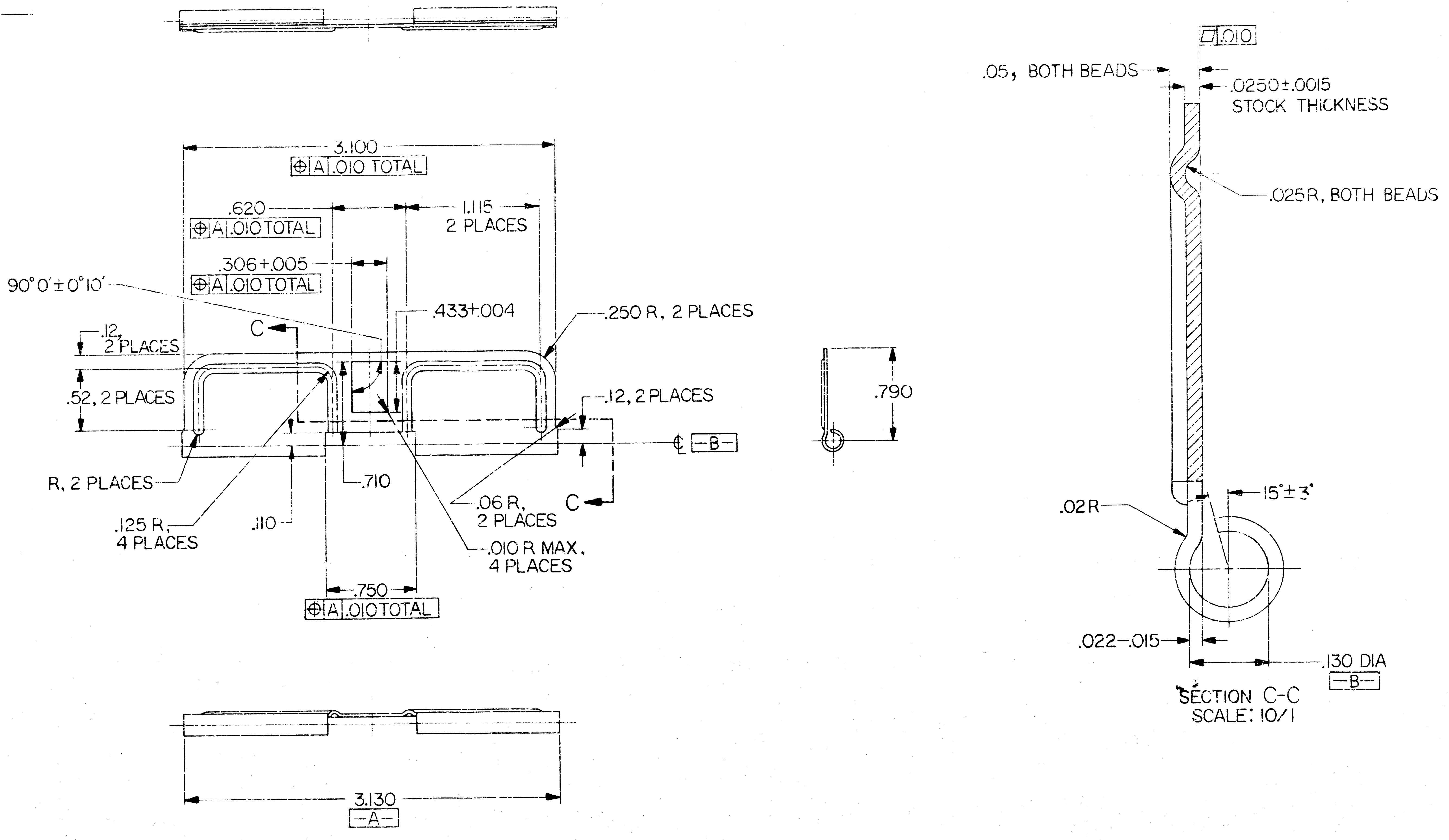
NOTES:

1. STEEL, CMPSN 1045 TO 1055, ANNEALED, COLD ROLLED STRIP, NO 2 FINISH, SPEC QQ-S-700.
2. BREAK ALL SHARP EDGES .005R+.005.
3. HEAT TREATMENT: AUSTEMPER TO HARDNESS SPECIFIED.
4. MIL-W-13855 APPLIES.


3.100
⊕ A .010 TOTAL
.620
⊕ A .010 TOTAL
1.115
2 PLACES
.306+.005
⊕ A .010 TOTAL
90°0'±0°10'
.433±.004
.250 R, 2 PLACES
C
.12,
2 PLACES
.52, 2 PLACES
.12, 2 PLACES
.790
℄ -B-
R, 2 PLACES
.710
.06 R,
2 PLACES
C
.125 R,
4 PLACES
.110
.010 R MAX,
4 PLACES
.750
⊕ A .010 TOTAL
3.130
-A-
▱ .010
.05, BOTH BEADS
.0250±.0015
STOCK THICKNESS
.025R, BOTH BEADS
15°±3°
.02R
.022-.015
.130 DIA
-B-
SECTION C-C
SCALE: 10/1

D8448785

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES ± — 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01	CONTRACT NO	PART NO. 8448785
YS MIN					DATE 15 SEPT 72	CODE IDENT NO. 19200
YS MAX				MATERIAL	PREPARED	~~DEPT OF THE ARMY~~ ~~US ARMY WEAPONS COMMAND~~ ~~ROCK ISLAND, ILLINOIS, 61201~~
EL 2				SEE NOTE 1	CHECKED	COVER, EJECTION PORT
RA					ENGINEER	
BH		D8448525 D8448783	M 231 M16/M16A1		SUBMITTED	SIZE D; CODE IDENT NO ~~19204~~; DRAWING NO 8448785
RH	C36T042	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	APPROVED	SCALE 2/1; SHEET OF 1
		APPLICATION				

EDITION OF 29 JUL 69 MAY BE USED

AMSWE Form 403D, 13 Nov 70

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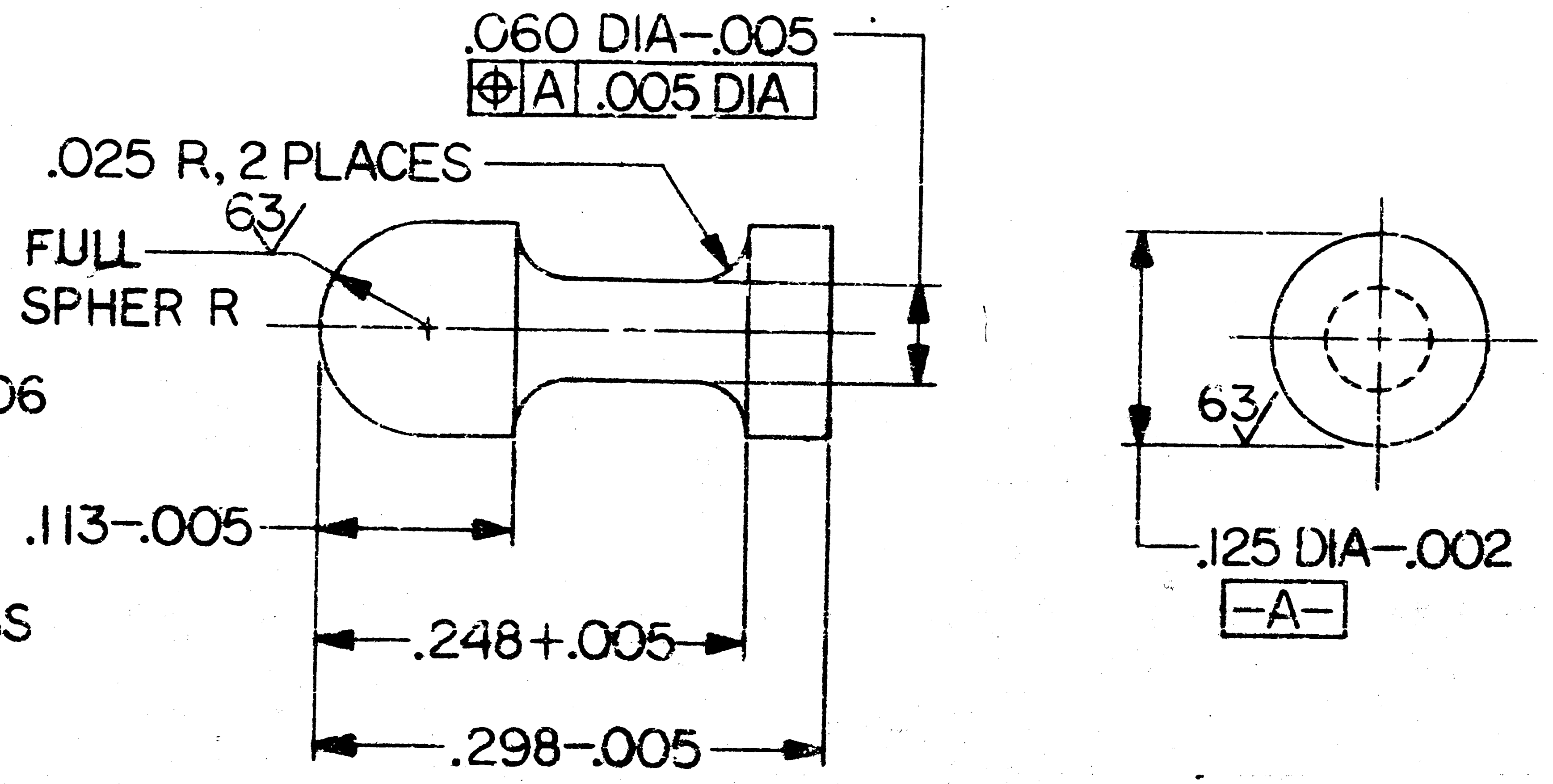
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		A	NOR W9S2003 80-02-13	80-05-16	RLRl
		B	NOR W3S 2023/83-06-06	83-09-14	RHoll

B8448786

NOTES:

1. FINISH $\sqrt[125]{}$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. CARBURIZE .003 TO .006 TOTAL CASE DEPTH.
4. HEAT TREATMENT: QUENCH AND TEMPER TO SURFACE HARDNESS 15 N 90 MIN.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT DESIGN ACTIVITY FSCM NO.19200

PART NO. 8448786

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		D 8448525	M231
RA		D8448525	M16/M16A1
BH		NEXT ASSY	USED ON
RH	SEE NOTE 4	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ± —
MATERIAL
STEEL, CMPSN 1117
SPEC ASTM A108
FINAL PROTECTIVE FINISH
SEE NOTE 5

CONTRACT NO.
DATE 15 SEPT 72
PREP R. Pasig P. Varon
CHK J. Duvelion V. Kolek
ENGR L. Bunton R. Elbe
SUBMITTED Loren Bunton
APPROVED R. S. Henry

LATCH, COVER

SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	8448786

SCALE 10/1 SHEET 1 OF 1

AMSWE Form 403B, 29 Jul 69

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M.		A	SEE ERR HQR 20778	6 OCT 72	RB
		B	NOR W9S2009 80-02-13	80-05-16	R Ald
		C	NORW2S2015 82 08 20	83 02 03	R Ald
		D	NOR W2S0011 /82-04-13 (ECP W3S3120 /83-07-07	83-11-04	

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER	.0120 ± .0003
COIL DIAMETER (O.D)	.120 ± .002
FREE LENGTH	.413 REF
TOTAL COILS	8 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .201	.80 LB ± .08 LB
LOAD AT COMPRESSED LENGTH OF	
SPRING RATE	3.77 LB/IN REF
SOLID LENGTH	.0984 MAX
TYPE OF ENDS	CLOSED, GROUND

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH900. HOLD AT 900°F ±10°F FOR ONE HOUR. AIR COOL.
3. FINISH 5.4.1 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003+.012.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT PART NO. 8448787

FSCM NO. 19200

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2		D8448525	M 231
RA		D8448525	M16/M16A1
BH		NEXT ASSY	USED ON
RH	15N 84.5 MIN	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ± —
2 PLACE DECIMALS ± —

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTE 3

CONTRACT NO:
DATE 15 SEPT 72
PREP R Passig P. Vernon
CHK J Krolak
ENGR L. Burton R. Elbe
SUBMITTED Loren Burton
APPROVED R. S. Henry

DEPT OF THE ARMY
US. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, COVER LATCH

SIZE B | CODE IDENT NO. 19204 | DRAWING NO. 8448787

SCALE — | SHEET 1 OF 1

AMSWE Form 4038, 29 Jul 69

8448787

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SYM	REVISIONS DESCRIPTION	DATE	APPROVED
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES.	79-04-18	7-16
B	ERR W9S2505	79-07-16	R.K

NOTES:

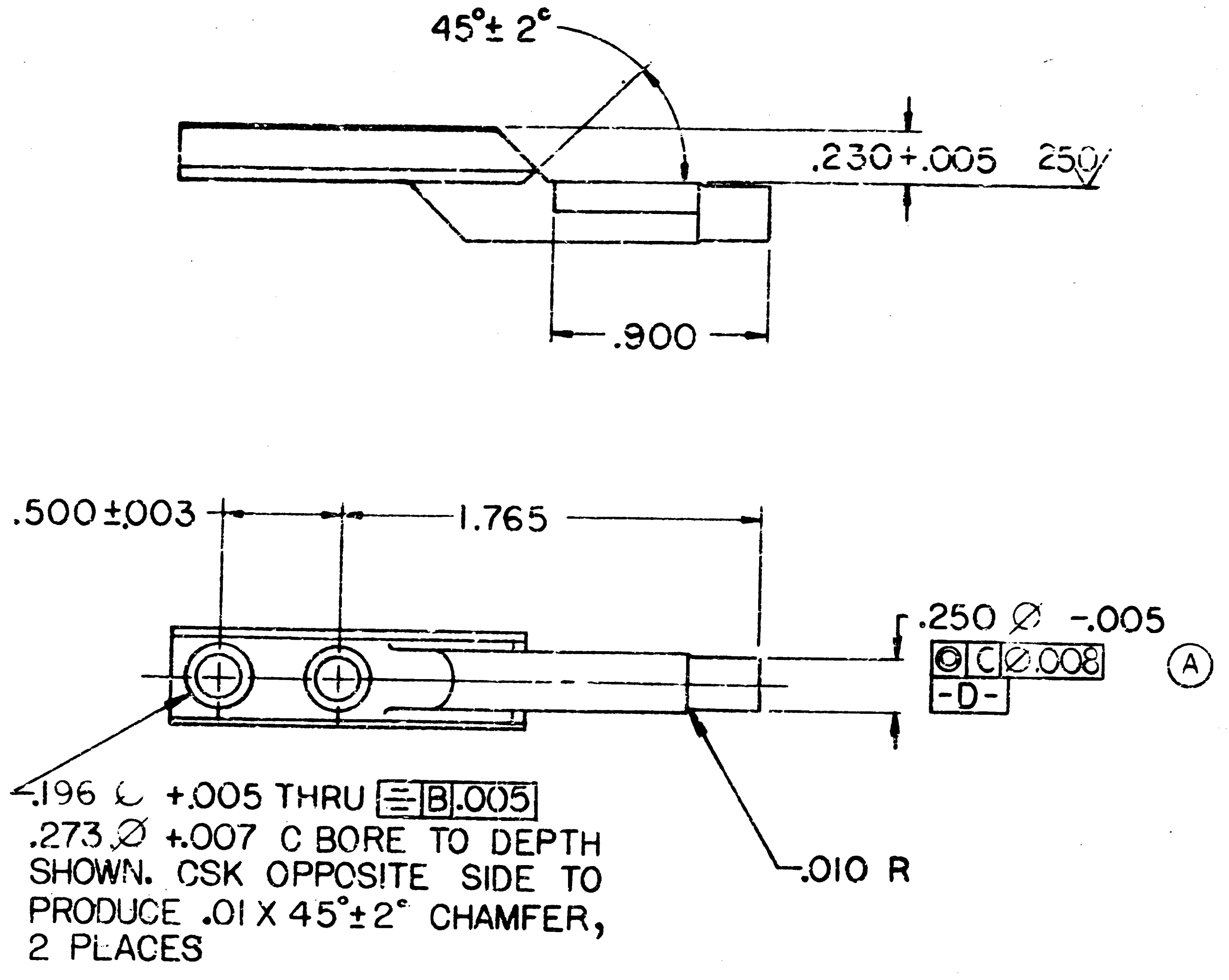
1-SPEC MIL-W-13855 AND ANSI Y14.5 1973 APPLY. Ⓐ

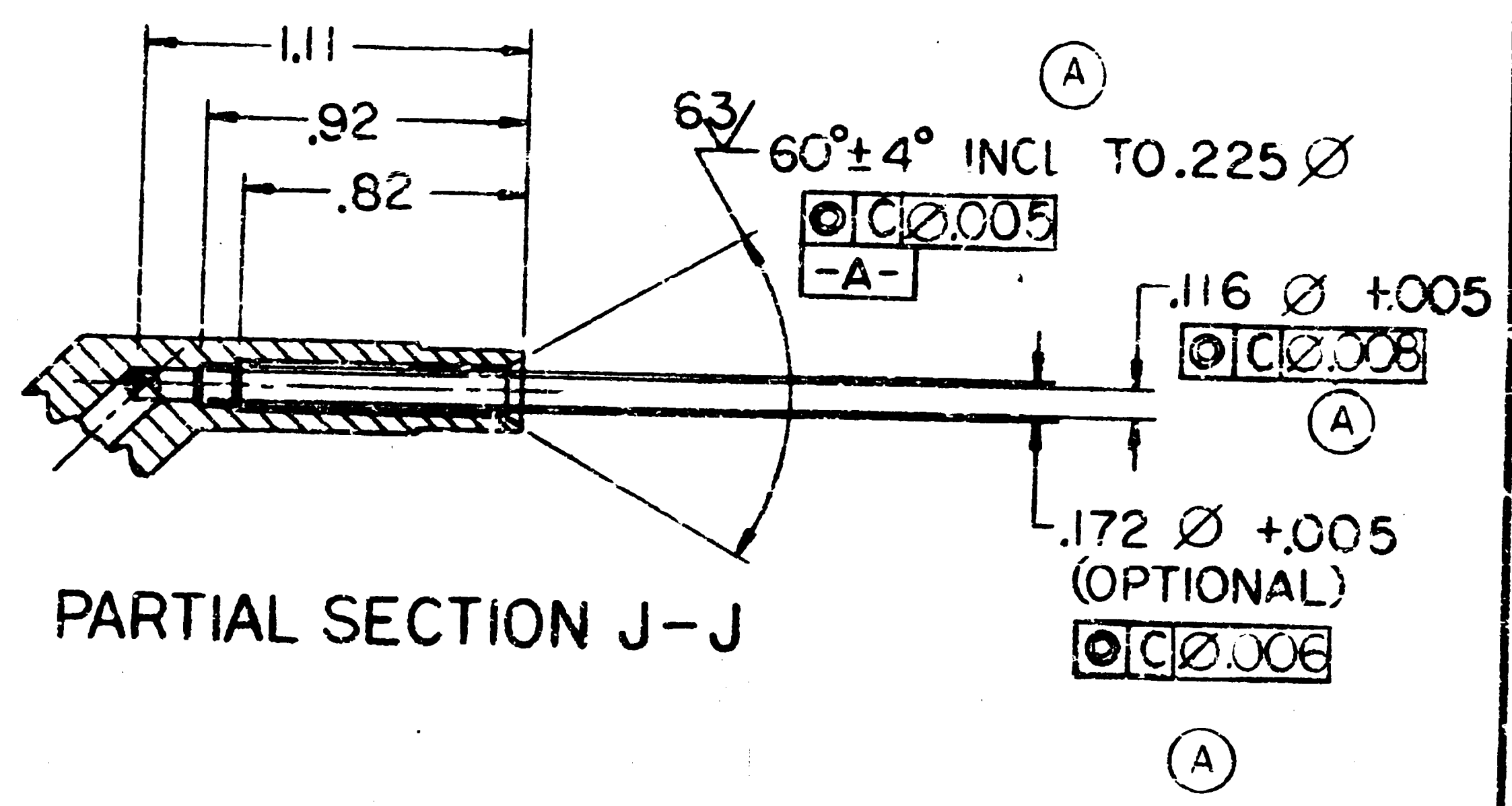
2-FINISH 125√ EXCEPT AS NOTED.

3-SUGGESTED HEAT TREAT PROCEDURE:
OIL QUENCH FROM 1575°F. TEMPER
AT 1100°F FOR 1 HOUR.

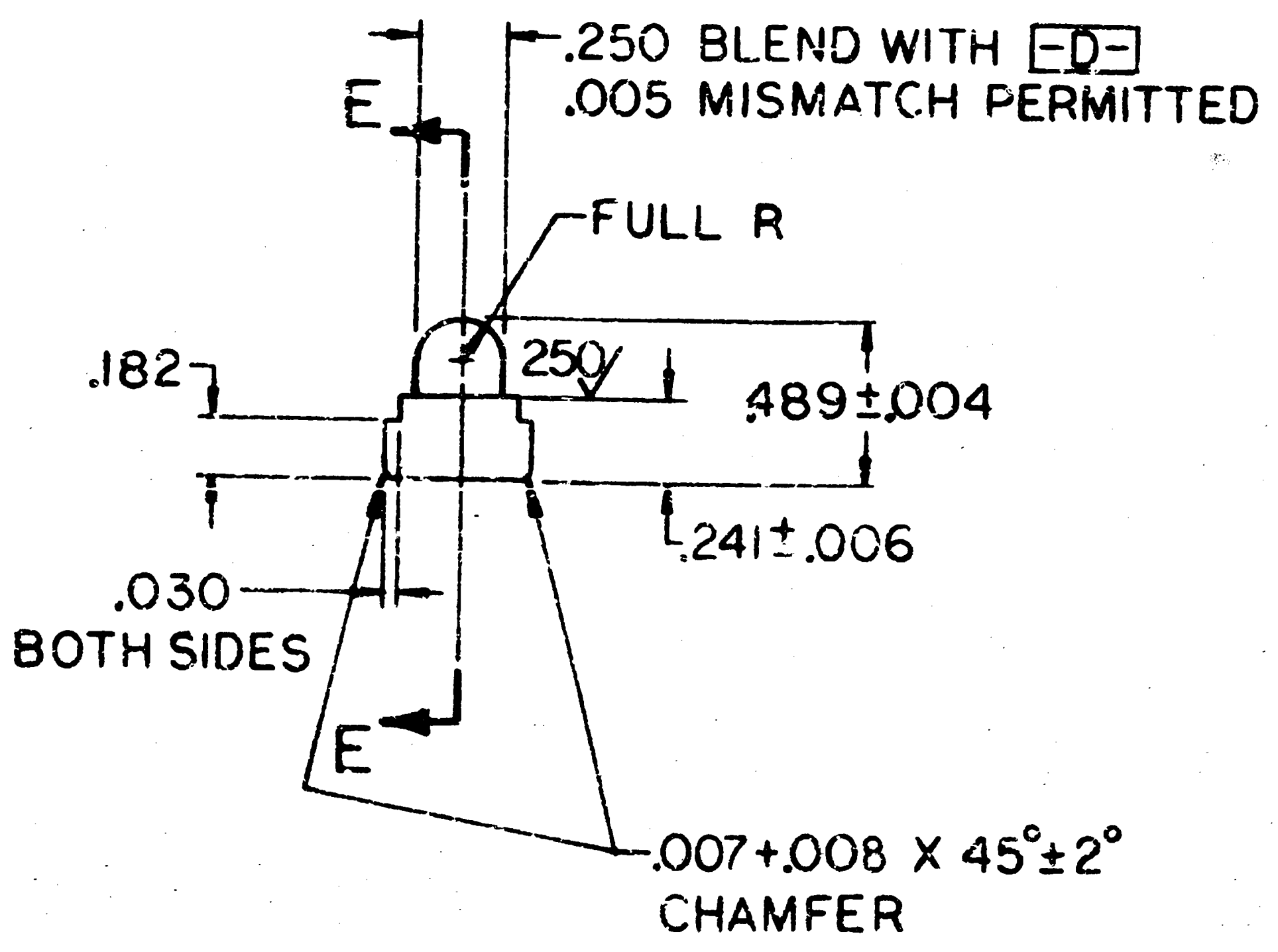
4-FINISH 1.2.2.2 OF MIL-STD-171 ON DIA -A- AND -C-. FILM THICKNESS .0002/.0003.

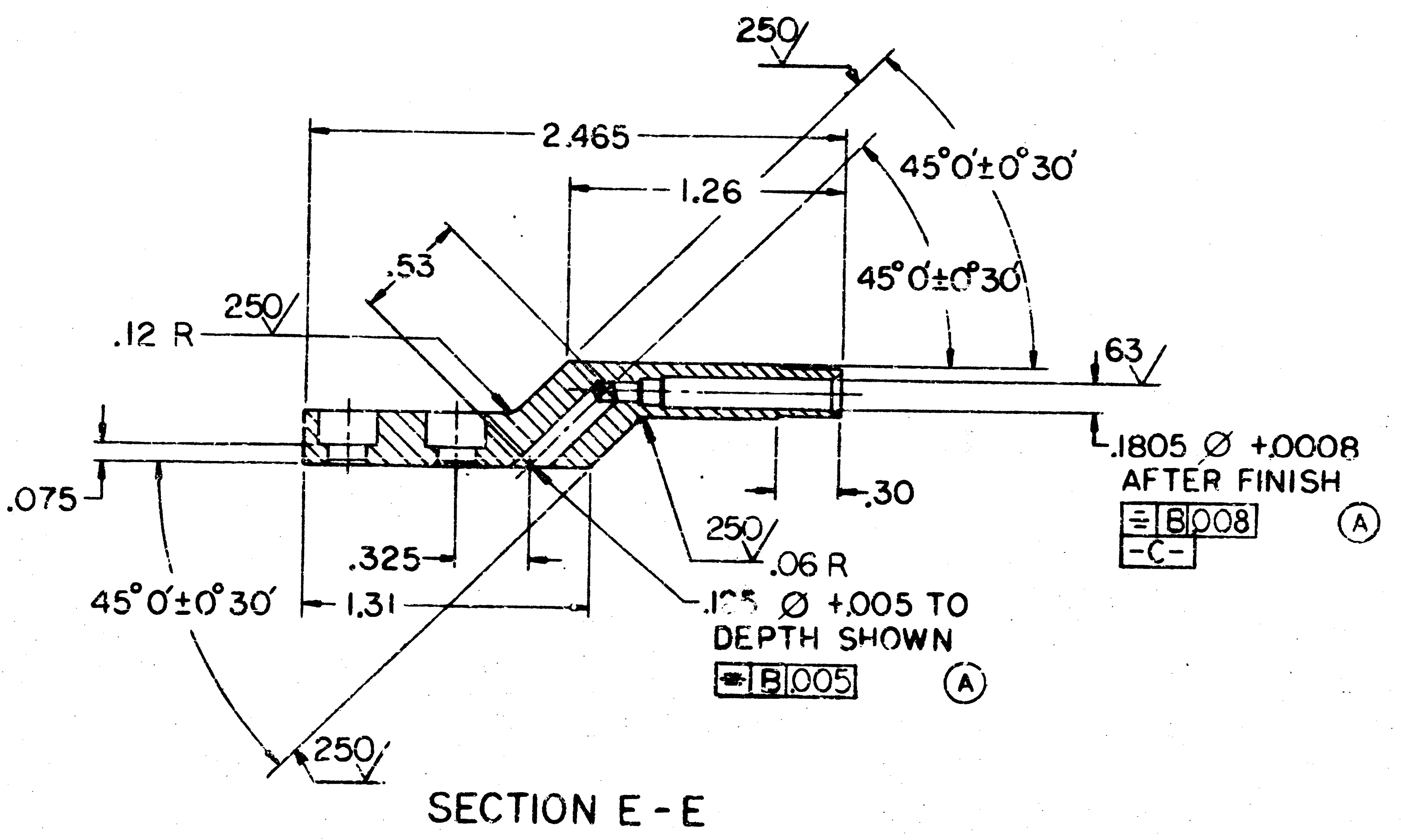
5-ALL OTHER SURFACES TO RECEIVE FINISH 5.3.1.2 OF MIL-STD-171.


45°± 2°
.230+.005
250√
.900
.500±.003
1.765
.250 Ø -.005
◎ C Ø.008
-D-
Ⓐ
.196 Ø +.005 THRU ⌯ B .005
.273 Ø +.007 C BORE TO DEPTH SHOWN. CSK OPPOSITE SIDE TO PRODUCE .01 X 45°±2° CHAMFER, 2 PLACES
.010 R

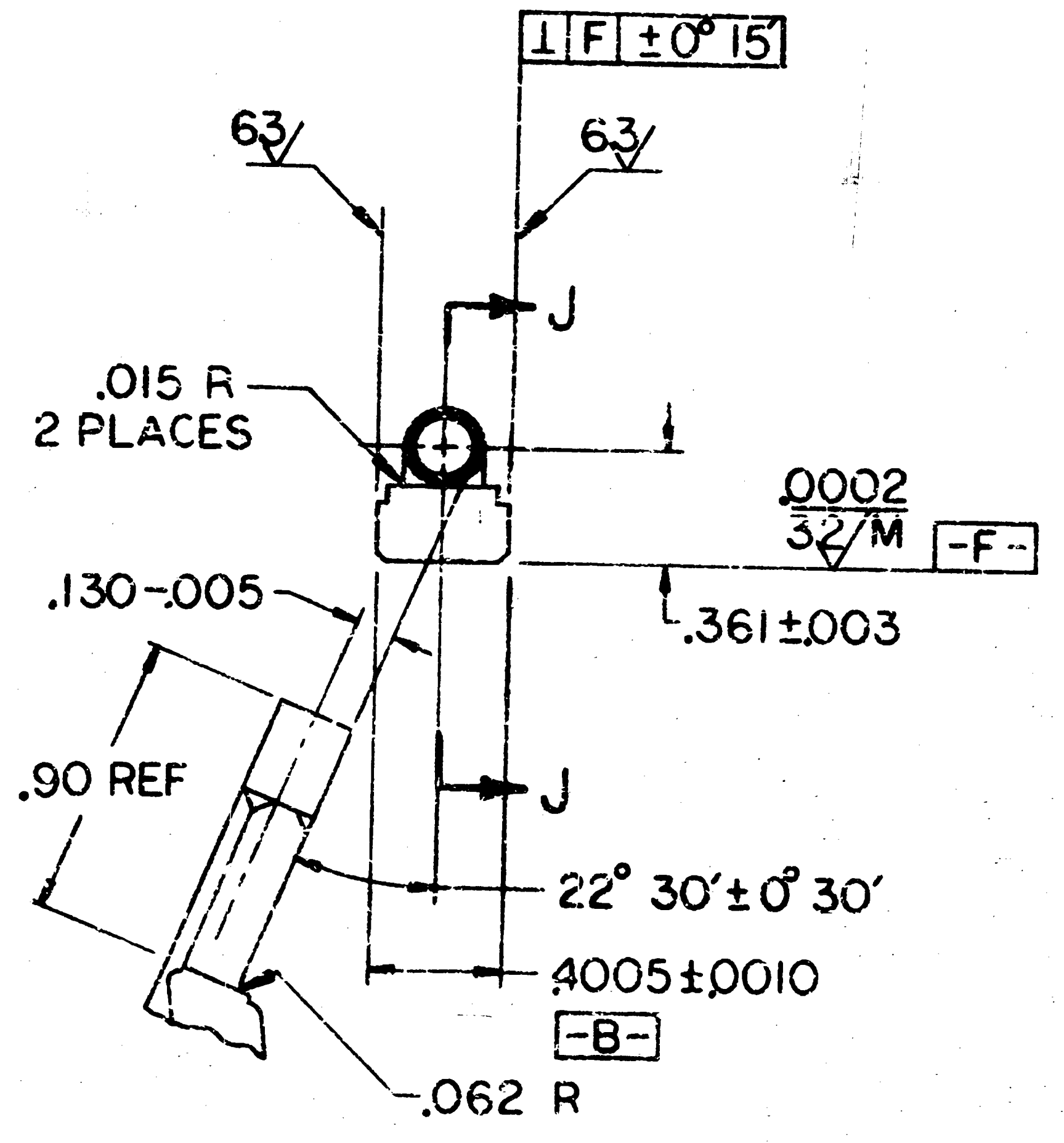

1.11
.92
.82
63√
60°±4° INCL TO .225 Ø
◎ C Ø.005
-A-
Ⓐ
.116 Ø +.005
◎ C Ø.008
Ⓐ
.172 Ø +.005
(OPTIONAL)
◎ C Ø.006
Ⓐ

PARTIAL SECTION J-J


E
E
.250 BLEND WITH -D-
.005 MISMATCH PERMITTED
FULL R
.182
250√
.489±.004
.241±.006
.030
BOTH SIDES
.007+.008 X 45°±2°
CHAMFER


250√
2.465
1.26
45°0'±0°30'
45°0'±0°30'
.53
.12 R
250√
63√
.1805 Ø +.0008
AFTER FINISH
⌯ B .008
-C-
Ⓐ
.075
.30
.325
250√
.06 R
45°0'±0°30'
1.31
.125 Ø +.005 TO DEPTH SHOWN
⌯ B .005
Ⓐ
250√

SECTION E-E


⊥ F ±0°15'
63√
63√
J
.015 R
2 PLACES
.0002
32/M
-F-
.361±.003
.130-.005
.90 REF
J
22° 30'±0°30'
.4005±.0010
-B-
.062 R

PART NO. 9327041

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA				
SH				XM231 PORT FIRING,
RH	C26-32		9327071	5.56MM, SMG
			NEXT ASSY	USED ON
			APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
STEEL, AISI 4130
GUN QUALITY
MAX BHN 229

FINAL PROTECTIVE FINISH
SEE NOTES 3 & 4

CONTRACT NO.
DATE DEC 9, 1977
PREPARED W. W. G.
CHECKED
ENGINEER
SUBMITTED
APPROVED

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

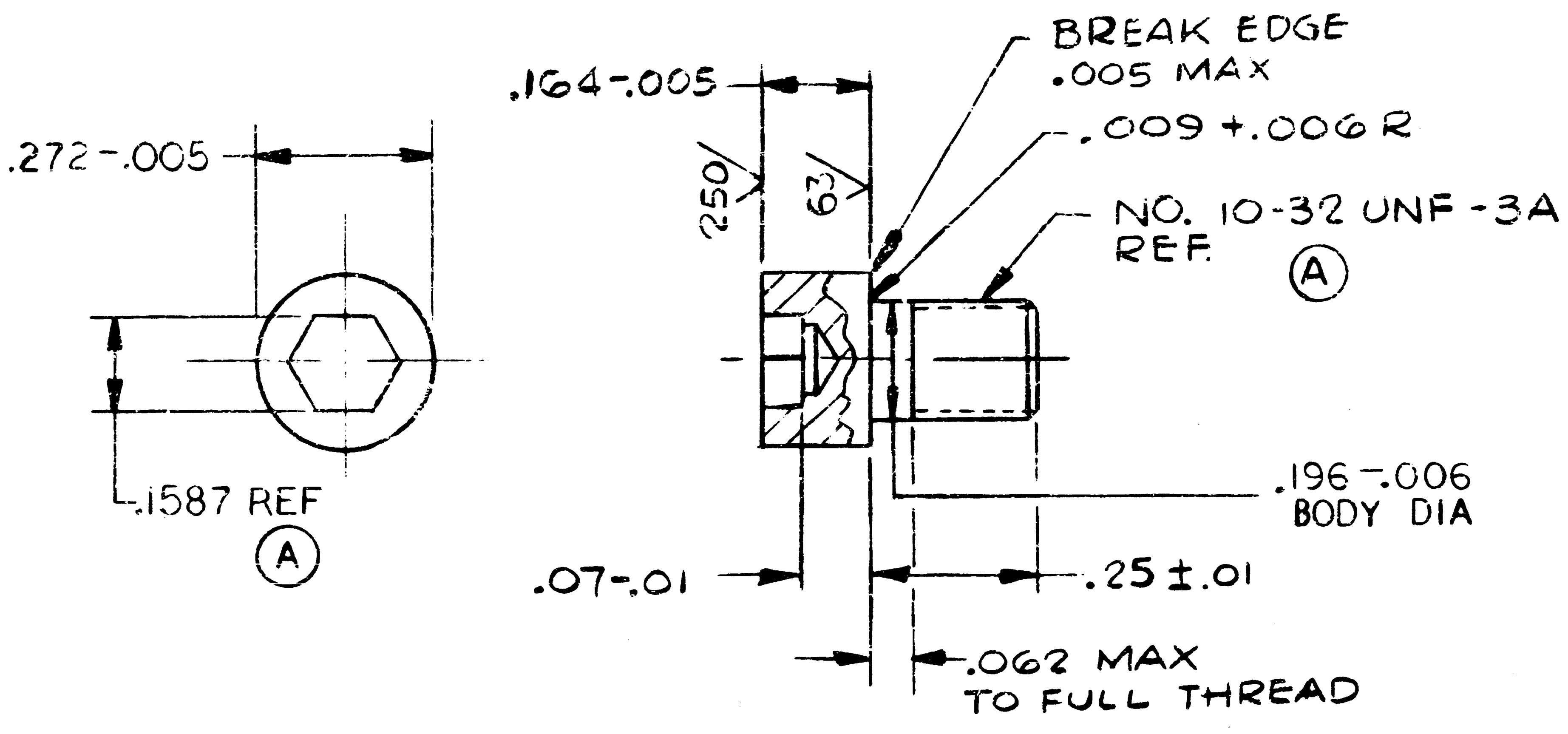
KEY,
BOLT CARRIER

SIZE	CODE IDENT NO	DRAWING NO
D	19200	9327041

SCALE 2/1
SHEET

AMSWE Form 403D, 29 Jul 69

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES.	79-04-10	
B	ERR W9S 2505	79-07-16	R.K.
C	NOR WIS5002 81-12-02	81-12-16	



.272 -.005
.1587 REF
Ⓐ
.164 -.005
250
63
BREAK EDGE
.005 MAX
.009 +.006 R
NO. 10-32 UNF-3A
REF.
Ⓐ
.196 -.006
BODY DIA
.07 -.01
.25 ±.01
.062 MAX
TO FULL THREAD

NOTES:-
1- SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
Ⓐ 2- MATERIAL: SCREW, CAP HEX SOCKET HEAD-B9349327
TO BE ALTERED AS INDICATED.

Ⓐ

ALTERED ITEM DRAWING

PART NO. 9327042

		MECHANICAL PROPERTIES	
		YP	
		TS	
	M231,	EL2	
	PORT FIRING,	RA	
9327071	5.56MM, SMG	BH	
NEXT ASSY	USED ON	RH	
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING
OCT 24, 1977

DRAFTSMAN R.K.	CHECKER
ENGR C.N.	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

SCREW, BOLT
CARRIER KEY

SIZE	CODE IDENT NO.	
B	19200	9327042

SCALE 4/1 UNIT WT. SHEET

SARPA FORM 1039 OCT 75 EDITION OF OCT 70. MAY BE USED

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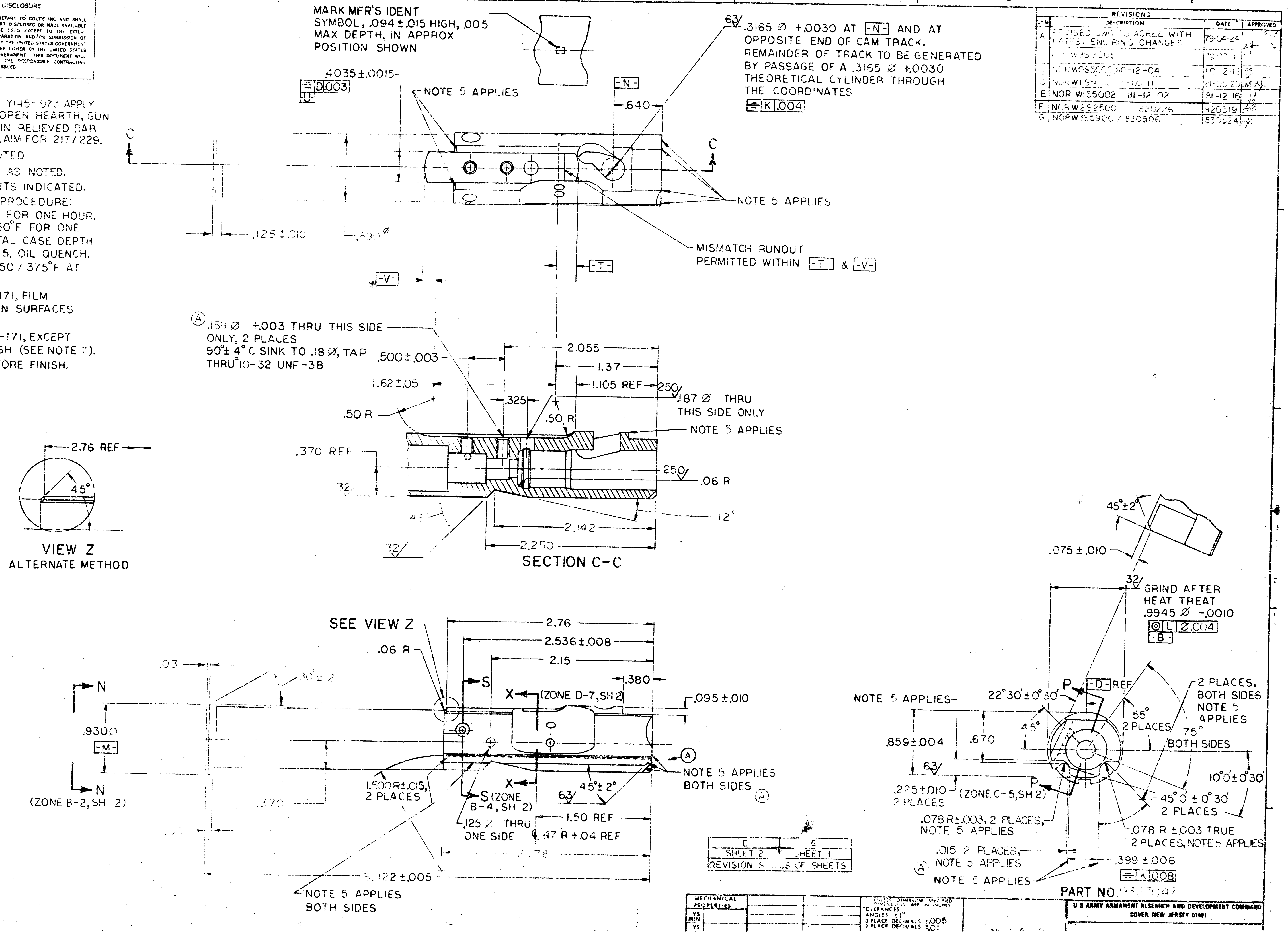
NOTES:

1. SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY
2. STEEL, AISI 8620, BASIC OPEN HEARTH, GUN QUALITY, COLD DRAWN, STRAIN RELIEVED BAR MAX BRINELL HARDNESS 241, AIM FOR 217/229.
3. FINISH 125/ EXCEPT AS NOTED.
4. FILLET RADII .010 EXCEPT AS NOTED.
5. .015 EDGE BREAK AT POINTS INDICATED.
6. SUGGESTED HEAT TREAT PROCEDURE: STRAIN RELIEVE AT 850°F FOR ONE HOUR. LIQUID CARBURIZE AT 1550°F FOR ONE HOUR 20 MIN APPROX. TOTAL CASE DEPTH REALIZED MUST BE .010/.015. OIL QUENCH. SUGGESTED DRAW TEMP 350/375°F AT HEAT FOR ONE HOUR.
7. FINISH 1.2.2.2 OF MIL-STD-171, FILM THICKNESS .0002/.0003 ON SURFACES INDICATED.
8. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT SURFACES WITH 1.2.2.2 FINISH (SEE NOTE 7).
9. ALL DIMENSIONS APPLY BEFORE FINISH.


MARK MFR'S IDENT SYMBOL, .094±.015 HIGH, .005 MAX DEPTH, IN APPROX POSITION SHOWN
.4035±.0015
D .003
NOTE 5 APPLIES
-N-
.640
.3165 Ø +.0030 AT -N- AND AT OPPOSITE END OF CAM TRACK. REMAINDER OF TRACK TO BE GENERATED BY PASSAGE OF A .3165 Ø +.0030 THEORETICAL CYLINDER THROUGH THE COORDINATES
K .004
C
NOTE 5 APPLIES
.125±.010
.890 Ø
MISMATCH RUNOUT PERMITTED WITHIN -T- & -V-
-T-
-V-
.159 Ø +.003 THRU THIS SIDE ONLY, 2 PLACES 90°± 4° C SINK TO .18 Ø, TAP THRU 10-32 UNF-3B
.500±.003
1.62±.05
.50 R
.325
.50 R
2.055
1.37
1.105 REF
.187 Ø THRU THIS SIDE ONLY
NOTE 5 APPLIES
.370 REF
.06 R
2.142
2.250
12°
SECTION C-C
2.76 REF
45°
VIEW Z
ALTERNATE METHOD
SEE VIEW Z
.06 R
2.76
2.536±.008
2.15
.380
.095±.010
.03
30°± 2°
N
.930 Ø
-M-
(ZONE B-2, SH 2)
S
X
(ZONE D-7, SH 2)
1.500 R±.015, 2 PLACES
S (ZONE B-4, SH 2)
.125 Ø THRU ONE SIDE
.47 R +.04 REF
1.50 REF
45°± 2°
NOTE 5 APPLIES BOTH SIDES
.370
2.78
5.122±.005
NOTE 5 APPLIES BOTH SIDES
45°±2°
.075±.010
GRIND AFTER HEAT TREAT .9945 Ø -.0010
L Ø.004
-B-
NOTE 5 APPLIES
22°30'±0°30'
P
-D- REF
2 PLACES, BOTH SIDES NOTE 5 APPLIES
55° 2 PLACES
75° BOTH SIDES
45°
.859±.004
.670
10°0'±0°30'
.225±.010 2 PLACES
(ZONE C-5, SH 2)
45°0'±0°30' 2 PLACES
.078 R±.003, 2 PLACES, NOTE 5 APPLIES
.078 R ±.003 TRUE 2 PLACES, NOTE 5 APPLIES
.015 2 PLACES, NOTE 5 APPLIES
NOTE 5 APPLIES
.399±.006
K .008

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVED
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES	79-04-24	
B	NOR W3S2005	79-07-11	
C	NOR W0S5000 80-12-04	80-12-12	
D	NOR W1S5000 81-05-11	81-05-29	
E	NOR W1S5002 81-12-02	81-12-16	
F	NOR W2S2500 820226	820319	
G	NOR W3S5900 / 830506	830524	

E	G
SHEET 2	SHEET 1
REVISION STATUS OF SHEETS	

PART NO. 9322047

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			
BH	15N 89.5-91.0	APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTES 6 & 7

DATE: NOV 4 19

PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CARRIER, BOLT

SIZE: F | CODE IDENT NO: 19200 | DRAWING NO:
SCALE: 2/1 | SHEET 1 OF 2

CDI

Form 403F, 29 Jul 69

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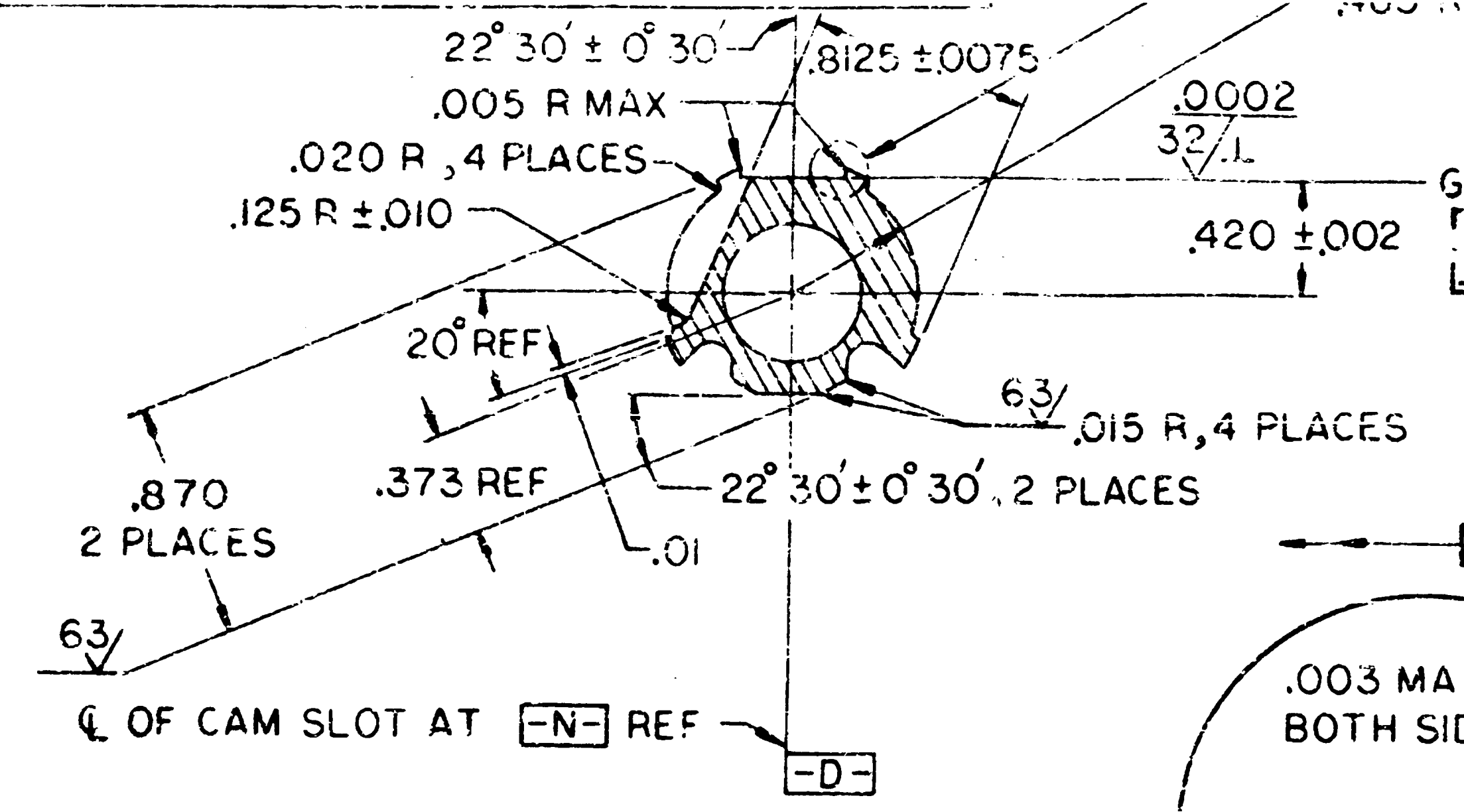
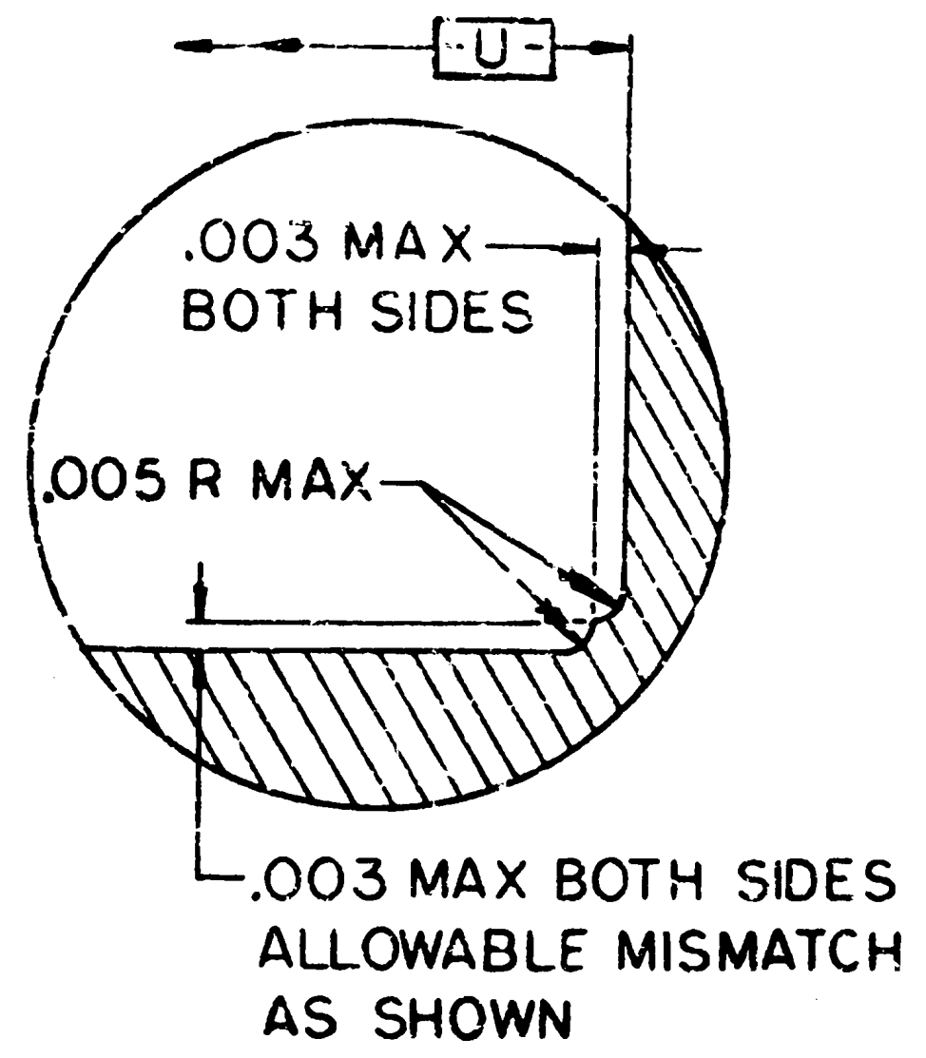
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVED
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES	79-04-24	
B	ERR W9S 2505	79 07-16	
C	NOR WOS5000,80 12-04	80-12-12	
E	NOR W1S5002 81-12-02	81-12-10	



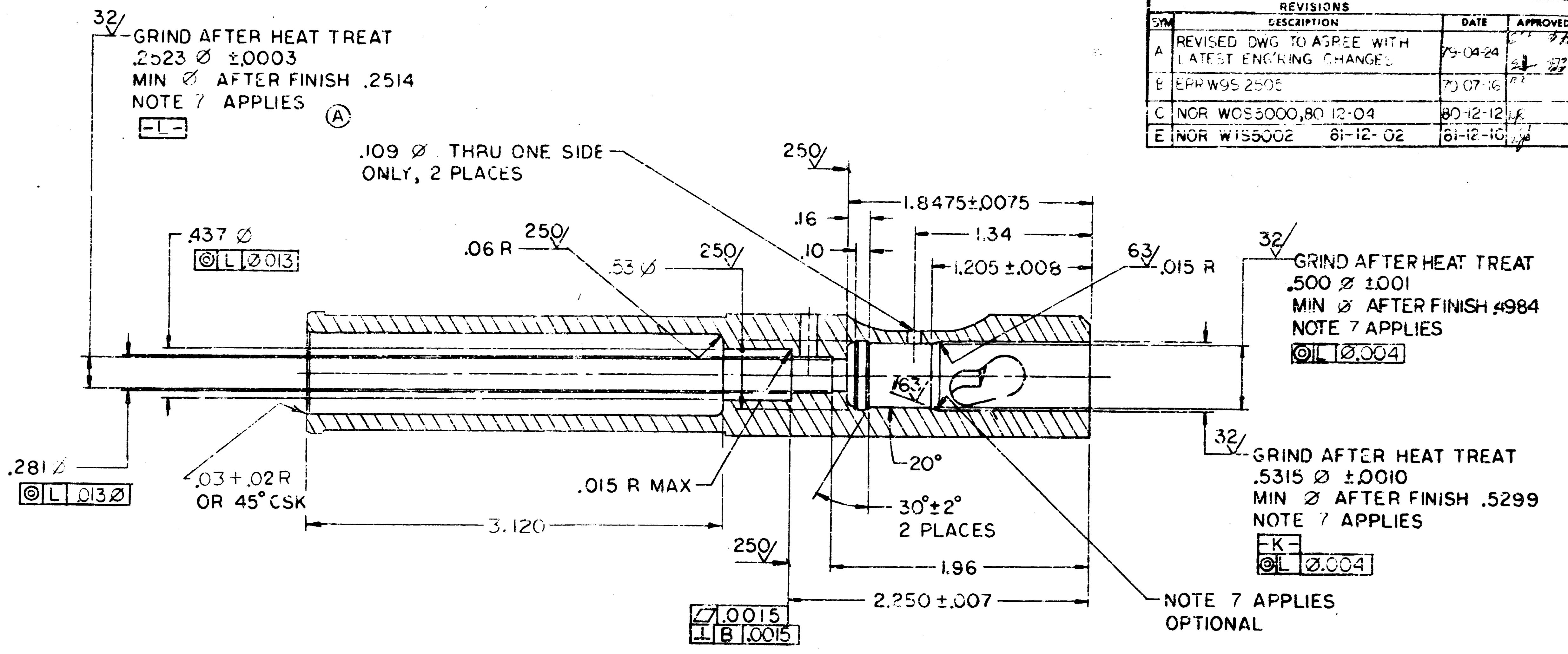
SEE VIEW V
.465 R, BOTH SIDES
22° 30' ± 0° 30'
.8125 ±.0075
.005 R MAX
.020 R, 4 PLACES
.125 R ±.010
.0002
32
GRIND AFTER HEAT TREAT
.420 ±.002
B .002
D .001
20° REF
63
.015 R, 4 PLACES
.870
2 PLACES
.373 REF
22° 30' ± 0° 30', 2 PLACES
.01
63
℄ OF CAM SLOT AT -N- REF
-D-

SECTION X - X
(SH 1, ZONE B - 4)



-U-
.003 MAX
BOTH SIDES
.005 R MAX
.003 MAX BOTH SIDES
ALLOWABLE MISMATCH
AS SHOWN

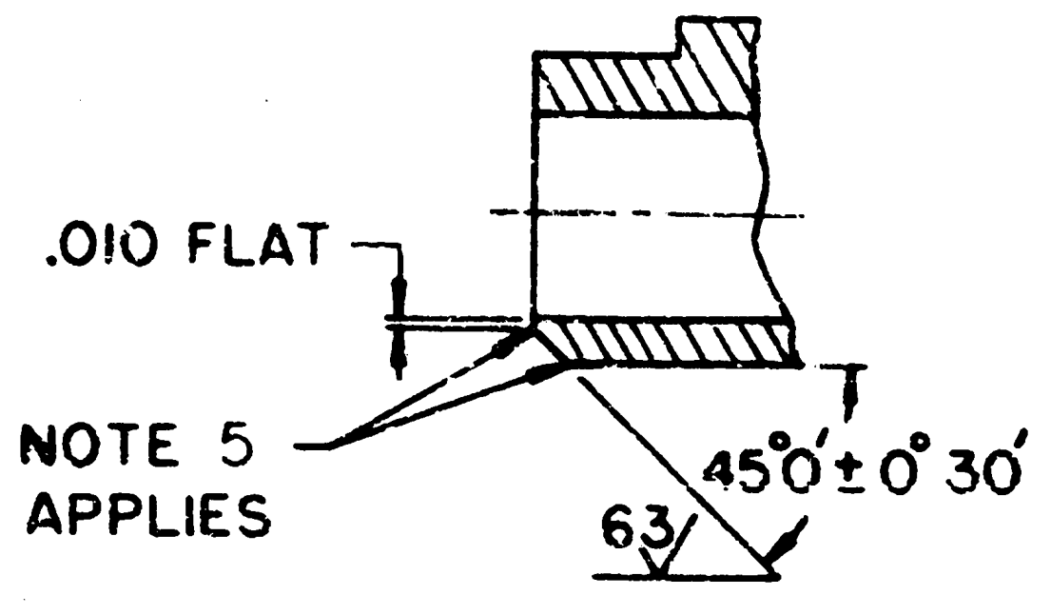
VIEW V
SCALE: 50/1



32
GRIND AFTER HEAT TREAT
.2523 Ø ±.0003
MIN Ø AFTER FINISH .2514
NOTE 7 APPLIES
Ⓐ
-L-
.109 Ø THRU ONE SIDE
ONLY, 2 PLACES
.437 Ø
◎ L Ø.013
.06 R
250
.53 Ø
250
250
.16
.10
1.8475±.0075
1.34
1.205±.008
63
.015 R
32
GRIND AFTER HEAT TREAT
.500 Ø ±.001
MIN Ø AFTER FINISH .4984
NOTE 7 APPLIES
◎ L Ø.004
63
.281 Ø
◎ L .013Ø
.03+.02R
OR 45° CSK
.015 R MAX
20°
30°±2°
2 PLACES
3.120
250
1.96
2.250±.007
.0015
⊥ B .0015
32
GRIND AFTER HEAT TREAT
.5315 Ø ±.0010
MIN Ø AFTER FINISH .5299
NOTE 7 APPLIES
-K-
◎ L Ø.004
NOTE 7 APPLIES
OPTIONAL

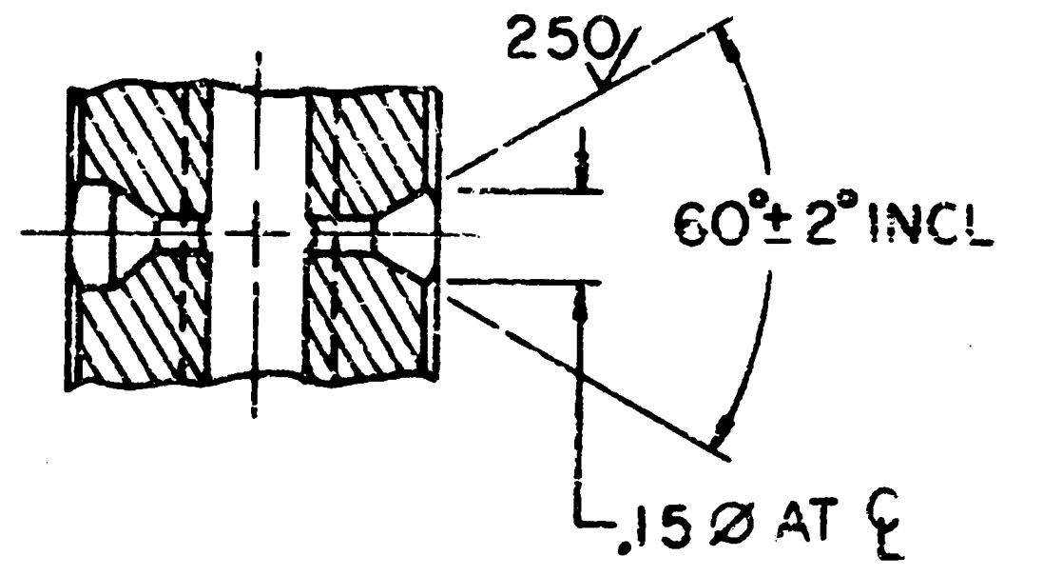
SECTION W - W
ROTATED 90° CCW

ANGLE BASIC	ADVANCE ±.002
0	.042
1/4	.044
1/2	.046
1	.050
1 1/2	.053
2	.057
2 1/2	.061
3	.065
3 1/2	.069
4	.073
4 1/2	.076
5	.080
5 1/2	.084
6	.088
6 1/2	.092
7	.096
7 1/2	.099
8	.103
8 1/2	.107
9	.111
9 1/2	.114
10	.118
10 1/2	.122
11	.126
11 1/2	.130
12	.134
12 1/2	.137
13	.141
13 1/2	.145
14	.149
14 1/2	.153
15	.157
15 1/2	.161
16	.164
16 1/2	.168
17	.172
17 1/2	.175
18	.179
18 1/2	.183
19	.187
19 1/2	.190
20	.195
20 1/2	.200
21	.207
21 1/2	.214
22	.226
22 1/4	.235
22 1/2	.255



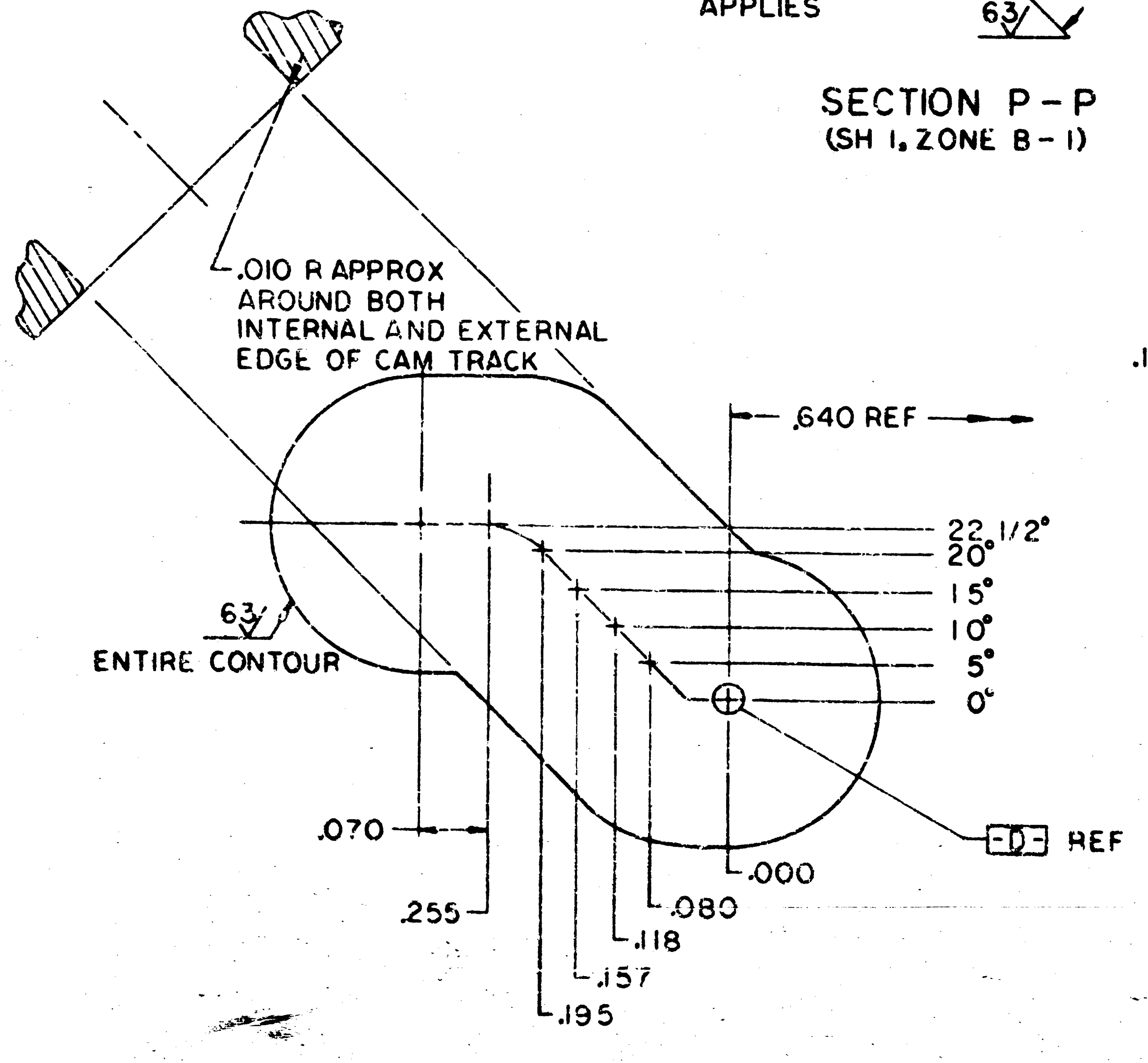
.010 FLAT
NOTE 5
APPLIES
63
45°0' ± 0° 30'

SECTION P - P
(SH 1, ZONE B - 1)

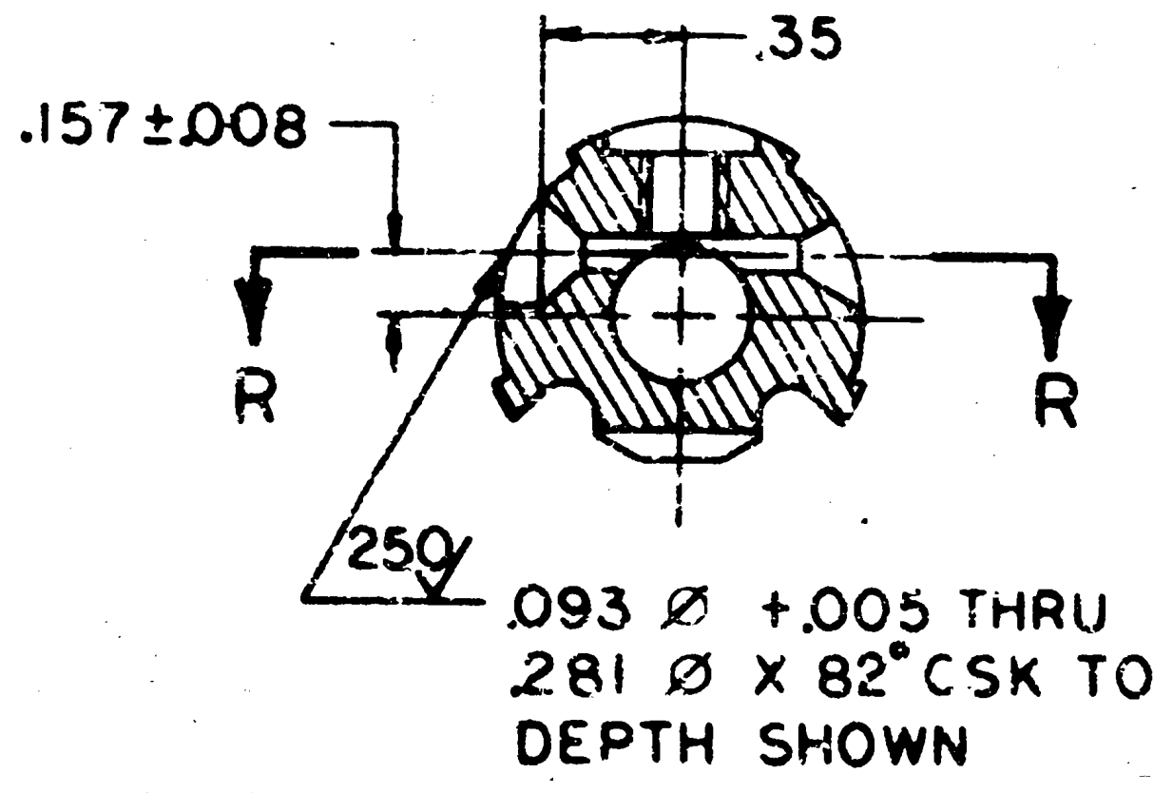


250
60°±2° INCL
.15 Ø AT ℄

SECTION R - R

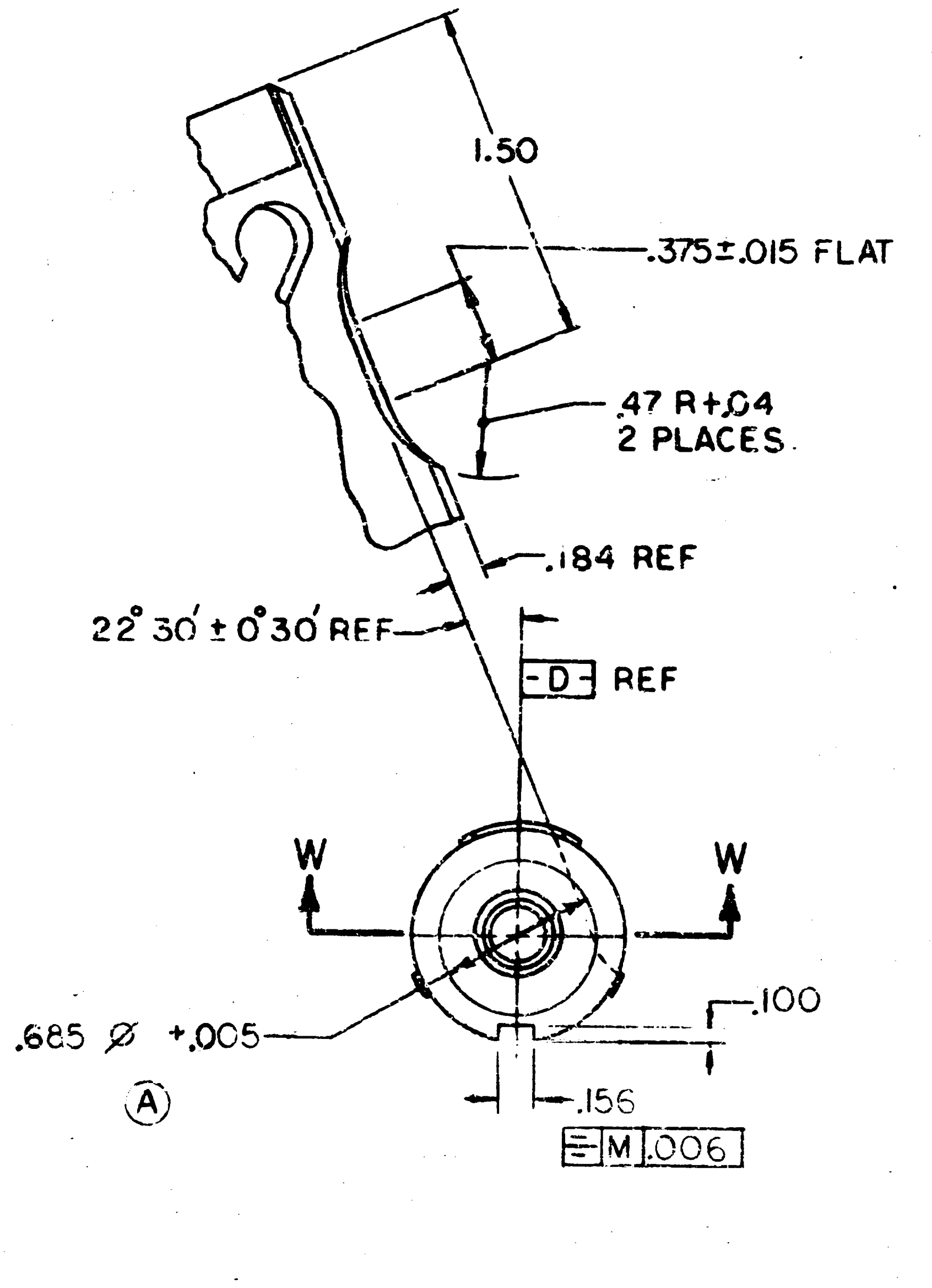


.010 R APPROX
AROUND BOTH
INTERNAL AND EXTERNAL
EDGE OF CAM TRACK
.640 REF
22 1/2°
20°
15°
10°
5°
0°
63
ENTIRE CONTOUR
-D- REF
.070
.000
.080
.255
.118
.157
.195



.35
.157±.008
R
R
250
.093 Ø +.005 THRU
.281 Ø X 82° CSK TO
DEPTH SHOWN

SECTION S - S
(SH 1, ZONE B - 5)



1.50
.375±.015 FLAT
.47 R+.04
2 PLACES
.184 REF
22° 30' ± 0° 30' REF
-D- REF
W
W
.685 Ø +.005
Ⓐ
.100
.156
-M .006

VIEW N - N
(SH 1, ZONE B - 7)

PART NO 9327047

MECHANICAL PROPERTIES		NEXT ASSY	USED ON	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
YS MIN				TOLERANCES ANGLES ±1° 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±.01
YS MAX				MATERIAL
EL 2				
RA			M231, PORT FIRING	
RH		9327071	5.56MM SMG	FINAL PROTECTIVE FINISH
		APPLICATION		

DATE NOV 4, 1977
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CARRIER, BOLT

SIZE F
CODE IDENT NO 19200
DRAWING NO 9327047
SCALE 2/1
SHEET 2

CDI

Form 4034, 29 Jul 69

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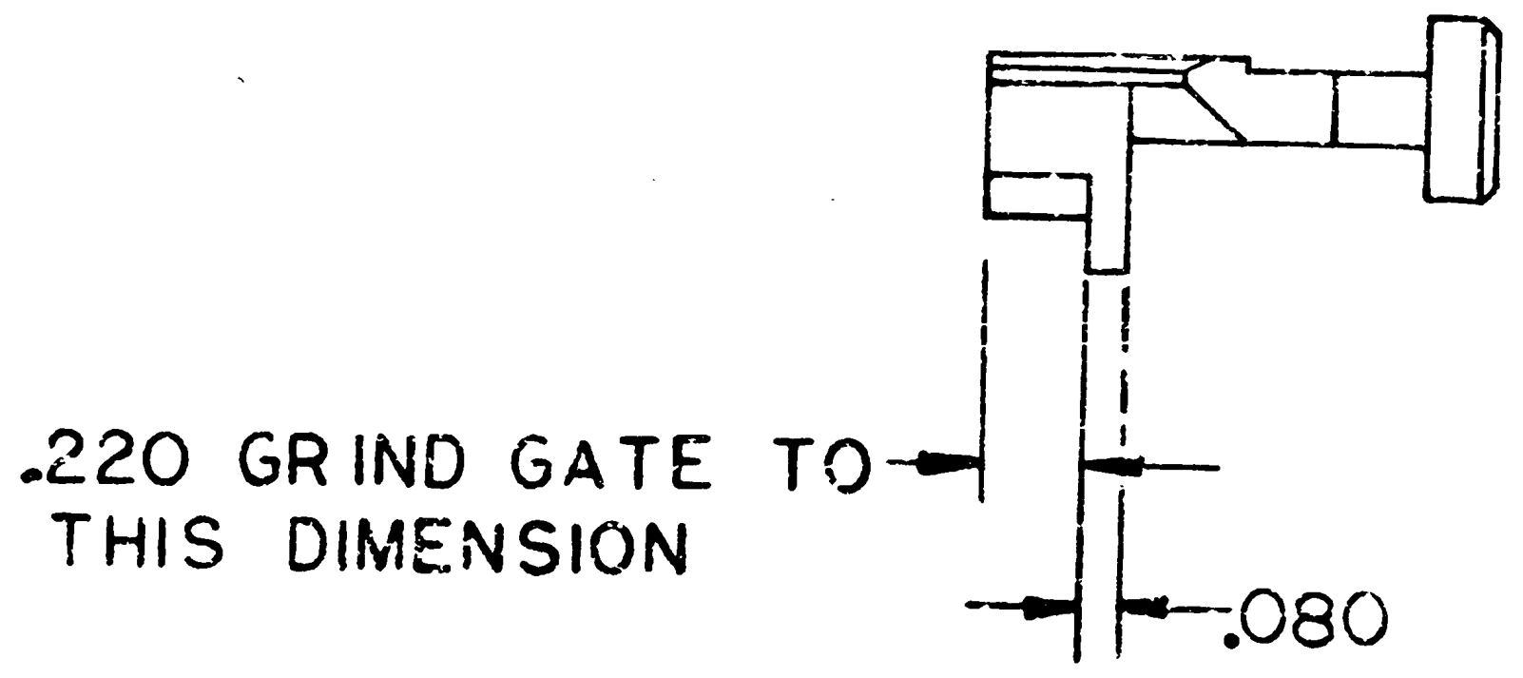
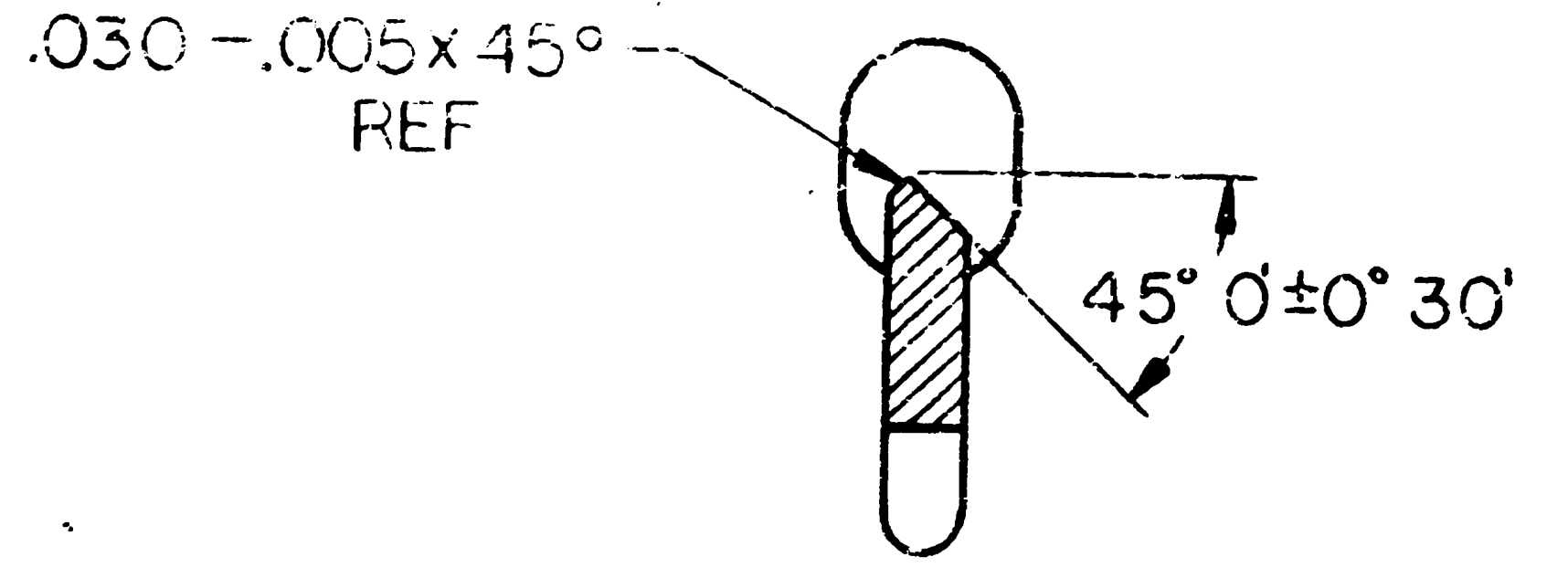
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVED
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES.	790419	
B	ERR W95 2505	79-07-16	

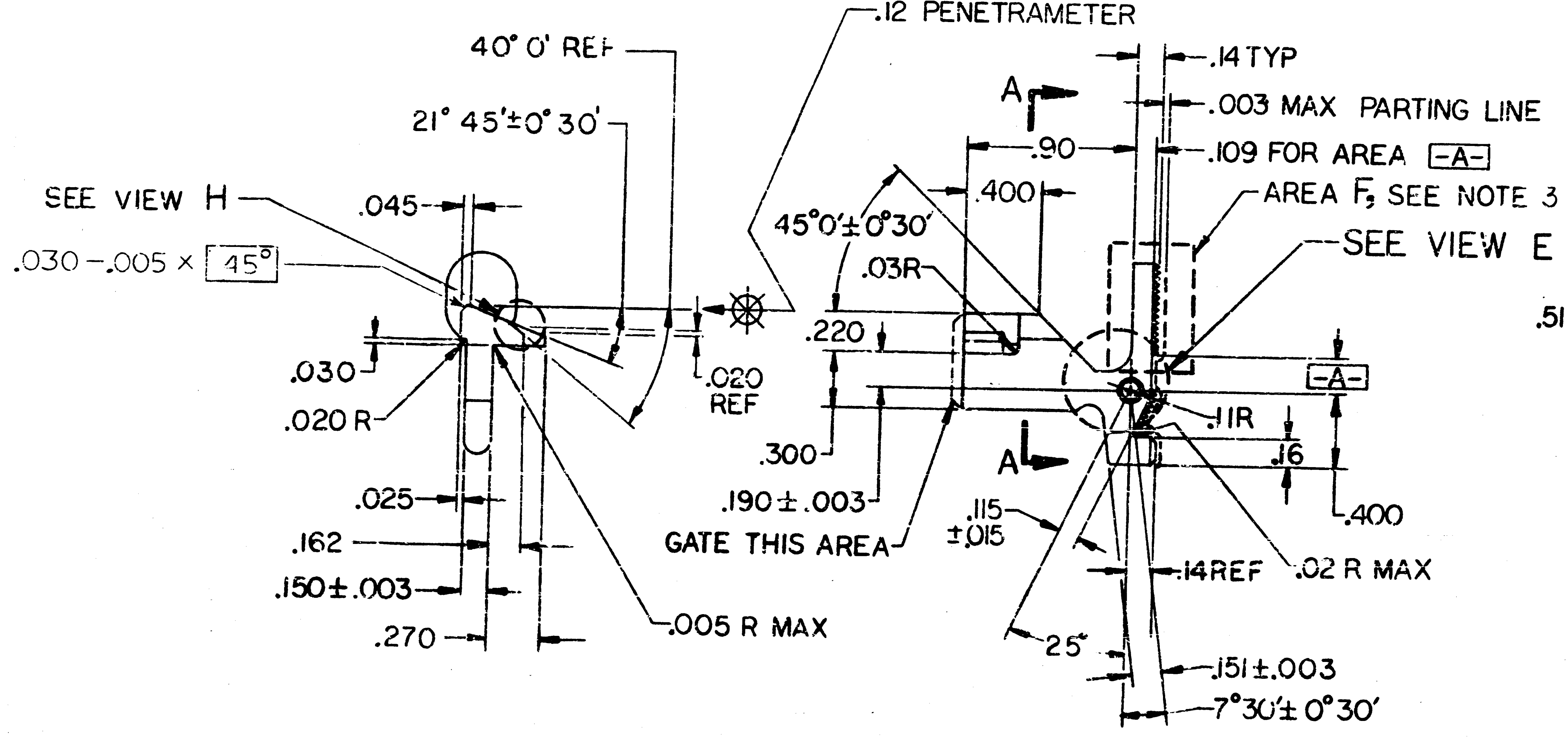
NOTES:

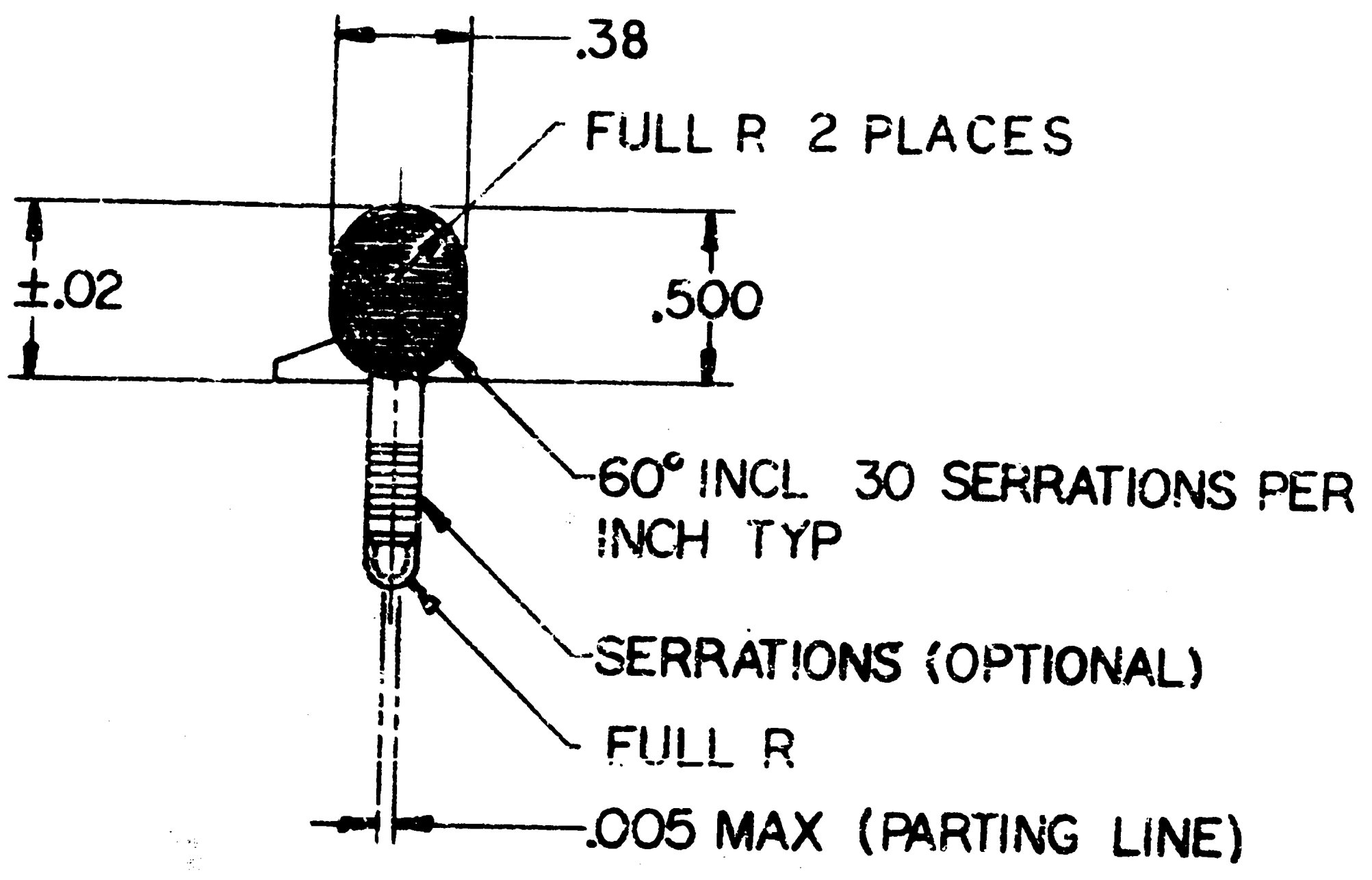
Ⓐ 1. SPEC MIL-W-13855 & ANSI-Y14.5-1973 APPLY.
2. STEEL, INVESTMENT CASTING, CMPSN IC 8620, SPEC MIL-S-22141, EXCEPT THAT MANGANESE CONTENT SHALL BE .70 TO 1.20 %.
3. CLASSIFICATION AND INSPECTION OF CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 2A, GRADE A, SPEC MIL-C-6021, EXCEPT CLASS 1B, GRADE C IS PERMISSIBLE IN AREA F.
4. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
5. EJECTOR PIN MARKS .010 NEGATIVE MAX.
6. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014 TO .018.
Ⓐ 7. PROTECTIVE FINISH: FINISH NO. 5.3.1.2 OF MIL-STD-171

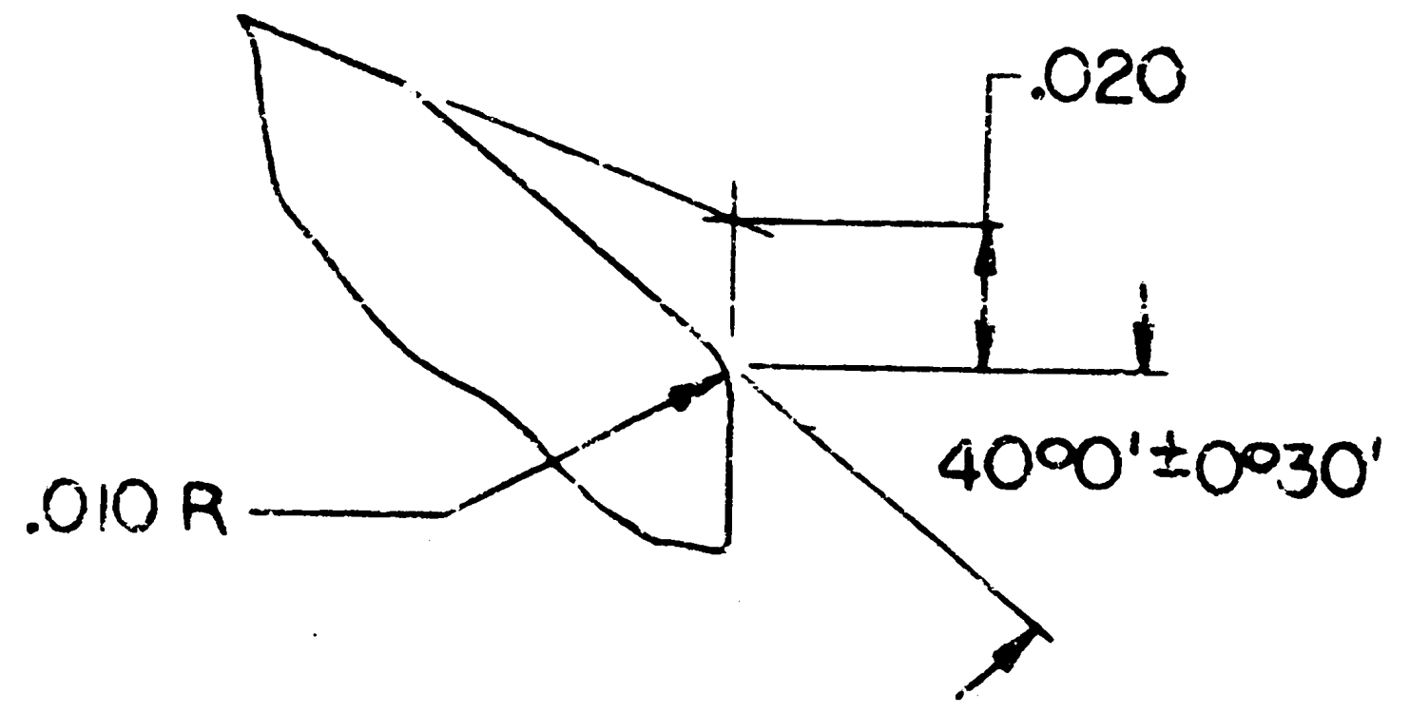

.220 GRIND GATE TO THIS DIMENSION
.080


.030 -.005 x 45° REF
45° 0'±0° 30'

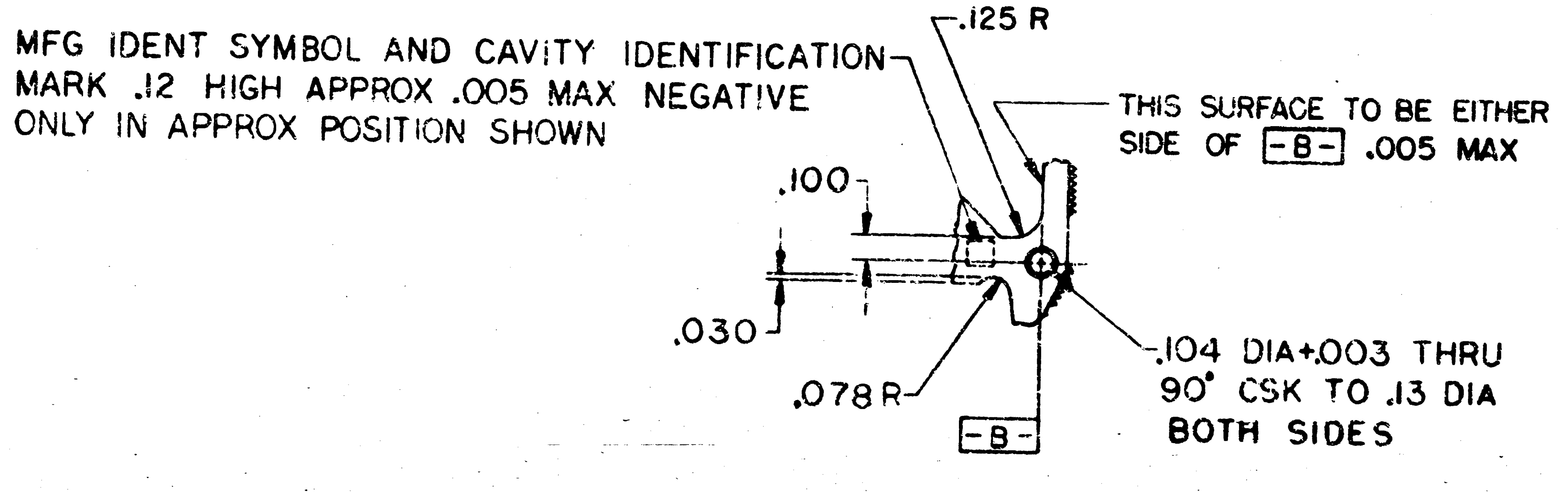
SECTION A-A


40° 0' REF
21° 45'±0° 30'
SEE VIEW H
.045
.030 -.005 x 45°
.030
.020 R
.025
.162
.150±.003
.270
.020 REF
.005 R MAX
.12 PENETRAMETER
.14 TYP
.003 MAX PARTING LINE
.90
.109 FOR AREA -A-
.400
AREA F, SEE NOTE 3
SEE VIEW E
45°0'±0°30'
.03R
.220
-A-
A
A
.11R
.16
.400
.300
.190±.003
GATE THIS AREA
.115 ±.015
.14 REF
.02 R MAX
25°
.151±.003
7°30'±0°30'

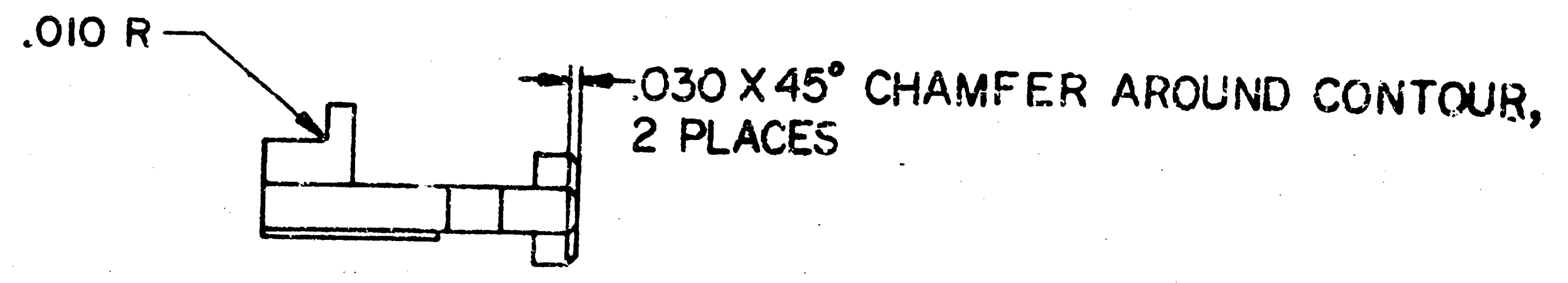

.38
FULL R 2 PLACES
.51±.02
.500
60° INCL 30 SERRATIONS PER INCH TYP
SERRATIONS (OPTIONAL)
FULL R
.005 MAX (PARTING LINE)


.020
.010 R
40°0'±0°30'

VIEW H
SCALE 30/1


MFG IDENT SYMBOL AND CAVITY IDENTIFICATION MARK .12 HIGH APPROX .005 MAX NEGATIVE ONLY IN APPROX POSITION SHOWN
.125 R
THIS SURFACE TO BE EITHER SIDE OF -B- .005 MAX
.100
.030
.078 R
-B-
.104 DIA+.003 THRU 90° CSK TO .13 DIA BOTH SIDES

VIEW E


.010 R
.030 X 45° CHAMFER AROUND CONTOUR, 2 PLACES

PART NO. 9327059

MECHANICAL PROPERTIES				
YS MIN				
YS MAX				
EL 2				
RA				
BH			XM231, PORT FIRING,	
RH	15N 89.5 -91.0	9327230	5.56MM, SMG	
		NEXT ASSY	USED ON	
		APPLICATION		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
ANGLES ±1°
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTE 7

DATE DEC 28, 1977
PREPARED
CHECKED
ENGINEER
SUBMITTED
APPROVED

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CATCH, BOLT

SIZE	CODE IDENT NO	DRAWING NO.
D	19200	9327059

SCALE 2/1
SHEET

AMSWE Form 6030 20 Jul 69

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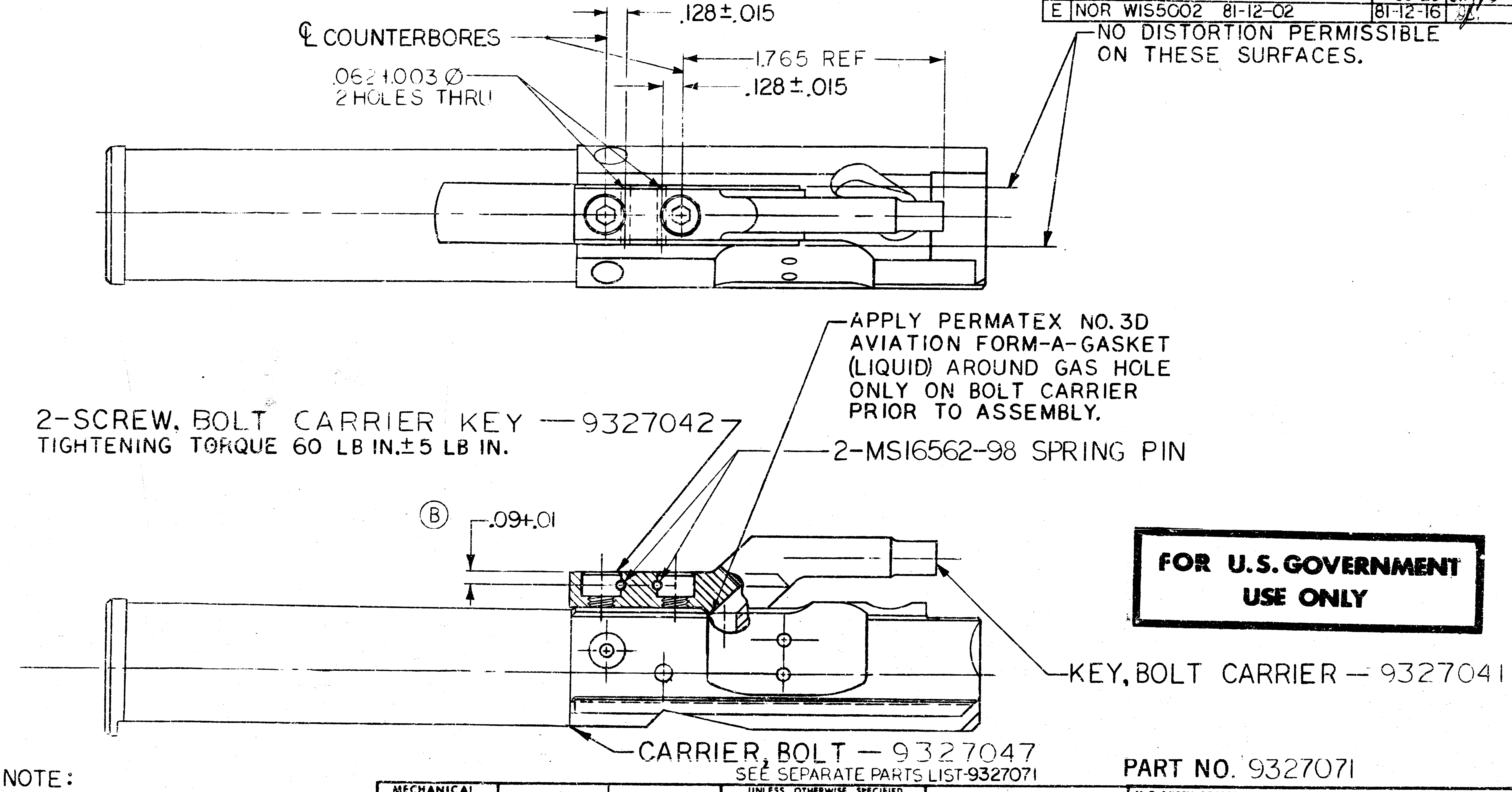
F	NORW2S2504 / 82-09-15	82-11-01	

REVISIONS

SYM	DESCRIPTION	DATE	APPROVED
A	2 SPRING PINS ADDED WITH DIM AND CALLOUTS	9-20-78	
B	REVISED DWG TO AGREE WITH LATEST ENGRING CHANGES	79-04-18	
C	ERR W9S 2505	79-07-16	
D	NOR WIS5000 81-05-11	81-05-29	
E	NOR WIS5002 81-12-02	81-12-16	


.128±.015
℄ COUNTERBORES
1.765 REF
.062±.003 Ø
2 HOLES THRU
.128±.015
NO DISTORTION PERMISSIBLE ON THESE SURFACES.
APPLY PERMATEX NO. 3D AVIATION FORM-A-GASKET (LIQUID) AROUND GAS HOLE ONLY ON BOLT CARRIER PRIOR TO ASSEMBLY.
2-SCREW, BOLT CARRIER KEY — 9327042
TIGHTENING TORQUE 60 LB IN.±5 LB IN.
2-MS16562-98 SPRING PIN
Ⓑ
.09±.01
KEY, BOLT CARRIER — 9327041
CARRIER, BOLT — 9327047

FOR U.S. GOVERNMENT USE ONLY

SEE SEPARATE PARTS LIST-9327071

PART NO. 9327071

NOTE:

1 – SPEC MIL-W-13855 AND Y14.5-1973 APPLY.

2 — APPLY FINISH NO. 30.7, MIL-STD-171 TO ALL EXTERNAL RUBBING SURFACES OF THE BOLT CARRIER AND THE BOLT CARRIER KEY IN THEIR ASSEMBLED CONFIGURATION

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			M231
BH			PORT FIRING,
		9327072	5.56MM, SMG
RH		NEXT ASSY	USED ON
		APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± —
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL
—

FINAL PROTECTIVE FINISH
—

DATE DEC 9, 1977
PREPARED W. W. B.
CHECKED
ENGINEER
SUBMITTED
APPROVED

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

KEY AND BOLT CARRIER ASSEMBLY

SIZE	CODE IDENT NO.	DRAWING NO.
C	19200	9327071

SCALE 2/1 SHEET OF

AMSWE Form 403C, 29 Jul 69

DRAWING SIZE D
(ARRADCOMR 70-12)

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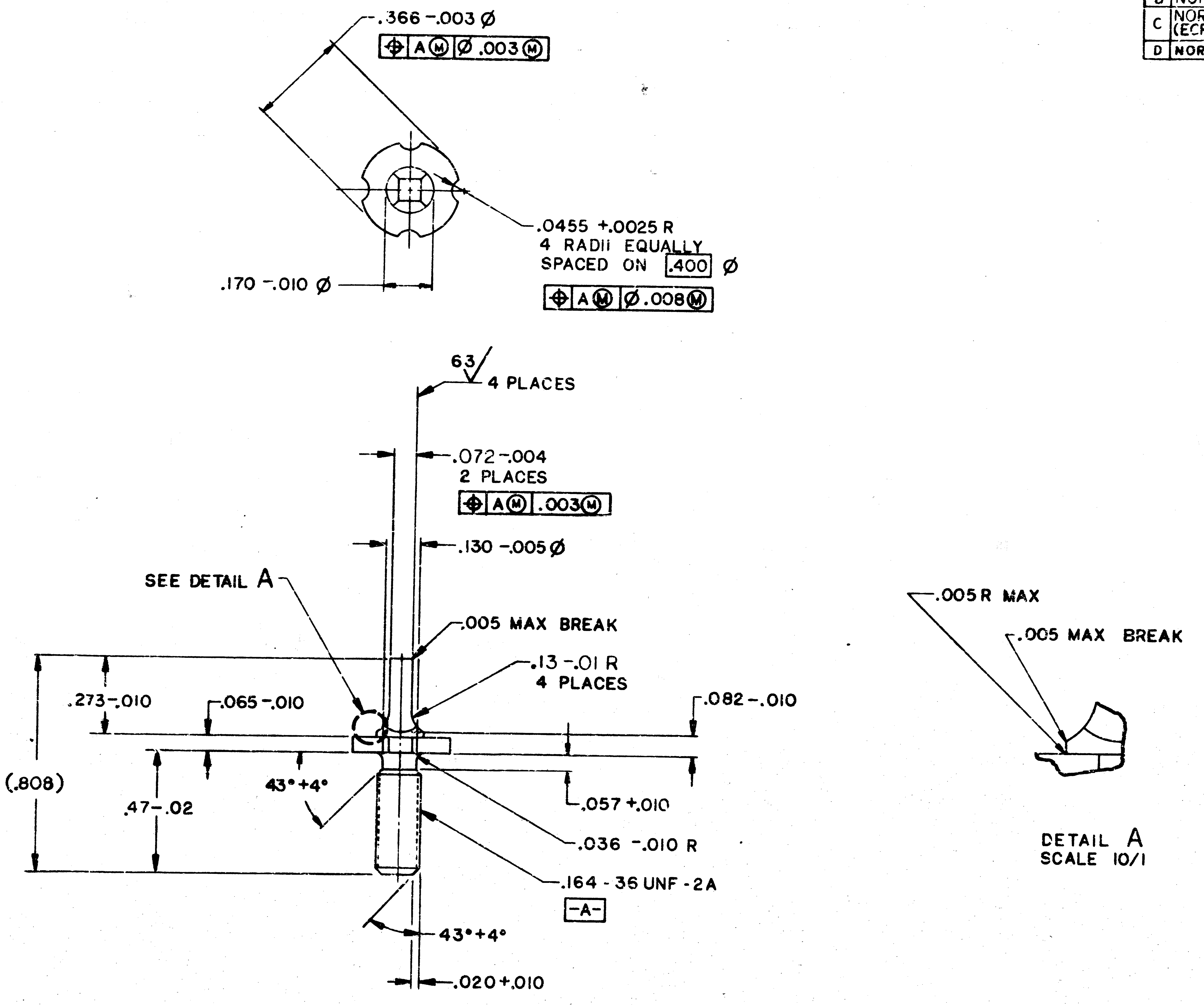
NOTES: —

1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL:- STEEL, COLD DRAWN BAR CMPSN 1117 THRU 1144, SPEC ASTM-A108.
ALTERNATE MATERIAL: STEEL AISI 1117.
3- ALL DIMENSIONS ARE BEFORE PROTECTIVE FINISH.
4- BREAK SHARP EDGES .005+.010 EXCEPT AS NOTED.
5- FILLET RADII .015-.012
6- FINISH 125√ ALL OVER
7- PROTECTIVE FINISH:- 5.3.1.2 OF MIL-STD-171.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S2016 / 84-05-13	84-06-07	R. Holl
B	NORW2S3258/82-12-30	840904	R. N. D.
C	NORW4S3014/84-06-01 (ECPW4S3024/84-07-24)	841004	R. Holl
D	NOR W4S0030 / 84-11-15	850402	



.366 -.003 Ø
⌖ A Ⓜ Ø .003 Ⓜ
.0455 +.0025 R
4 RADII EQUALLY
SPACED ON .400 Ø
⌖ A Ⓜ Ø .008 Ⓜ
.170 -.010 Ø
63√ 4 PLACES
.072 -.004
2 PLACES
⌖ A Ⓜ .003 Ⓜ
.130 -.005 Ø
SEE DETAIL A
.005 MAX BREAK
.13 -.01 R
4 PLACES
.273 -.010
.065 -.010
.082 -.010
(.808)
.47 -.02
43° +4°
.057 +.010
.036 -.010 R
.164 - 36 UNF - 2A
-A-
43° +4°
.020 +.010
.005 R MAX
.005 MAX BREAK
DETAIL A
SCALE 10/1

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING
		YP		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
		TS		TOLERANCES ON DECIMALS ±
		ELG		FRACTIONS ± ANGLES ±
		RA		
9349050	M16A2	BH		
NEXT ASSY	USED ON	RH		
APPLICATION				

PART NO. 9349056

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN M M
CHECKER JWH
ENGR
ENGR
ENGR
ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

POST, FRONT SIGHT

SIZE D
FSCM NO. 19200
9349056
SCALE 4/1
UNIT WT.
SHEET 1 OF 1

ARRADCOM FORM 60 AUG 77 REPLACES DARCOM FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED

DRAWING SIZE D
(ARRADCOMR 70-12)

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW4S 3021/84-07-24	841030	HW
B	NORW4S 0030 / 84-11-15	850402	HW EB
C	NORW4S 3071 / 85-02-08	850621	HW
D	NORW5S3050/85-12-11	870218	
E	NORG1S2018/ 91-07-08	91-10-11	RE
F	NORG3S3110 93-11-30	940323	

NOTES:-

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 -- MAKE FROM FRONT SIGHT FORGING-8448643.

3 — ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH.

4 — PLANE -B- IS ESTABLISHED BY DIAMETER -C- AND WIDTH -D-.

5 — .005 MAX MISMATCH BETWEEN ADJACENT SURFACES GENERATED BY -K- AND -L-.

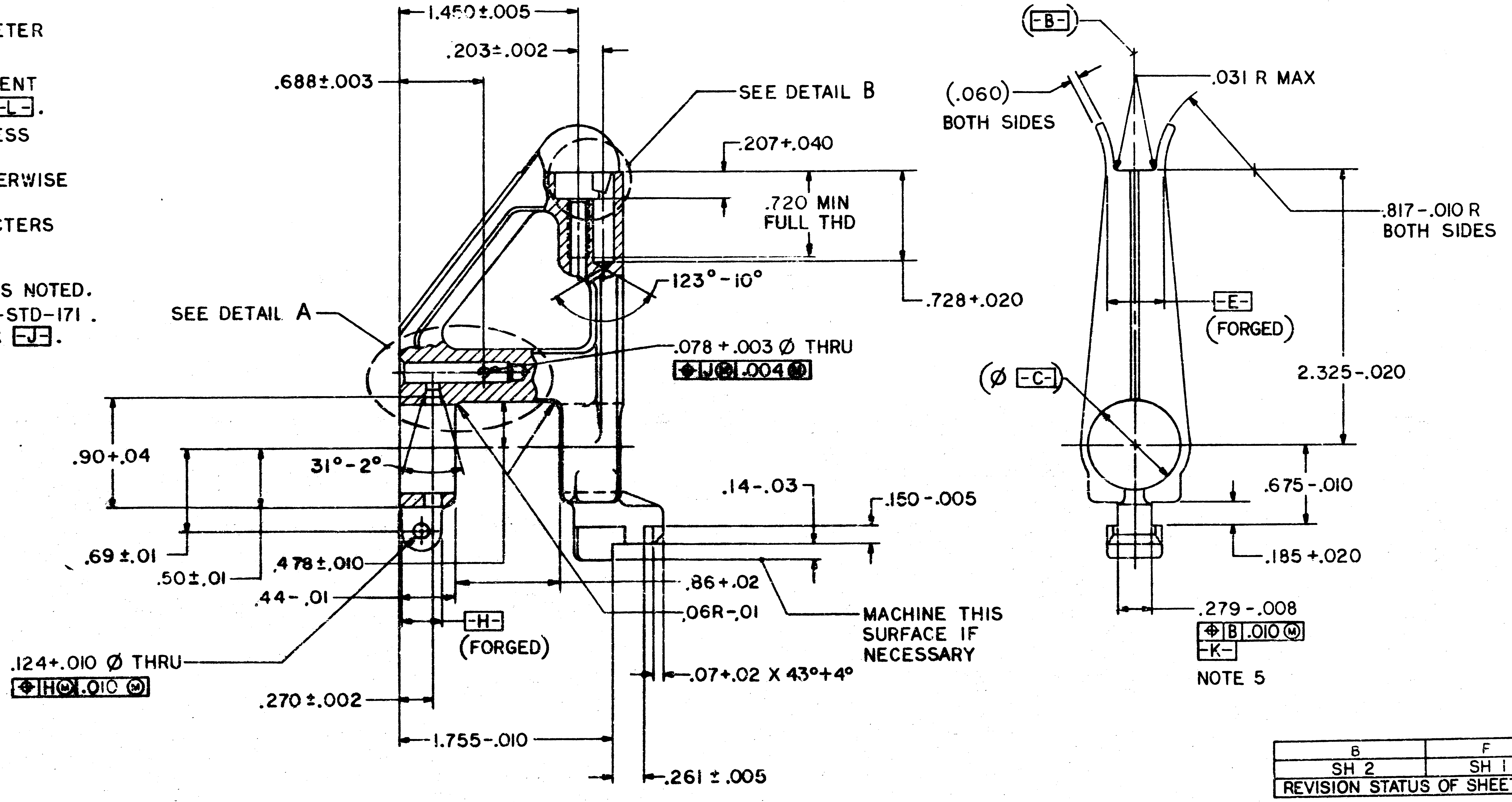
6 — BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE NOTED.

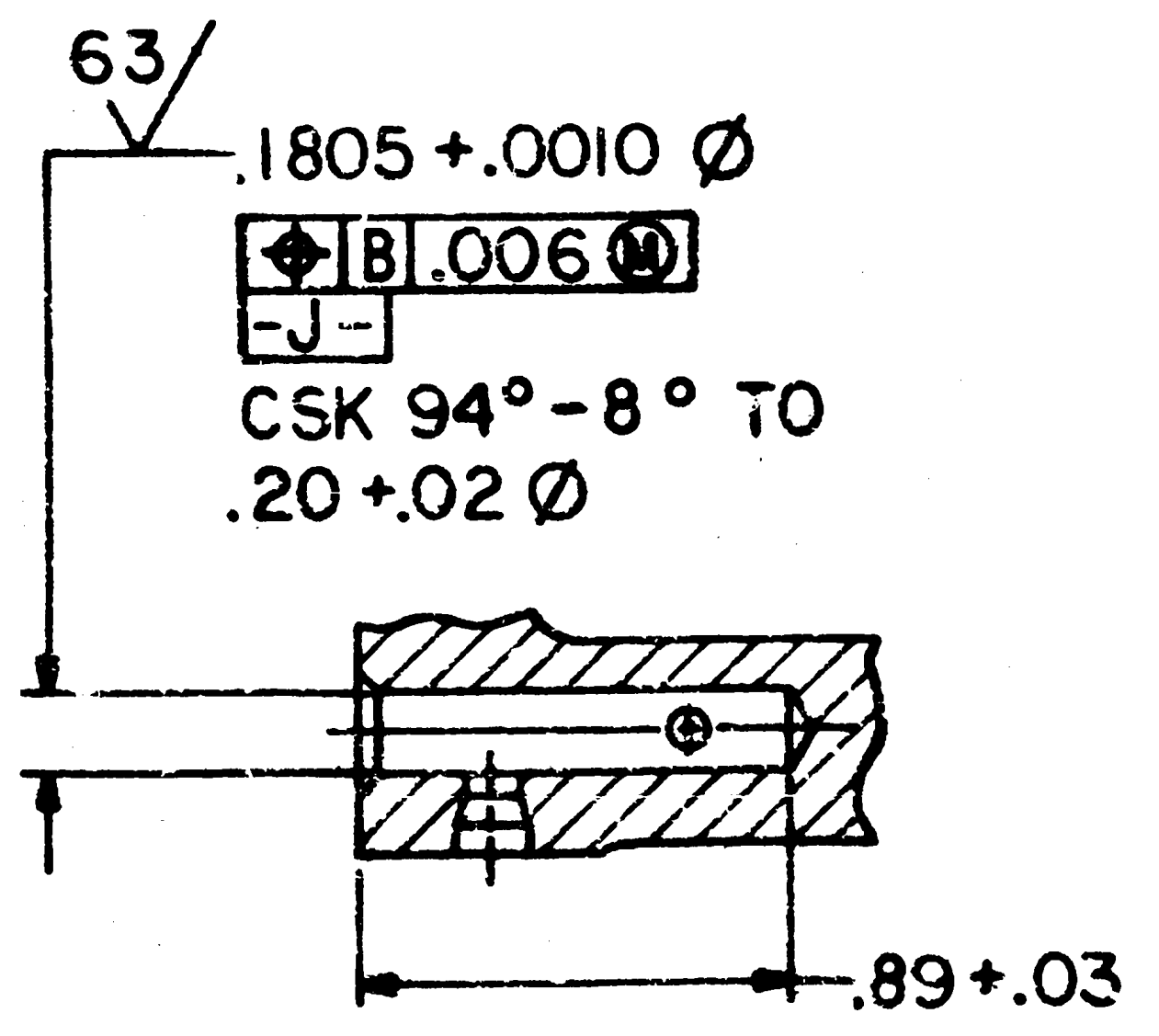
7 — FILLET RADII .015 -.012 UNLESS OTHERWISE NOTED.

8 — MARK WITH .094 ± .015 HIGH CHARACTERS .005 +.010 DEEP, IN POSITION SHOWN.

9 — FINISH 125/√ ALL SURFACES, EXCEPT AS NOTED.

10 — PROTECTIVE FINISH: -5.3.1.2 OF MIL-STD-171. BEFORE GRIT BLAST, MASK DIAMETER -J-.


1.450±.005
.203±.002
.688±.003
SEE DETAIL B
.207+.040
.720 MIN
FULL THD
123°-10°
.728+.020
SEE DETAIL A
.078+.003 Ø THRU
⊕ J Ⓜ .004 Ⓜ
.90+.04
31°-2°
.69±.01
.50±.01
.478±.010
.44-.01
.14-.03
.150-.005
.86+.02
.06R-.01
-H-
(FORGED)
MACHINE THIS
SURFACE IF
NECESSARY
.124+.010 Ø THRU
⊕ H Ⓜ .010 Ⓜ
.270±.002
.07+.02 X 43°+4°
1.755-.010
.261±.005
-B-
(.060)
BOTH SIDES
.031 R MAX
.817-.010 R
BOTH SIDES
-E-
(FORGED)
(Ø -C-)
2.325-.020
.675-.010
.185+.020
.279-.008
⊕ B .010 Ⓜ
-K-
NOTE 5


63/
.1805+.0010 Ø
⊕ B .006 Ⓜ
-J-
CSK 94°-8° TO
.20+.02 Ø
.89+.03

DETAIL A
ALTERNATIVE METHOD

DISTRIBUTION STATEMENT F

FURTHER DISSEMINATION ONLY AS DIRECTED BY SMCRI-IMO-DR; 93-09-14 OR HIGHER DoD AUTHORITY.

B	F
SH 2	SH 1

REVISION STATUS OF SHEETS

PART NO. 9349058

NEXT ASSY	USED ON
9390008	M4
9349057	M16A1E1

APPLICATION

MECHANICAL PROPERTIES
YP
TS
EL
RA
BH
BH

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN SMI
CHECKER JWH
ENGR
ENGR
ENGR
ENGR
Robert J. McGuf

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SIGHT, FRONT

SIZE D
FSCM NO. 19200
9349058
SCALE 2/1
UNIT WT.
SHEET 1 OF 2

ARRADCOM FORM 66 AUG 77 REPLACES [illegible]

DRAWING SIZE D
(ARRADCOMR 79-12)

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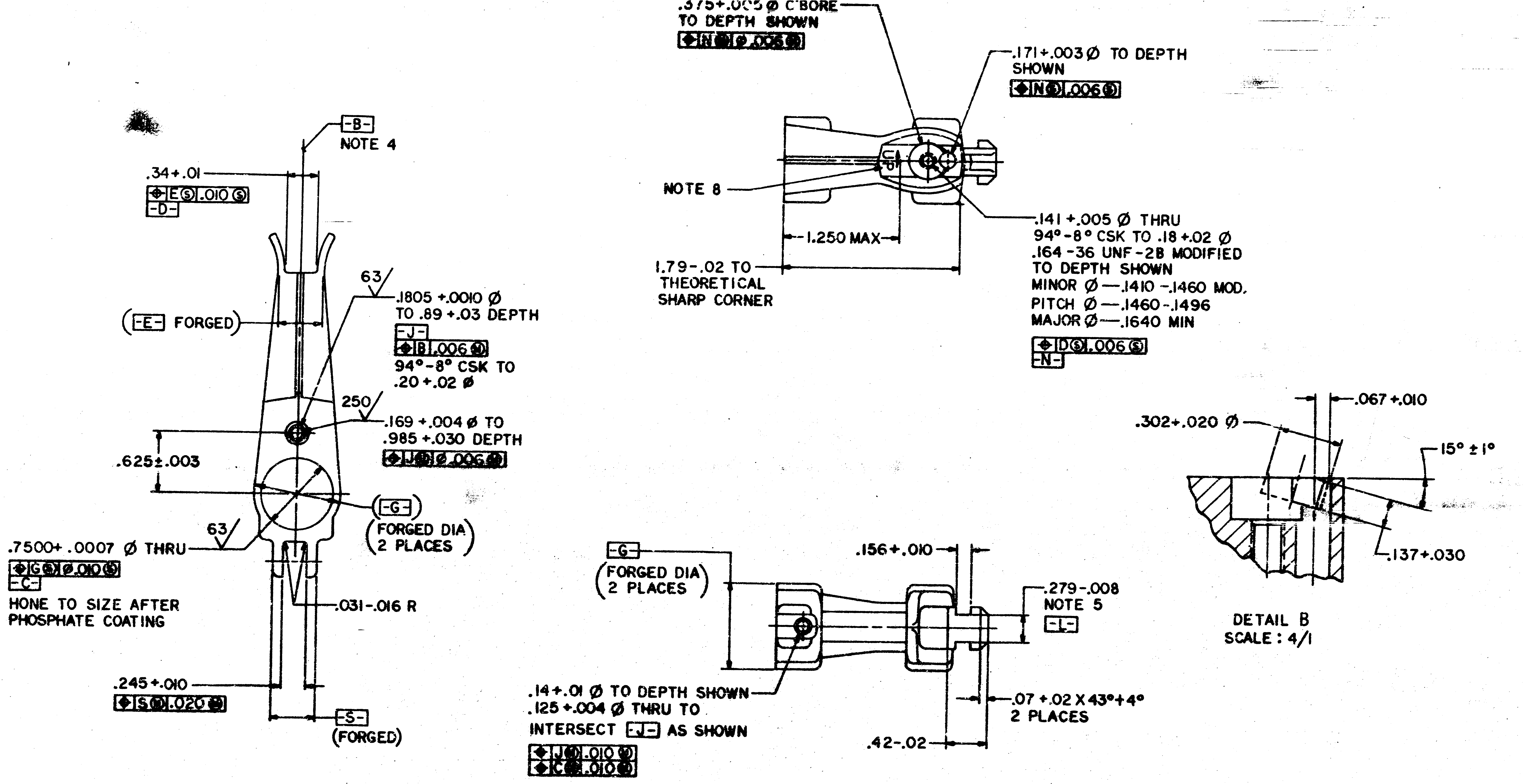
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W4S3021/84-07-24	841030	RW R.A.G.
B	NOR W4S0030/84-11-15	850402	RW


.375+.005 Ø C'BORE
TO DEPTH SHOWN
◆ N Ⓜ Ø .005 Ⓜ
.171+.003 Ø TO DEPTH
SHOWN
◆ N Ⓢ .006 Ⓢ
NOTE 8
1.250 MAX
1.79-.02 TO
THEORETICAL
SHARP CORNER
.141 +.005 Ø THRU
94°-8° CSK TO .18 +.02 Ø
.164-36 UNF-2B MODIFIED
TO DEPTH SHOWN
MINOR Ø—.1410-.1460 MOD.
PITCH Ø—.1460-.1496
MAJOR Ø—.1640 MIN
◆ D Ⓢ .006 Ⓢ
-N-
-B-
NOTE 4
.34+.01
◆ E Ⓢ .010 Ⓢ
-D-
63
.1805 +.0010 Ø
TO .89 +.03 DEPTH
-J-
◆ B .006 Ⓜ
94°-8° CSK TO
.20 +.02 Ø
(-E- FORGED)
250
.169 +.004 Ø TO
.985 +.030 DEPTH
◆ J Ⓜ Ø .006 Ⓜ
.625±.003
(-G-)
(FORGED DIA
2 PLACES)
63
.7500+.0007 Ø THRU
◆ G Ⓢ Ø .010 Ⓢ
-C-
HONE TO SIZE AFTER
PHOSPHATE COATING
.031-.016 R
.245+.010
◆ S Ⓜ .020 Ⓜ
-S-
(FORGED)
.067 +.010
.302+.020 Ø
15° ± 1°
.137+.030
DETAIL B
SCALE: 4/1
-G-
(FORGED DIA
2 PLACES)
.156+.010
.279-.008
NOTE 5
-L-
.14+.01 Ø TO DEPTH SHOWN
.125 +.004 Ø THRU TO
INTERSECT -J- AS SHOWN
◆ J Ⓜ .010 Ⓜ
◆ C Ⓜ .010 Ⓜ
.07 +.02 X 43°+4°
2 PLACES
.42-.02

PART NO. 9349058

MECHANICAL PROPERTIES	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±	ORIGINAL DATE OF DRAWING 82-06-09 DRAFTSMAN SMI CHECKER UWH	U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801
NEXT ASSY USED ON APPLICATION		Robert J. McC[illegible]	SIGHT, FRONT

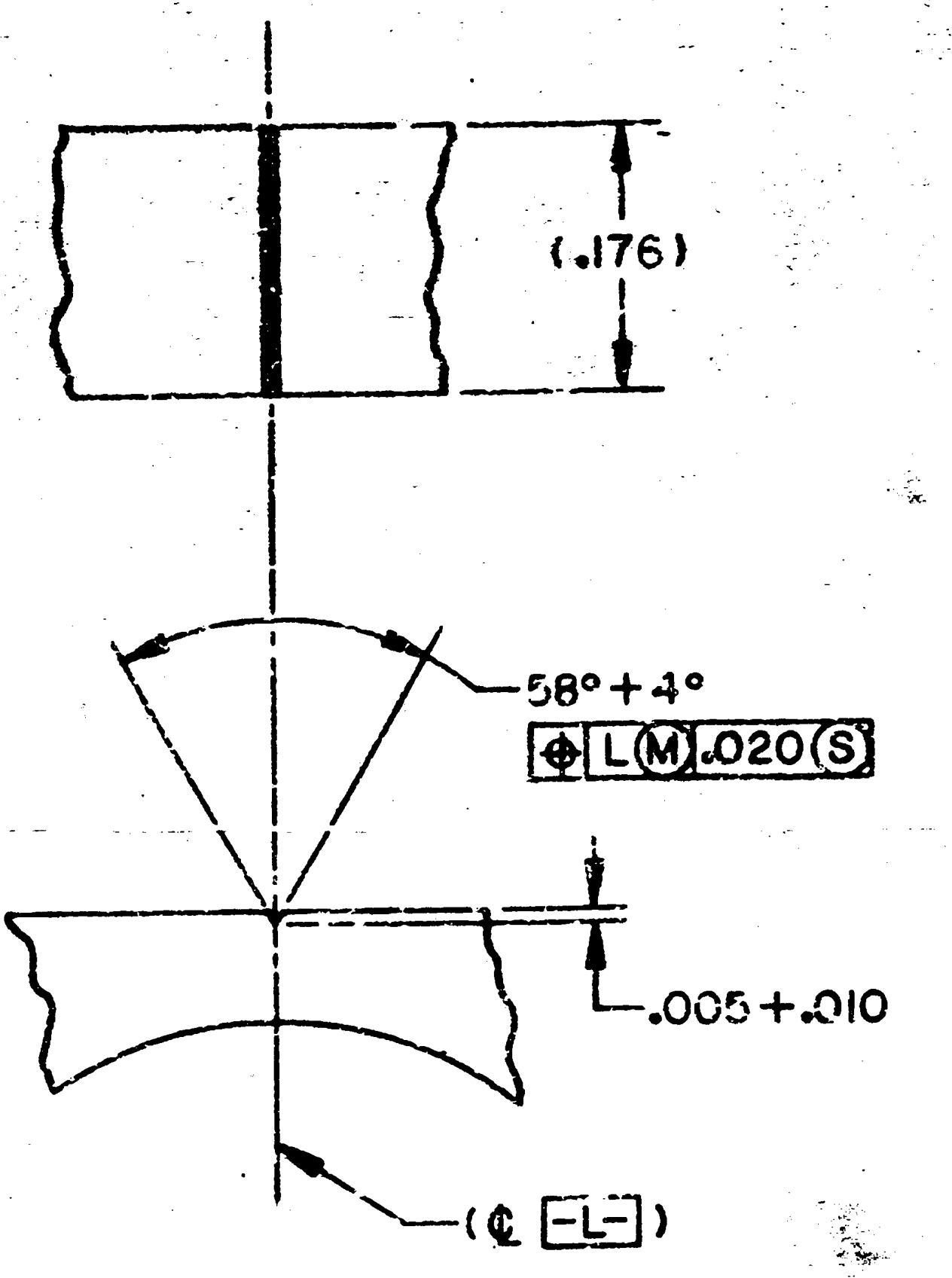
SIZE D FSCM NO. 19200 9349058

SCALE 2/1 UNIT WT. SHEET 2

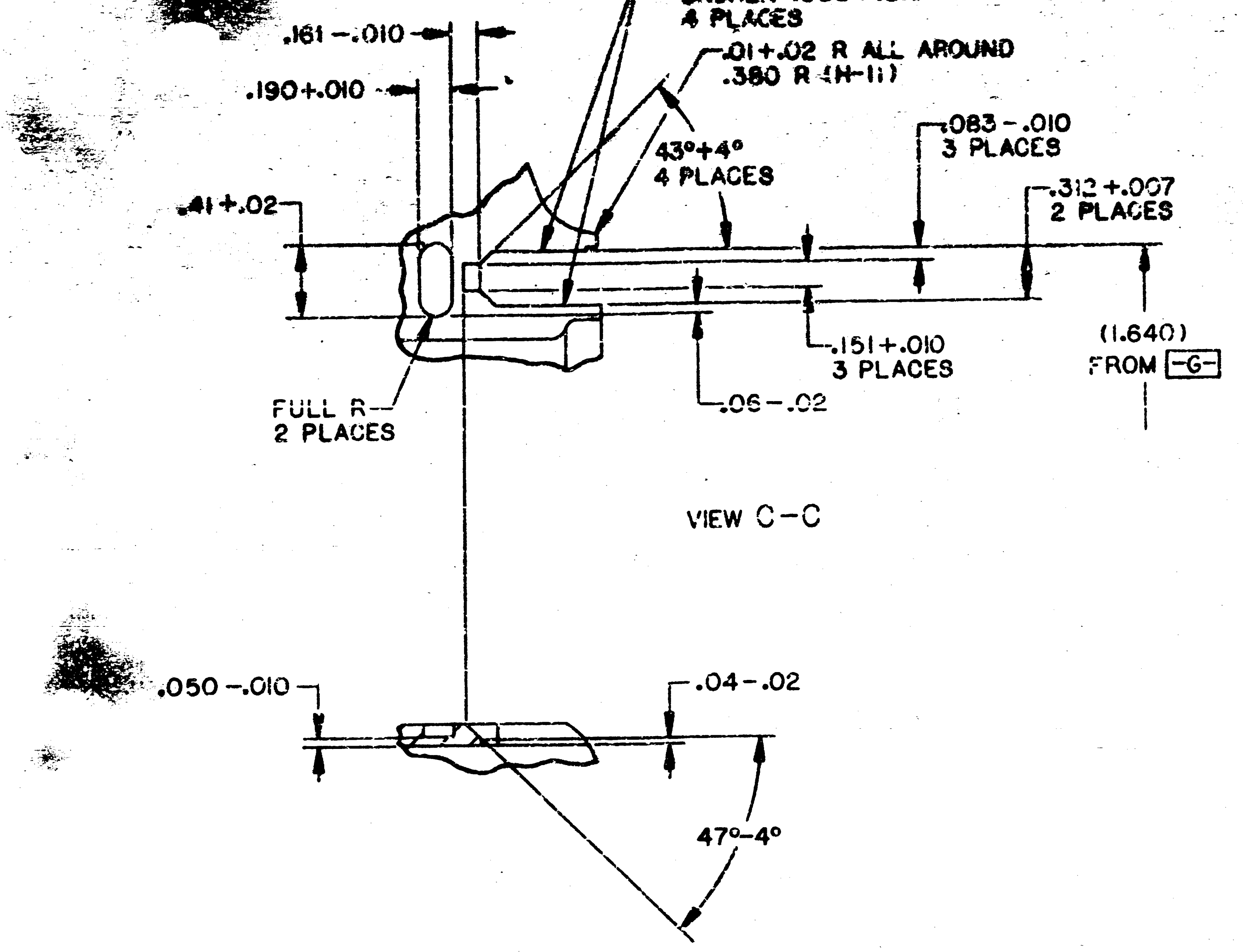
[illegible]

NOTES:-

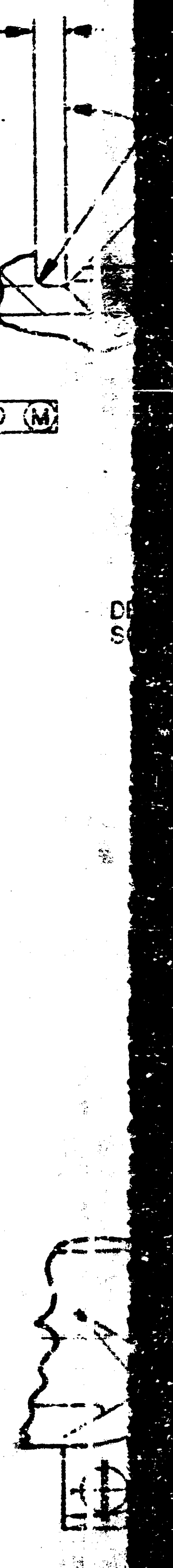
1 — SPEC MIL-W-13855 AND ANSI Y14.5 - 73 APPLY.
2 — MATERIAL:- MAKE FROM FORGING, UPPER RECEIVER -9349064.
3 — CENTER LINE -D- (G-6) AND -J- (D-5) ARE ESTABLISHED WHEN LOCATING ON Ø -C-, AND SLOT -F- AT AREA -M- (D-18).
4 — WITNESS MARK (H-9) TO DETERMINE STARTING POINT FOR MACHINING.
5 — ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
6 — BREAK SHARP EDGES .005 + .010 UNLESS OTHERWISE NOTED.
7 — FILLET RADII .015 – .012 UNLESS OTHERWISE NOTED.
8 — EVERLUBE 626 OR 626S CURED AT 275° F ± 25° F FOR 1 HOUR OR MIL-L-46010 CURED 300°F TO 325°F FOR 2 HOURS, TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .875 TO 1.25 LENGTH (B-16). FILM THICKNESS .0002 + .0001.
9 — FINISH 125√ ALL MACHINED SURFACES, EXCEPT AS NOTED.
10 — PROTECTIVE FINISH:- MIL-A-8625. TYPE III CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, 36076, TABLE VIII OF FED-STD-595 AND SEAL. GRIT BLAST PRIOR TO FINISH TO PROVIDE NON REFLECTIVE MATTE SURFACE AFTER FINISH.


(.176)
58° + 4°
⌖ L Ⓜ .020 Ⓢ
.005 + .010
(℄ -L-)

DETAIL A
SCALE: 10/1

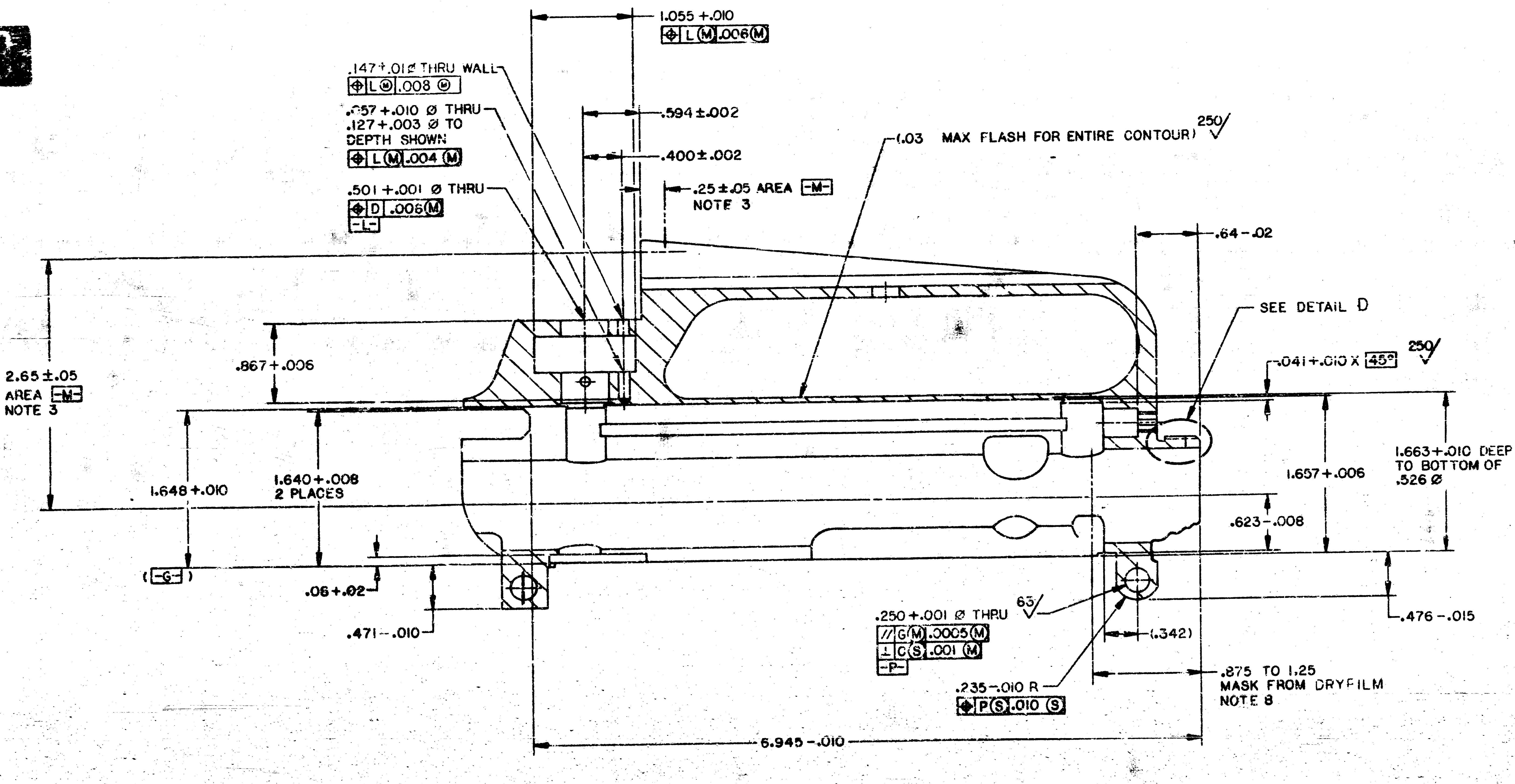

ALL CORNERS IN THIS AREA MUST BE BROKEN .005 + .010 4 PLACES
.161 – .010
.190 + .010
.01 + .02 R ALL AROUND .380 R (H-11)
43° + 4° 4 PLACES
.083 – .010 3 PLACES
.312 + .007 2 PLACES
.41 + .02
.151 + .010 3 PLACES
(1.640) FROM -G-
.06 – .02
FULL R 2 PLACES
.050 – .010
.04 – .02
47° – 4°

VIEW C–C


.07 + .02
1.175 – .010 Ø
⌖ C Ⓢ Ø .010 Ⓜ

J9349[illegible]6[illegible]

F-[illegible]


1.055 + .010
⌖ L Ⓜ .006 Ⓜ
.147 + .01 Ø THRU WALL
⌖ L Ⓜ .008 Ⓜ
.057 + .010 Ø THRU .127 + .003 Ø TO DEPTH SHOWN
⌖ L Ⓜ .004 Ⓜ
.594 ± .002
.400 ± .002
.501 + .001 Ø THRU
⌖ D .006 Ⓜ
-L-
.25 ± .05 AREA -M- NOTE 3
(.03 MAX FLASH FOR ENTIRE CONTOUR) 250√
.64 – .02
SEE DETAIL D
.041 + .010 X 45°
250√
2.65 ± .05 AREA -M- NOTE 3
.867 + .006
1.648 + .010
1.640 + .008 2 PLACES
1.663 + .010 DEEP TO BOTTOM OF .526 Ø
1.657 + .006
.623 – .008
(-G-)
.06 + .02
.471 – .010
.476 – .015
.250 + .001 Ø THRU
63√
// G Ⓜ .0005 Ⓜ
⊥ C Ⓢ .001 Ⓜ
-P-
(.342)
.235 – .010 R
⌖ P Ⓢ .010 Ⓢ
.875 TO 1.25 MASK FROM DRYFILM NOTE 8
6.945 – .010

SECTION B–B

DWG NO 9349063 SHT REV

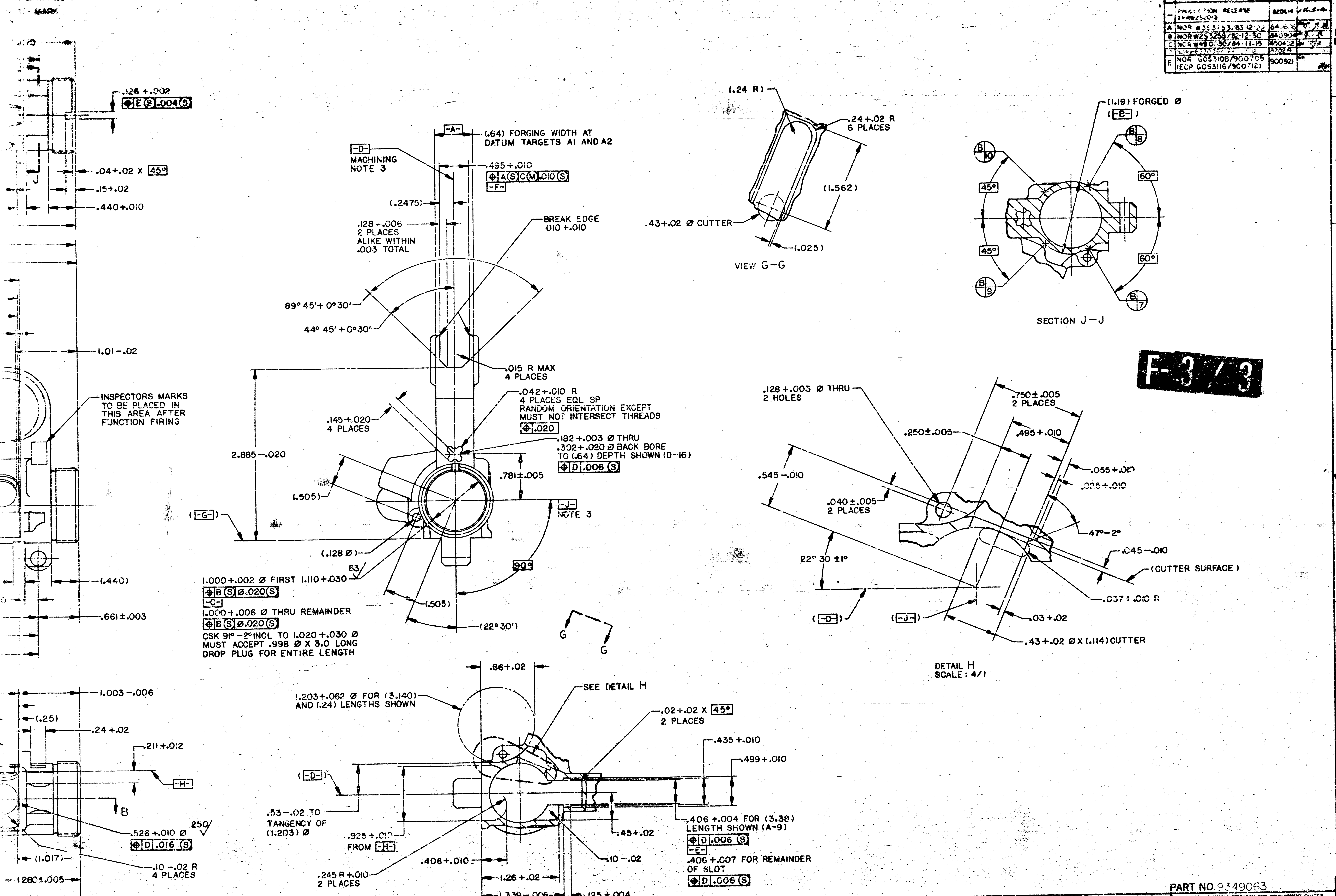
.07+.02
.04-.02 R
44°+2°
1.175-.010 Ø
⊕ C Ⓢ Ø .010 Ⓜ
1.250 - 18 UNEF - 2AG
MAJOR Ø 1.2473 - 1.2390 SPL BEFORE COATING
PITCH Ø 1.2100 - 1.2059 SPL BEFORE COATING
MINOR Ø 1.1731 MAX SPL BEFORE COATING
⊕ C Ⓢ Ø .006 Ⓢ
MAJOR Ø 1.2485 - 1.2398 AFTER COATING
PITCH Ø 1.2124 - 1.2075 AFTER COATING
MINOR Ø 1.1803 MAX AFTER COATING
DETAIL D
SCALE: 4/1
(1.19) FORGED Ø
-B-
60°
45°
SECTION E - E
.015+.010
SEE DETAIL A
.380-.010 R
.06 MAX FLAT PERMISSIBLE
1.0285±.0050
20°±1°
.160-.010
.65±.01
.1560±.0025
.094+.003 Ø
.506+.006 Ø TO DEPTH SHOWN
⊕ K Ⓢ Ø .005 Ⓢ
.314+.002 Ø
⊕ J .010 Ⓢ
-K-
.960
(-N-) (C-10)
.820
(2.27)
3.650
℄ WITNESS MARK NOTE 4
1.945±.010
.126+.002
⊕ E Ⓢ .004 Ⓢ
.281+.005 Ø THRU
⊕ F Ⓢ .010 Ⓜ
(.015)
.16-.02
.04+.02 X 45°
.15+.02
.440+.010
3.19±.01
5.778-.010
5.035
3.140+.010
3.120+.010
.125 Ø 2 PLACES
.005+.010
.010-.010
1.562±.010
.037+.010
1.01-.02
(.594)
.093+.004 Ø THRU
⊕ L Ⓜ .010 Ⓜ
.0920 GAGE MUST PASS THRU BOTH SIDES SIMULTANEOUSLY
INSPECTORS MARKS TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
2.500
1.948 .008
1.304±.003
1.772+.008
.380+.006
.005 MAX R MISMATCH 2 PLACES
.627-.004
.03 MAX STEP PERMISSIBLE
-G-
.2525±.0015
.250+.002 Ø THRU C'SINK .30+.02 Ø X 88°+4° INCL THIS SIDE ONLY, WITH (.017) CUTTER TRAVEL SHOWN
// G Ⓜ .0005 Ⓜ
63
.462-.020
.017+.008 CUTTER TRAVEL
.15+.06
.220-.010
(.440)
.661±.003
6.365±.005
6.604-.014
6.999-.006
(-F-)
(2.65)
C
.041+.010 X 45°
(-C-)
1.665+.010 DEPTH OF .526 AND .586 DIMENSIONS
.755+.010 R 2 PLACES
(1.165) R 2 PLACES
.010 R MAX 4 PLACES
47°-4° 2 PLACES OPTIONAL ON FRONT LUG
.41-.02 2 PLACES OPTIONAL ON FRONT LUG
(.413 FOR 1.320 LENGTH)
.496-.003 BOTH LUGS
⊕ D .006 Ⓢ
SEE DETAIL D
.04+.010 X 45°
250
1.857+.006
1.663+.010 DEEP TO BOTTOM OF .526 Ø
.476-.015
DRYFILM
1.60±.01
.34+.02 CUTTER TRAVEL
.13-.02 R
.74+.02 Ø SPOTFACE TO .08+.02 DEPTH AND (.34) TRAVEL SHOWN
-N- (H-9)
3.03+.02
.33+.02
1.003-.006
(℄.10 R)
(.25)
.24+.02
.211+.012
-H-
.413+.010 FOR 1.320+.010 LENGTH
⊕ E Ⓢ .006 Ⓢ
.79+.02
⊕ D .015 Ⓢ
B
F
.526+.010
⊕ D .010 Ⓢ
.255-.030 R 4 PLACES
.49+.02
⊕ D .010 Ⓢ
.30+.02 R 2 PLACES
.526+.010 Ø
⊕ D .016 Ⓢ
.10-.02 R 4 PLACES
(1.017)
.045+.010
1.290±.005
3.38 MIN
(.89)
(1.012)
.586+.020
1.900±.005
6.648+.028
89° 45'
44°
2.885-.020
(-G-)
.505
1.000+.002 Ø FIRST 1.110
⊕ B Ⓢ Ø .020 Ⓢ
-C-
1.000+.005 Ø THRU REMAI
⊕ B Ⓢ Ø .020 Ⓢ
CSK 91°-2° INCL TO 1.020
MUST ACCEPT .996 Ø X 3.
DROP PLUG FOR ENTIRE LEN
1.203
(-D-)
.53-.02 TO TANGENCY OF (1.203) Ø

J9349063

F-273

DWG NO 9349063 SH REV

–	PRODUCTION RELEASE ERR W25S013	820614	
A	NOR W3S3153/83-12-22	84	
B	NOR W2S3258/82-12-30	84090	
C	NOR W4S0030/84-11-15	850402	
D	[illegible]	870219	
E	NOR G0S3108/900705 (ECP G0S3116/900712)	900921	



.126 +.002
⊕ E Ⓢ .004 Ⓢ
.04+.02 X 45°
.15+.02
.440+.010
J
1.01-.02
INSPECTORS MARKS TO BE PLACED IN THIS AREA AFTER FUNCTION FIRING
(.440)
.661±.003
1.003-.006
(.25)
.24+.02
.211+.012
-H-
B
.526+.010 Ø
⊕ D .016 Ⓢ
250
(1.017)
.10-.02 R 4 PLACES
1.280±.005
.00±.005
-A-
(.64) FORGING WIDTH AT DATUM TARGETS A1 AND A2
-D- MACHINING NOTE 3
.495+.010
⊕ A Ⓢ C Ⓜ .010 Ⓢ
-F-
(.2475)
.128-.006 2 PLACES ALIKE WITHIN .003 TOTAL
BREAK EDGE .010+.010
89° 45'+0°30'
44° 45'+0°30'
.015 R MAX 4 PLACES
.042+.010 R 4 PLACES EQL SP RANDOM ORIENTATION EXCEPT MUST NOT INTERSECT THREADS
⊕ .020
.145+.020 4 PLACES
.182+.003 Ø THRU .302+.020 Ø BACK BORE TO (.64) DEPTH SHOWN (D-16)
⊕ D .006 Ⓢ
2.885-.020
.781±.005
(.505)
-J- NOTE 3
(-G-)
(.128 Ø)
63
90°
1.000+.002 Ø FIRST 1.110+.030
⊕ B Ⓢ Ø.020 Ⓢ
-C-
1.000+.006 Ø THRU REMAINDER
⊕ B Ⓢ Ø.020 Ⓢ
CSK 91°-2° INCL TO 1.020+.030 Ø MUST ACCEPT .998 Ø X 3.0 LONG DROP PLUG FOR ENTIRE LENGTH
(.505)
(22°30')
G
G
(.24 R)
.24+.02 R 6 PLACES
(1.562)
.43+.02 Ø CUTTER
(.025)
VIEW G-G
(1.19) FORGED Ø
(-B-)
B 10
B 8
45°
60°
45°
60°
B 9
B 7
SECTION J-J
F-3/3
.128+.003 Ø THRU 2 HOLES
.750±.005 2 PLACES
.250±.005
.495+.010
.545-.010
.055+.010
.025+.010
.040±.005 2 PLACES
47°-2°
.045-.010
(CUTTER SURFACE)
22° 30 ±1°
.037+.010 R
(-D-)
(-J-)
.03+.02
.43+.02 Ø X (.114) CUTTER
DETAIL H SCALE: 4/1
.86+.02
SEE DETAIL H
1.203+.062 Ø FOR (3.140) AND (.24) LENGTHS SHOWN
.02+.02 X 45° 2 PLACES
.435+.010
.499+.010
(-D-)
.53-.02 TO TANGENCY OF (1.203) Ø
.925+.010 FROM -H-
.45+.02
.406+.010
.10-.02
.406+.004 FOR (3.38) LENGTH SHOWN (A-9)
⊕ D .006 Ⓢ
-E-
.406+.007 FOR REMAINDER OF SLOT
⊕ D .006 Ⓢ
.245 R+.010 2 PLACES
1.26+.02
1.339-.006
.125+.004
SECTION F-F
9349063

PART NO. 9349063

		MECHANICAL PROPERTIES	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING 82-06-08	U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER NEW JERSEY 07801
		YP	TOLERANCES ON DECIMALS ±	DRAFTSMAN SMI	CHECKER JWH
		TS	FRACTIONS ± ANGLES ±	ENGR	ENGR
		EL2		ENGR	ENGR
		RA			RECEIVER, UPPER
		BH			SIZE J FSCM NO. 19200 9349063
9349062	M16A2	RH			SCALE 2/1 UNIT WT SHEET 1 OF 1
NEXT ASSY	USED ON				
APPLICATION					

3-FR

NOTICE: [illegible]

[illegible]

NOTES:-

1 — SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 — MATERIAL:-ALUMINUM ALLOY 7075. FORGE PER SPEC. QQ-A-367 TO COND T6. MIN BRINELL HARDNESS 135 TH 500 KG LOAD.

3 — ALL DIMENSIONS ARE GIVEN TO THEORETICAL SHARP CORNERS. SEE DETAIL A.

4 — 4° MAX DRAFT ANGLE UNLESS OTHERWISE NOTED.

5 — CORNER RADII .05+.03 UNLESS OTHERWISE NOTED.

6 — FILLET RADII .08-.03 UNLESS OTHERWISE NOTED.

7 — FLASH EXTENSION .03 MAX.

8 — MISMATCH .020 MAX.

9 — ALL DIMENSIONS ± .020 UNLESS OTHERWISE NOTED.

10 — ALL ANGLES ± 0°30′ UNLESS OTHERWISE NOTED.

11 — DIMENSIONED RADII TO BE $^{+.02}_{-.01}$ UNLESS OTHERWISE NOTED.

12 — ALL DIMENSIONS ⊕ Ø.020 (S) TO THE PLANES ESTABLISHED BY THE ℄ -A- (G-7) AND THE ℄ OF -B- (A-12).

13 — CONICAL ABOUT ℄ OF -B-. SEE SECTION F-F.

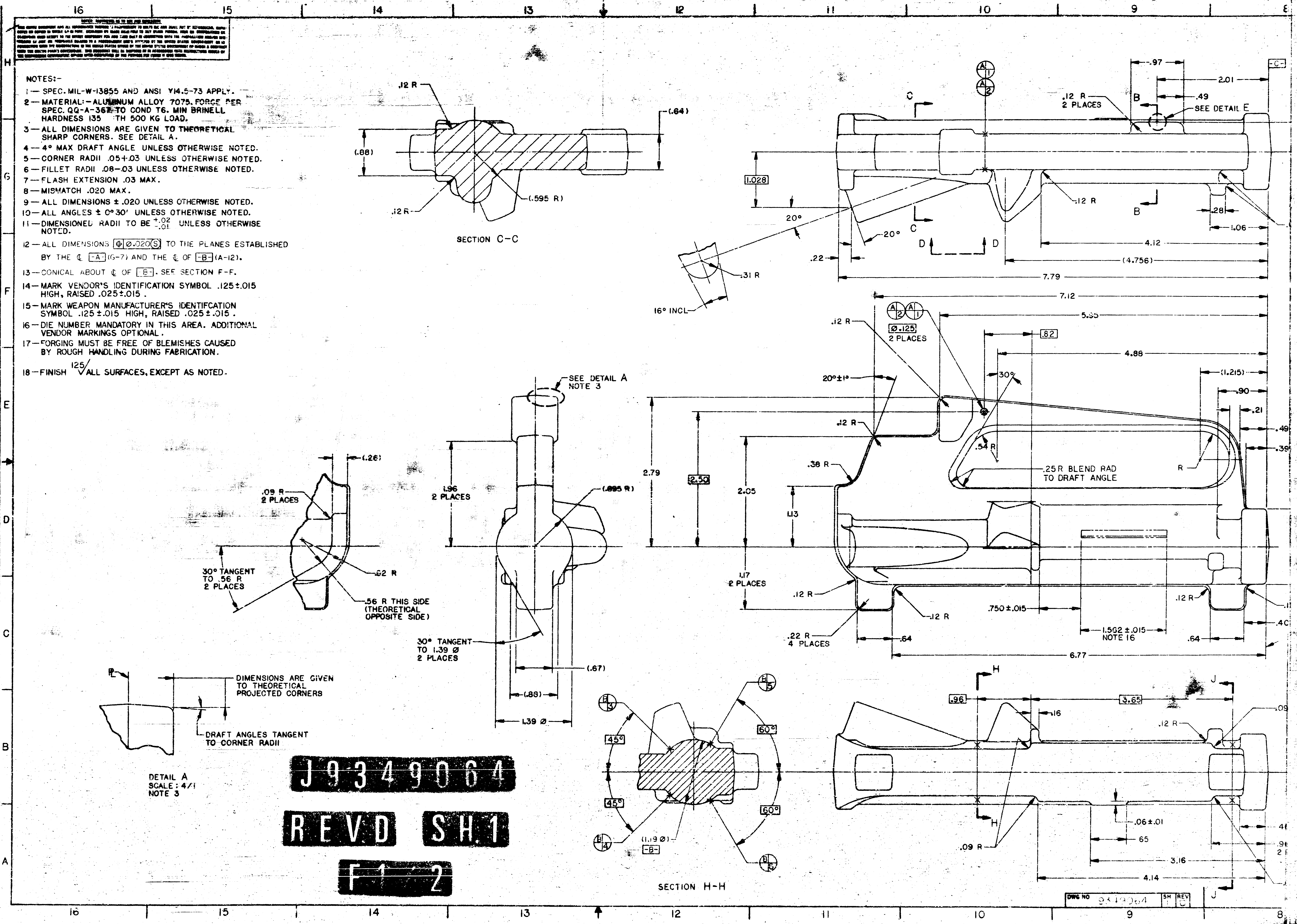
14 — MARK VENDOR'S IDENTIFICATION SYMBOL .125±.015 HIGH, RAISED .025±.015 .

15 — MARK WEAPON MANUFACTURER'S IDENTIFCATION SYMBOL .125±.015 HIGH, RAISED .025±.015 .

16 — DIE NUMBER MANDATORY IN THIS AREA. ADDITIONAL VENDOR MARKINGS OPTIONAL.

17 — FORGING MUST BE FREE OF BLEMISHES CAUSED BY ROUGH HANDLING DURING FABRICATION.

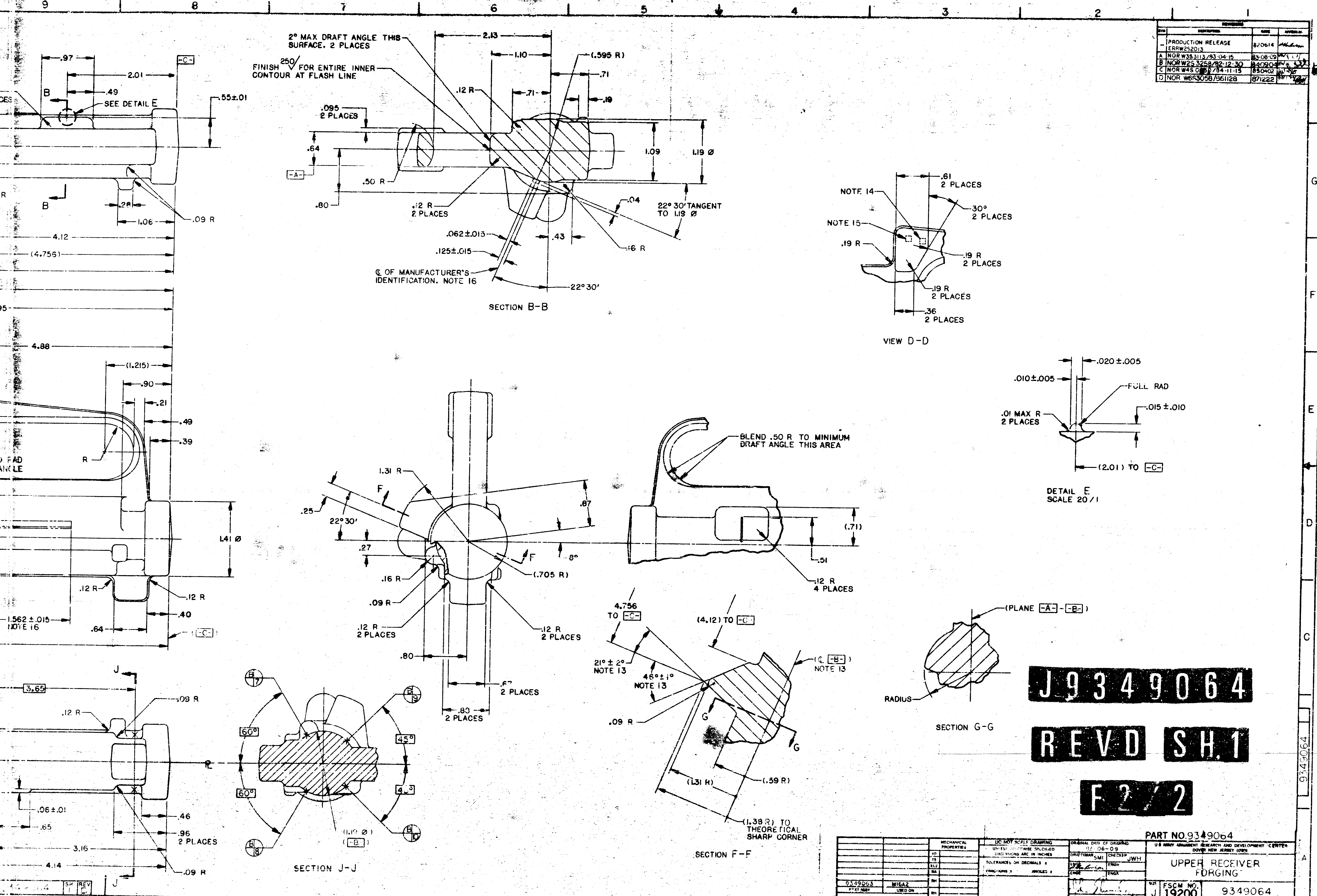
18 — FINISH 125/√ ALL SURFACES, EXCEPT AS NOTED.


16
15
14
13
12
11
10
9
H
G
F
E
D
C
B
A
.12 R
(.88)
(.64)
.12 R
(.595 R)
SECTION C-C
C
C
B
B
D
D
.12 R
2 PLACES
SEE DETAIL E
.97
2.01
.49
-C-
1.028
20°
20°
.22
.12 R
.28
1.06
4.12
(4.756)
7.79
.31 R
16° INCL
7.12
5.35
Ø.125
2 PLACES
.82
4.88
(1.215)
.90
.21
.49
20°±1°
.12 R
30°
.54 R
.38 R
.25 R BLEND RAD
TO DRAFT ANGLE
R
2.79
2.50
2.05
1.13
1.17
2 PLACES
.12 R
.12 R
.12 R
.22 R
4 PLACES
.64
.750±.015
1.562±.015
NOTE 16
.64
6.77
SEE DETAIL A
NOTE 3
1.96
2 PLACES
(.895 R)
(.26)
.09 R
2 PLACES
30° TANGENT
TO .56 R
2 PLACES
.52 R
.56 R THIS SIDE
(THEORETICAL
OPPOSITE SIDE)
30° TANGENT
TO 1.39 Ø
2 PLACES
(.67)
(.88)
1.39 Ø
R
DIMENSIONS ARE GIVEN
TO THEORETICAL
PROJECTED CORNERS
DRAFT ANGLES TANGENT
TO CORNER RADII
DETAIL A
SCALE: 4/1
NOTE 3
45°
45°
60°
60°
(1.19 Ø)
-B-
SECTION H-H
H
H
J
J
.96
3.65
.16
.12 R
.09 R
.06±.01
.65
3.16
4.14
DWG NO 9349064
SH 1
REV D

J9349064

REVD SH1

F1 2


SECTION B-B
2° MAX DRAFT ANGLE THIS SURFACE. 2 PLACES
FINISH 250 FOR ENTIRE INNER CONTOUR AT FLASH LINE
2.13
1.10
(.595 R)
.71
.19
.12 R
.095 2 PLACES
.64
.50 R
.80
.12 R 2 PLACES
.062±.013
.125±.015
℄ OF MANUFACTURER'S IDENTIFICATION. NOTE 16
1.09
1.19 Ø
.04
22° 30' TANGENT TO 1.19 Ø
.43
.16 R
22° 30'
-A-
VIEW D-D
NOTE 14
NOTE 15
.19 R
.61 2 PLACES
30° 2 PLACES
.19 R 2 PLACES
.19 R 2 PLACES
.36 2 PLACES
DETAIL E
SCALE 20/1
.020 ±.005
.010±.005
FULL RAD
.015 ±.010
.01 MAX R 2 PLACES
(2.01) TO -C-
.97
2.01
-C-
.49
SEE DETAIL E
.55±.01
B
.28
1.06
.09 R
4.12
(4.756)
4.88
(1.215)
.90
.21
.49
.39
R
1.41 Ø
.12 R
.12 R
1.562 ± .015 NOTE 16
.64
.40
-C-
1.31 R
F
.25
22° 30'
.27
.87
8°
(.705 R)
.16 R
.09 R
.12 R 2 PLACES
.12 R 2 PLACES
.80
.67 2 PLACES
.83 2 PLACES
BLEND .50 R TO MINIMUM DRAFT ANGLE THIS AREA
(.71)
.51
.12 R 4 PLACES
J
3.65
.12 R
.09 R
.06±.01
.65
.46
.96 2 PLACES
3.16
4.14
.09 R
SECTION J-J
60°
60°
45°
45°
(1.19 Ø) (-B-)
B 7
B 8
B 9
B 10
℄
4.756 TO -C-
(4.12) TO -C-
21° ± 2° NOTE 13
46° ± 1° NOTE 13
(℄ -B-) NOTE 13
.09 R
G
G
(1.31 R)
(.59 R)
(1.38 R) TO THEORETICAL SHARP CORNER
SECTION F-F
(PLANE -A- - -B-)
RADIUS
SECTION G-G
9
8
7
6
5
4
3
2
1
H
G
F
E
D
C
A
SH 1
REV C
9349064

SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W3S3113/83-04-15	83-08-09	
B	NOR W2S 3258/82-12-30	840904	
C	NOR W4S 0[illegible]/84-11-15	850402	
D	NOR W6S3058/861128	871222	

J9349064

REVD SH.1

F2/2

PART NO. 9349064

9349063	M16A2	MECHANICAL PROPERTIES	DO NOT SCALE DRAWING
NEXT ASSY	USED ON	YP	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
APPLICATION		TS	TOLERANCES ON DECIMALS ±
		ELG	FRACTIONS ± ANGLES ±
		RA	
		RH	
		RH	

ORIGINAL DATE OF DRAWING 82-06-09
DRAFTSMAN SMI
CHECKER JWH
ENGR
ENGR
ENGR
ENGR

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

UPPER RECEIVER FORGING

SIZE J
FSCM NO. 19200
9349064
SCALE 2/1
UNIT WT
SHEET 1 OF 1

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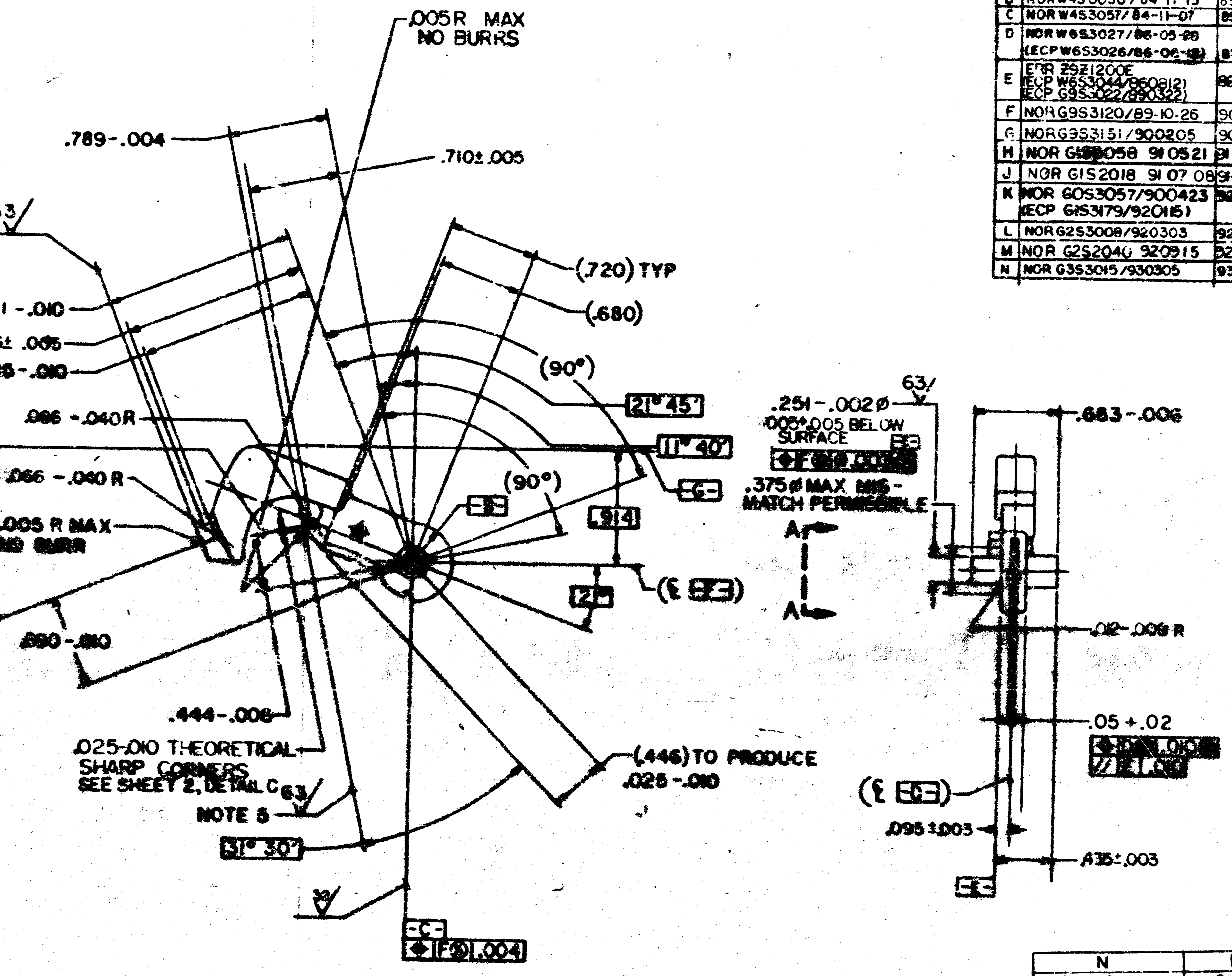
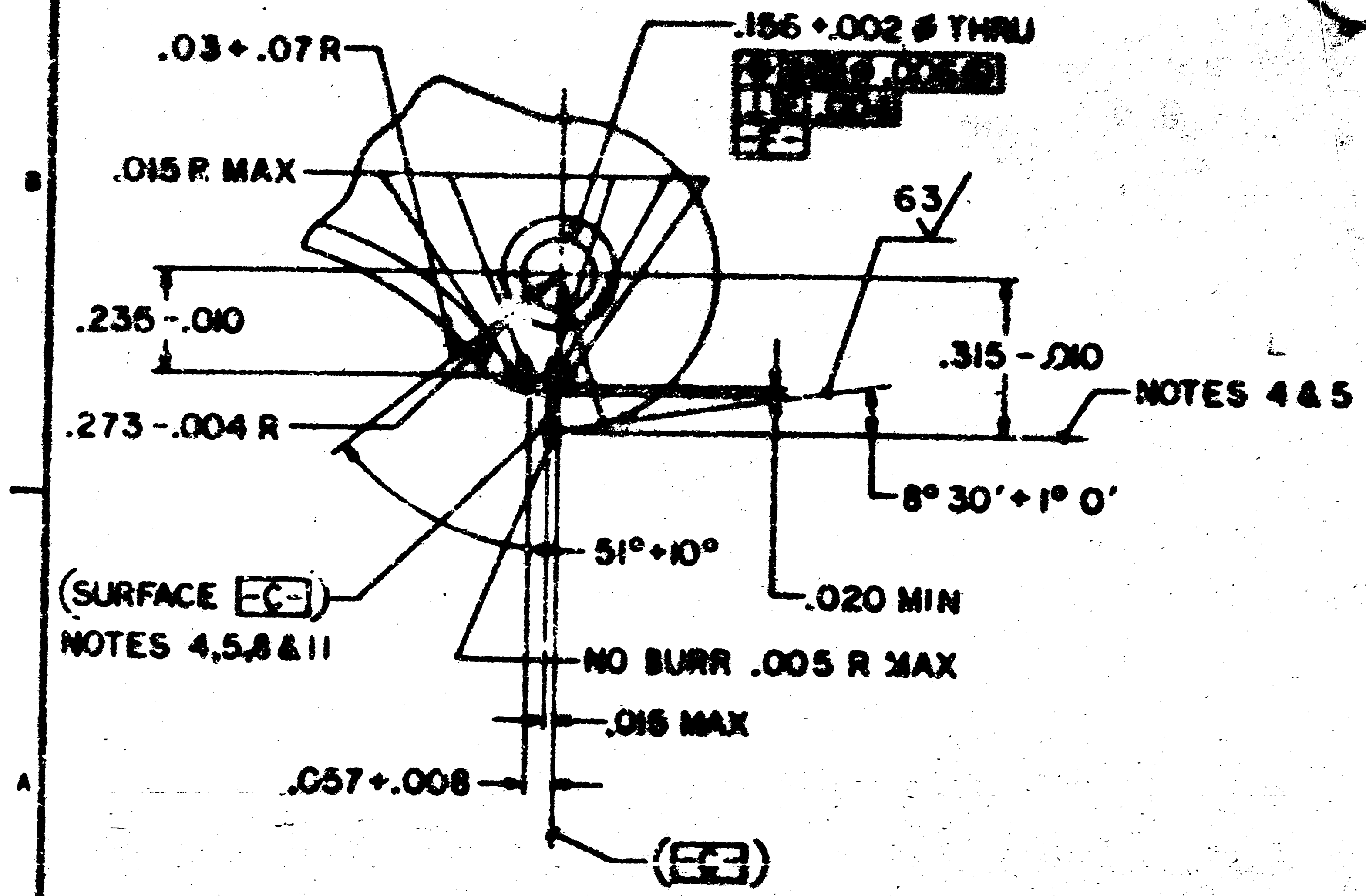
NOTES :-

1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 - MATERIAL :- HAMMER CASTING - 9349112.
3 - ALL DIMENSIONS APPLY WHEN LOCATED ON -F- AND -G- .
4 - ALL DIM. EXCEPT THOSE DEFINING -C- ARE BEFORE FINAL PROTECTIVE FINISH.
5 - SURFACES SO NOTED // F .001 .
6 - BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE NOTED.
7 - FILLET RADII .015 - .012 UNLESS OTHERWISE NOTED.
8 - GRIND -C- AFTER HEAT TREAT AND FINAL PROTECTIVE FINISH, DIRECTION OF GRIND // F . MAX METAL REMOVED BY GRINDING .005.
9 - HEAT TREATMENT :- CARBURIZE, CASE DEPTH .014 TO .018 TOTAL. CASE HARDNESS EQUIV. TO RH 30N 75 TO 79.
10 - FINISH 125√ ALL SURFACES EXCEPT AS NOTED.
11 - COAT GROUND SURFACE -C- WITH CORROSION RESISTING OIL PER MIL-L-46000A.
12 - PROTECTIVE FINISH :- 5.3.1.2 OF MIL-STD-171.


.005R MAX
NO BURRS
.789-.004
.710±.005
63
NOTE 5
(.720) TYP
(.680)
1.531-.010
1.416±.005
1.385-.010
(90°)
21°45'
.066-.040R
11°40'
NOTE 5
.066-.040R
(90°)
-G-
-E-
.914
.005 R MAX
NO BURR
2°
(℄ -F-)
NOTE 5
.880-.010
.444-.008
.025-.010 THEORETICAL SHARP CORNERS SEE SHEET 2, DETAIL C
63
NOTE 5
(.446) TO PRODUCE .025-.010
31° 30'
32
-C-
⌖ F Ⓢ .004
.251-.002 Ø
.005 ±.005 BELOW SURFACE -E-
63
.683-.006
.375 Ø MAX MIS-MATCH PERMISSIBLE
A
A
.012-.008 R
.05 +.02
// F .001
(℄ -E-)
.095±.003
.435±.003
-E-


.03+.07R
.156 +.002 Ø THRU
-F-
.015 R MAX
63
.235-.010
.315-.010
NOTES 4 & 5
.273-.004 R
8° 30' + 1° 0'
51°+10°
.020 MIN
(SURFACE -C-)
NOTES 4,5,8 & 11
NO BURR .005 R MAX
.015 MAX
.057+.008
(-C-)

DETAIL A
SCALE: 4/1

DISTRIBUTION STATEMENT F. FURTHER DISTRIBUTION ONLY AS DIRECTED BY AMSMC, SMCAR-ESW, ROCK ISLAND, IL. AMSMC-AR: 12 [illegible]

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S 3160/83-12-22	840618	
B	NORW4S 0030/84-11-15	850402	
C	NOR W4S3057/84-11-07	850528	
D	NOR W6S3027/86-05-28 (ECP W6S3026/86-06-18)	870810	
E	ERR 2S21200E (ECP W6S3044/860812) (ECP G9S3022/890322)	891016	ORFI-CMT
F	NOR G9S3120/89-10-26	90-03-30	
G	NOR G9S3151/900205	901011	
H	NOR G1S3058 910521	91 07 23	
J	NOR G1S2018 91 07 08	91-10-11	
K	NOR G0S3057/900423 (ECP G1S3179/920151)	920227	SR
L	NOR G2S3008/920303	920331	
M	NOR G2S2040 920915	921106	
N	NOR G3S3015/930305	930406	

N	N
SH 2	SH 1

REVISION STATUS OF SHEETS

9349110	M4	
9349110	M16A2	
NEXT ASSY	USED ON	
APPLICATION		

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN EJZ
CHECKER JWH

PART NO. 9349111
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HAMMER

SIZE D FSCM NO. 19200 9349111
SCALE 2/1 UNIT WT. SHEET 1 OF 2

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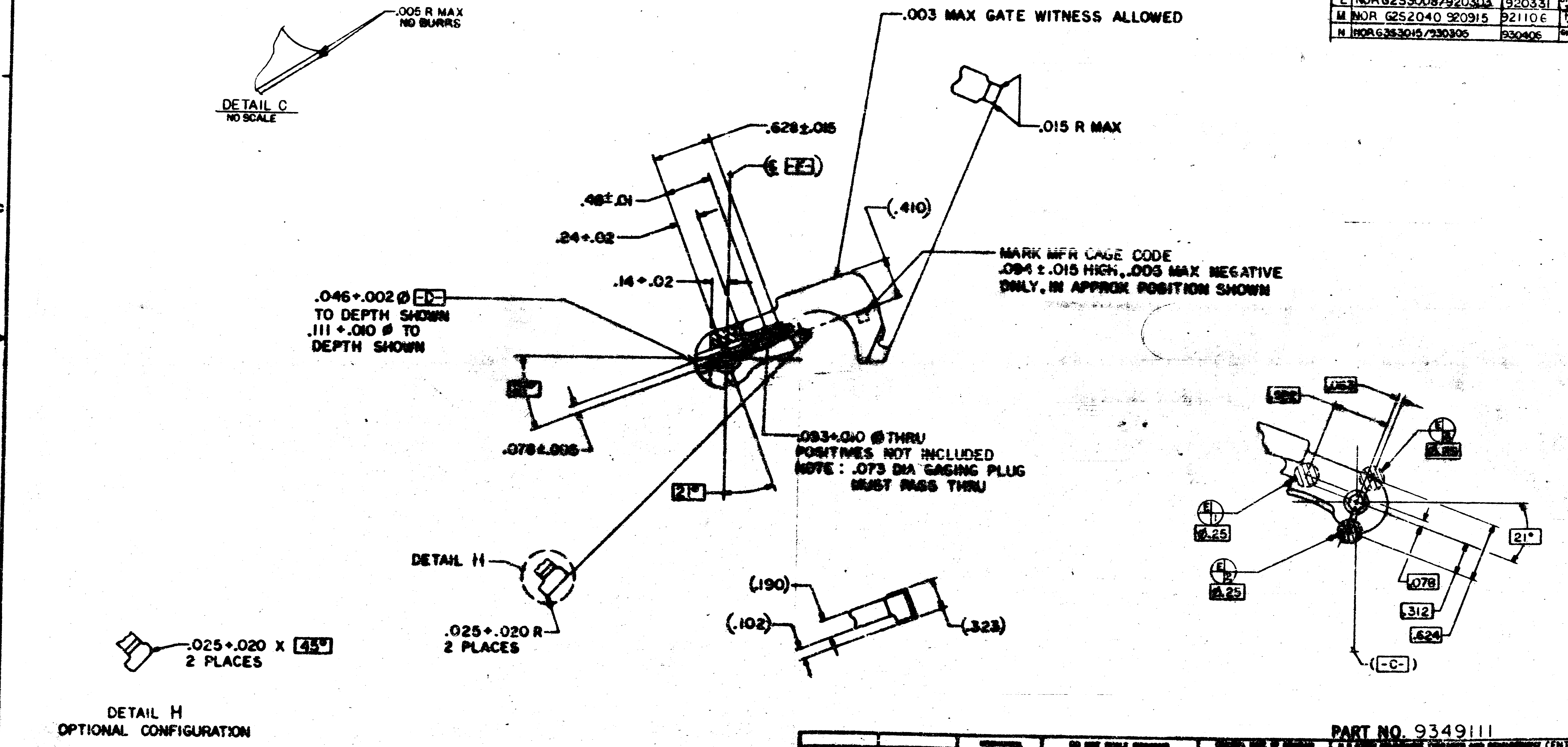
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S3160/83-12-22	840618	
B	NORW4S0030/84-11-15	850402	
C	NORW4S3057/84-11-07	860626	
D	NORW6S3027/86-05-48	870218	
F	NOR G9S3120/89-10-26	90-0330	
G	NCRG9S3151/900205	901011	GHS
L	NOR G2S3008/920303	920331	GHS
M	NOR G2S2040 920915	921106	
N	NOR G3S3015/930306	930406	GHS


.005 R MAX
NO BURRS
DETAIL C
NO SCALE
.003 MAX GATE WITNESS ALLOWED
.015 R MAX
.628±.015
(℄ -E-)
.48±.01
.24+.02
(.410)
MARK MFR CAGE CODE
.094 ±.015 HIGH, .005 MAX NEGATIVE
ONLY, IN APPROX POSITION SHOWN
.14+.02
.046+.002 Ø -D-
TO DEPTH SHOWN
.111+.010 Ø TO
DEPTH SHOWN
.078±.005
.093+.010 Ø THRU
POSITIVES NOT INCLUDED
NOTE: .073 DIA GAGING PLUG
MUST PASS THRU
21°
DETAIL H
.025+.020 R
2 PLACES
(.190)
(.102)
(.323)
.025+.020 X 45°
2 PLACES
DETAIL H
OPTIONAL CONFIGURATION
E 1
Ø.25
E 2
Ø.25
E 3
.078
.312
.624
21°
(-C-)

DISTRIBUTION STATEMENT F. FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, SMCAR-ESW, ROCK ISLAND, IL, ASQNC-AR; 911025.

PART NO. 9349111

M16A2	NEXT ASSY	USED ON
APPLICATION		

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES ON DECIMALS ±

FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26

DRAFTSMAN EJZ

CHECKER JWH

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HAMMER

SIZE D FSCM NO. 19200 9349111

SCALE 2/1 UNIT WT. SHEET 2

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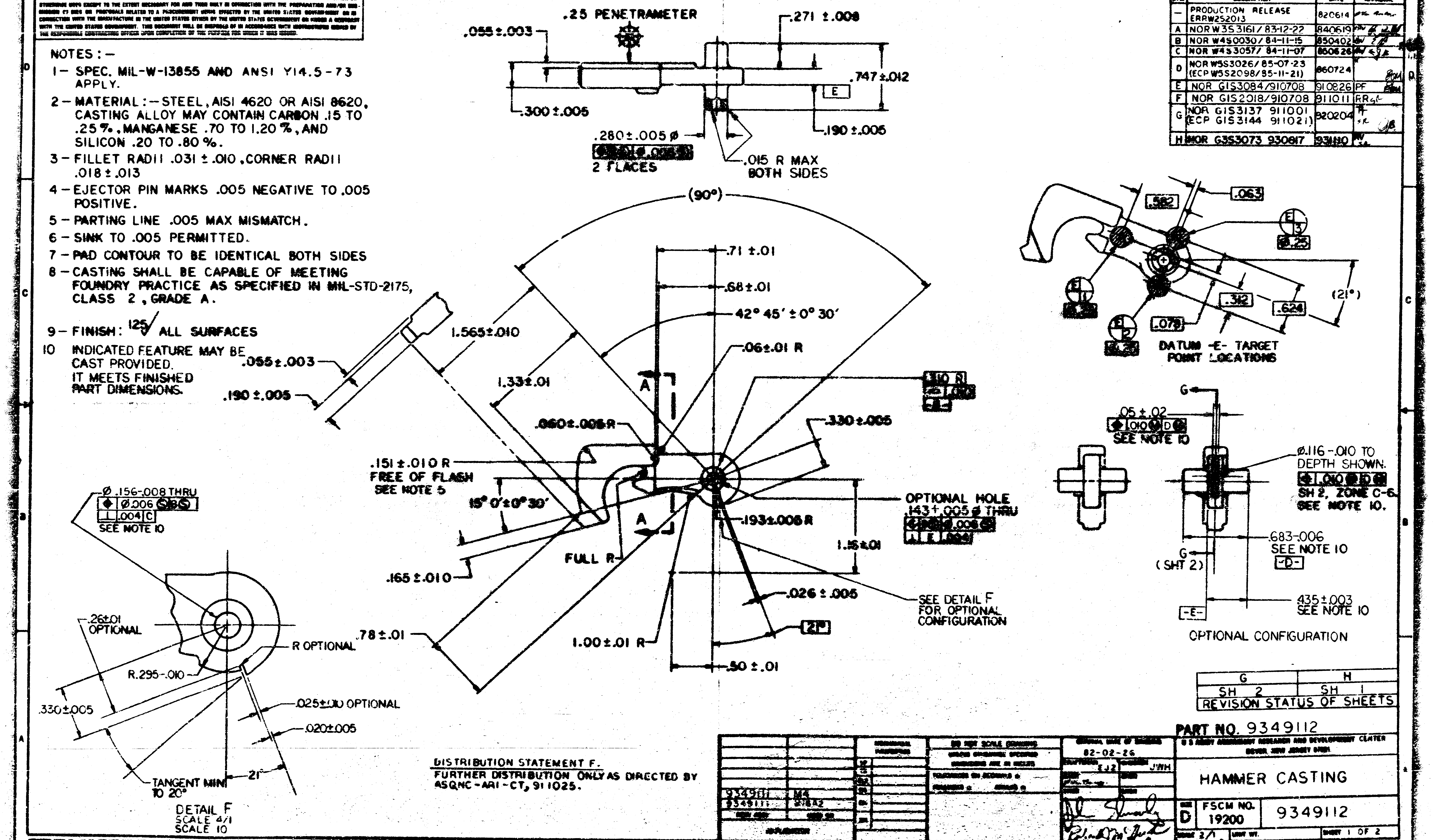
NOTES :-

1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- MATERIAL :- STEEL, AISI 4620 OR AISI 8620, CASTING ALLOY MAY CONTAIN CARBON .15 TO .25%, MANGANESE .70 TO 1.20%, AND SILICON .20 TO .80%.
3- FILLET RADII .031 ± .010, CORNER RADII .018 ± .013
4- EJECTOR PIN MARKS .005 NEGATIVE TO .005 POSITIVE.
5- PARTING LINE .005 MAX MISMATCH.
6- SINK TO .005 PERMITTED.
7- PAD CONTOUR TO BE IDENTICAL BOTH SIDES
8- CASTING SHALL BE CAPABLE OF MEETING FOUNDRY PRACTICE AS SPECIFIED IN MIL-STD-2175, CLASS 2, GRADE A.
9- FINISH: 125√ ALL SURFACES
10 INDICATED FEATURE MAY BE CAST PROVIDED. IT MEETS FINISHED PART DIMENSIONS.

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W3S3161/83-12-22	840619	
B	NOR W4S0030/84-11-15	850402	
C	NOR W4S3057/84-11-07	850626	
D	NOR W5S3026/85-07-23 (ECP W5S2098/85-11-21)	860724	
E	NOR G1S3084/910708	910826	PF
F	NOR G1S2018/910708	911011	RR
G	NOR G1S3137 911001 (ECP G1S3144 911021)	920204	
H	NOR G3S3073 930817	931110	



.25 PENETRAMETER
.055 ±.003
.271 ±.008
.747 ±.012
E
.300 ±.005
.280 ±.005 Ø
2 PLACES
.190 ±.005
.015 R MAX
BOTH SIDES
(90°)
.71 ±.01
.68 ±.01
42° 45' ±0° 30'
.06 ±.01 R
1.565 ±.010
.055 ±.003
.190 ±.005
1.33 ±.01
A
.060 ±.005 R
.330 ±.005
.151 ±.010 R
FREE OF FLASH
SEE NOTE 5
15° 0' ±0° 30'
OPTIONAL HOLE
.143 ±.005 Ø THRU
.193 ±.005 R
FULL R
1.16 ±.01
.165 ±.010
.026 ±.005
SEE DETAIL F
FOR OPTIONAL
CONFIGURATION
.78 ±.01
21°
1.00 ±.01 R
.50 ±.01
Ø .156-.008 THRU
Ø.006
.004 C
SEE NOTE 10
.26±.01
OPTIONAL
R OPTIONAL
R.295-.010
.330±.005
.025±.010 OPTIONAL
.020±.005
TANGENT MIN
TO 20°
21°
DETAIL F
SCALE 4/1
SCALE 10
.582
.063
E 3
Ø.25
E 1
E 2
.312
.624
.079
(21°)
DATUM -E- TARGET
POINT LOCATIONS
G
.05 ± .02
.010 D
SEE NOTE 10
Ø.116 -.010 TO
DEPTH SHOWN.
.010 D E
SH 2, ZONE C-6.
SEE NOTE 10.
.683-.006
SEE NOTE 10
-D-
G
(SHT 2)
.435 ±.003
SEE NOTE 10
-E-
OPTIONAL CONFIGURATION

G	H
SH 2	SH 1

REVISION STATUS OF SHEETS

DISTRIBUTION STATEMENT F.
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-ARI-CT, 911025.

PART NO. 9349112

NEXT ASSY	USED ON
9349111	M4
9349111	M16A2

APPLICATION

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TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING 82-02-26
DRAFTSMAN EJ2 CHECKER JWH

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

HAMMER CASTING

SIZE D
FSCM NO. 19200
9349112
SCALE 2/1 UNIT WT. SHEET 1 OF 2

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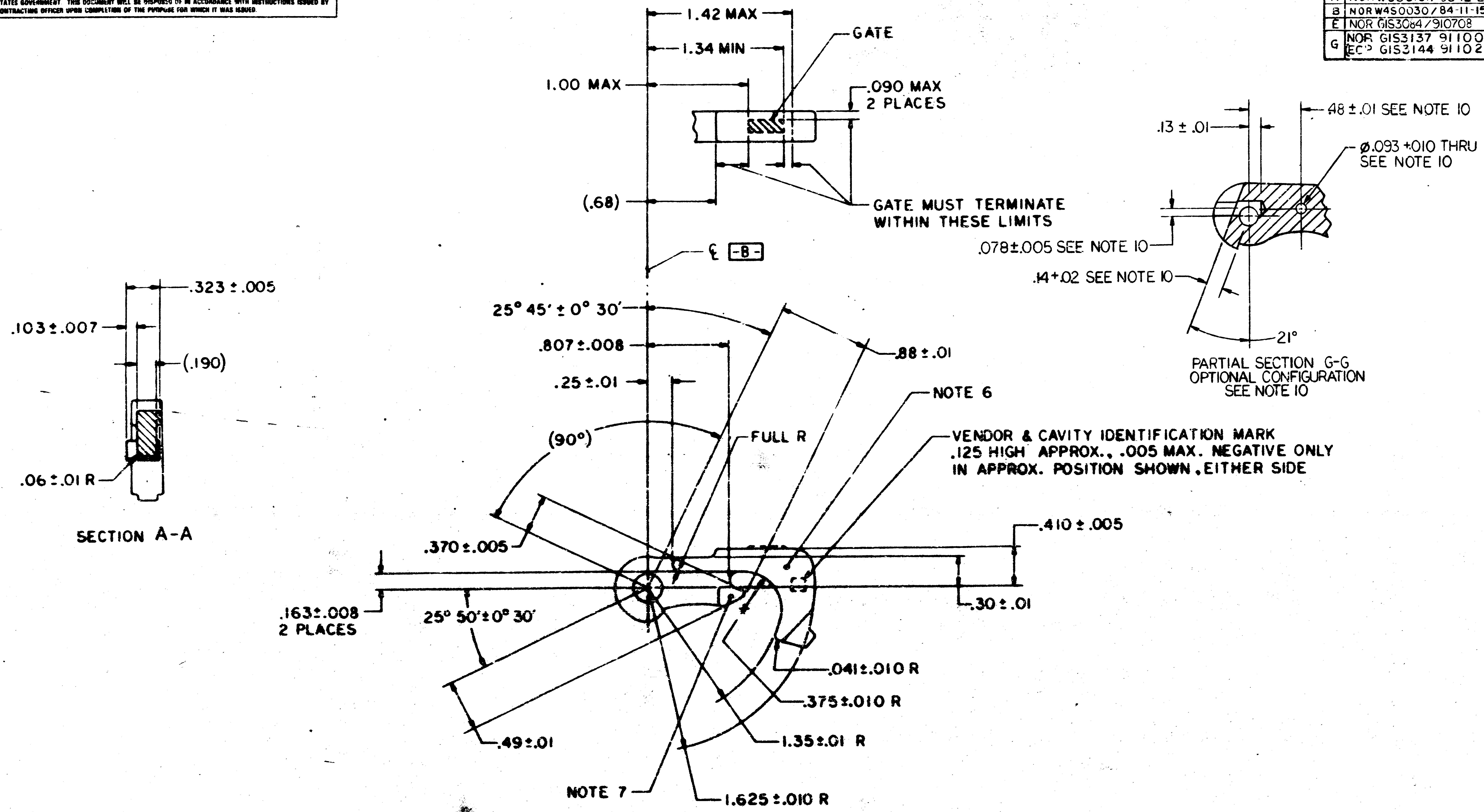
REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
–	PRODUCTION RELEASE ERRW2S2013	820614	
A	NORW3S3161/83-12-22	840619	R Hoff
B	NORW4S0030/84-11-15	850402	
E	NOR GIS3084/910708	910826	PF
G	NOR GIS3137 911001 (ECP GIS3144 911021)	920204	SL



1.42 MAX
1.34 MIN
GATE
1.00 MAX
.090 MAX
2 PLACES
(.68)
GATE MUST TERMINATE
WITHIN THESE LIMITS
℄ -B-
.323 ±.005
.103 ±.007
(.190)
.06 ±.01 R
SECTION A-A
25° 45' ± 0° 30'
.807 ±.008
.25 ±.01
.88 ±.01
NOTE 6
(90°)
FULL R
VENDOR & CAVITY IDENTIFICATION MARK
.125 HIGH APPROX., .005 MAX. NEGATIVE ONLY
IN APPROX. POSITION SHOWN, EITHER SIDE
.410 ±.005
.370 ±.005
.163 ±.008
2 PLACES
25° 50' ± 0° 30'
.30 ±.01
.041 ±.010 R
.375 ±.010 R
.49 ±.01
1.35 ±.01 R
NOTE 7
1.625 ±.010 R
.13 ±.01
.48 ±.01 SEE NOTE 10
⌀.093 +.010 THRU
SEE NOTE 10
.078 ±.005 SEE NOTE 10
.14 +.02 SEE NOTE 10
21°
PARTIAL SECTION G-G
OPTIONAL CONFIGURATION
SEE NOTE 10

PART NO. 9349112

DO NOT SCALE DRAWING

ORIGINAL DATE OF DRAWING 82-02-26

CHECKER JWH

M16A2

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

HAMMER CASTING

SIZE D

FSCM NO. 19200

9349112

SCALE 2/1

UNIT WT

SHEET 2

DRAWING SIZE C
(ARRADCOMR 70-12)

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW2S2013	820614	
A	NOR W2S0011/82-04-13 (ECP W3S3120/83-07-07	83-11-04	
B	NOR W2S3258/82-12-30	840904	
C	NOR W4S0030/84-11-15	850402	
D	NOR W5S 2030/85-05-25	850731	

NOTES :—

1— SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2— MATERIAL :
WIRE, STAINLESS STEEL, TYPE 631 (17-7PH),
COLD DRAWN, ASTM-A313.

3— WIRE DIAMETER :— .0200 ± .0005 .

4— DIRECTION OF HELIX :- OPTIONAL.

5— TOTAL NO. OF COILS :— (7.5)

6— LOAD AT COMPRESSED LENGTH OF .263 :— 2.1 LBS ± .21 LBS.

7— MAX. SOLID HEIGHT :— .154 .

8— BREAK SHARP EDGES .003 + .012 .

9— FINISH $^{125}\surd$ ALL SURFACES.

10— MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572, EXCEPT PARAGRAPH 4.4.4.1 SHALL NOT APPLY.

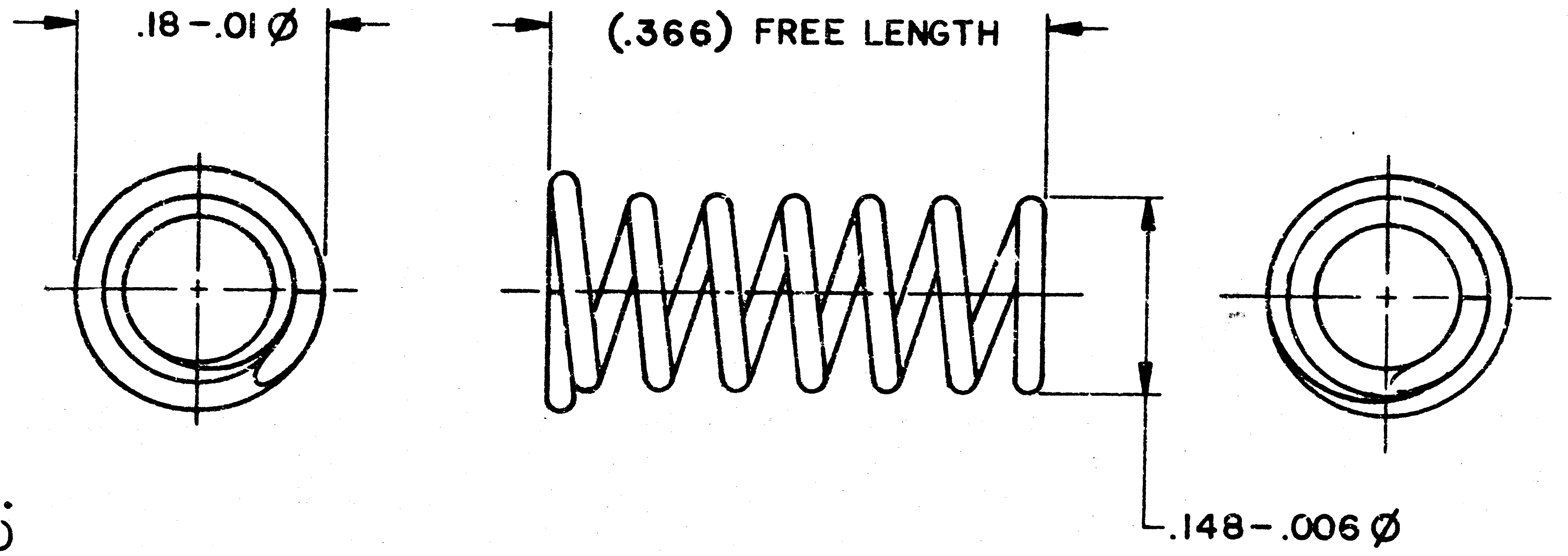
11— PRECIPITATION HEAT TREAT AFTER FORMING. HOLD AT 900°F ± 10°F FOR ONE HOUR, AIR COOL.

12— HARDNESS EQUIV TO ROCKWELL C 48 MIN.

13— TYPE OF ENDS :— ONE CLOSED AND GROUND.
ONE CLOSED, FLARED AND GROUND.

14— PROTECTIVE FINISH :— 5.4.1 OF MIL-STD-171.

15— SPRING REQUIREMENTS APPLY AFTER COMPRESSING TO SOLID LENGTH.



PART NO. 9349116

9349115	M16A2	MECHANICAL PROPERTIES	YP TS EL2 RA BH RH
NEXT ASSY	USED ON		
APPLICATION			

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

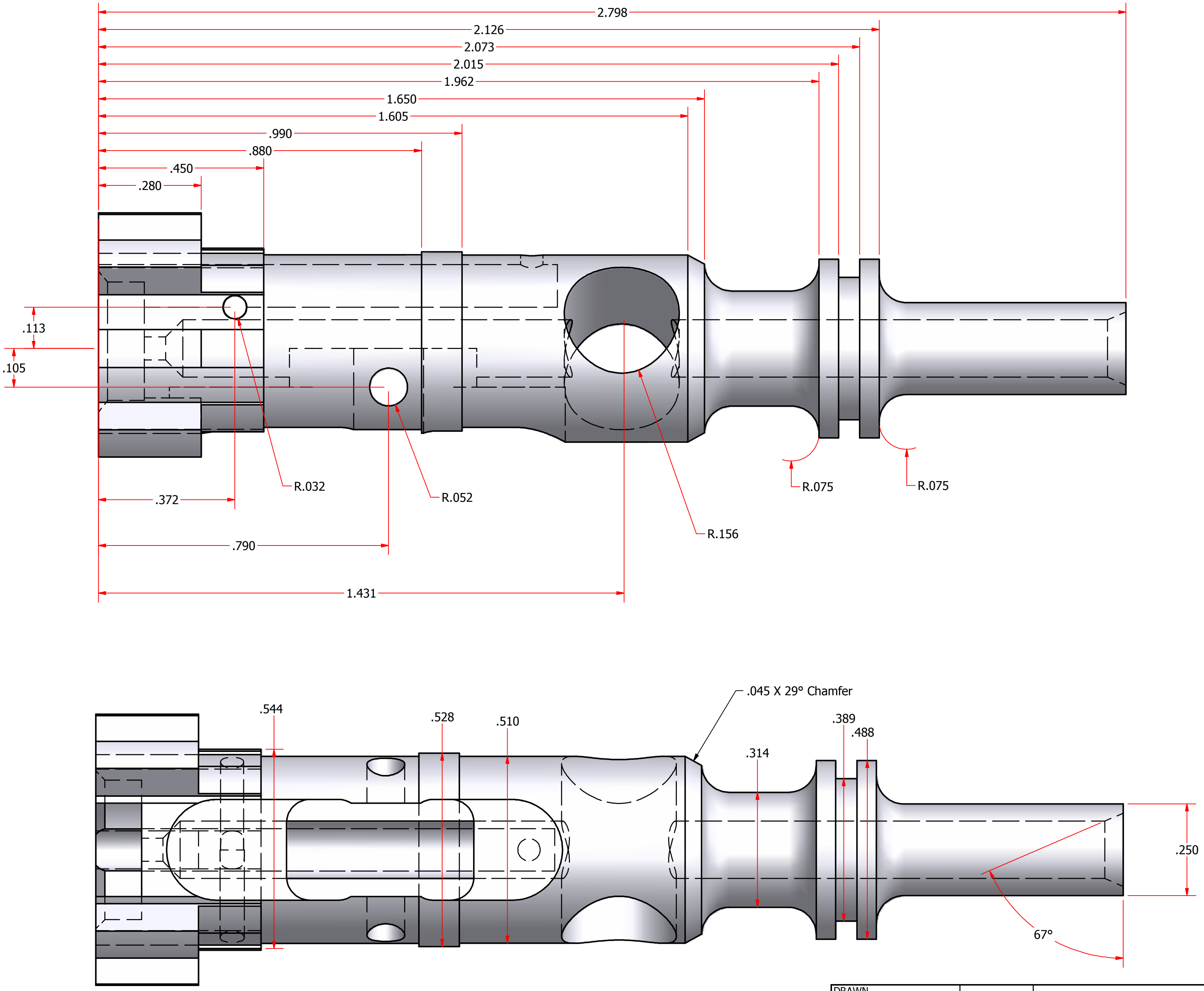
ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN M M	CHECKER DEW
ENGR	ENGR
ENGR	ENGR

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SPRING, DISCONNECT

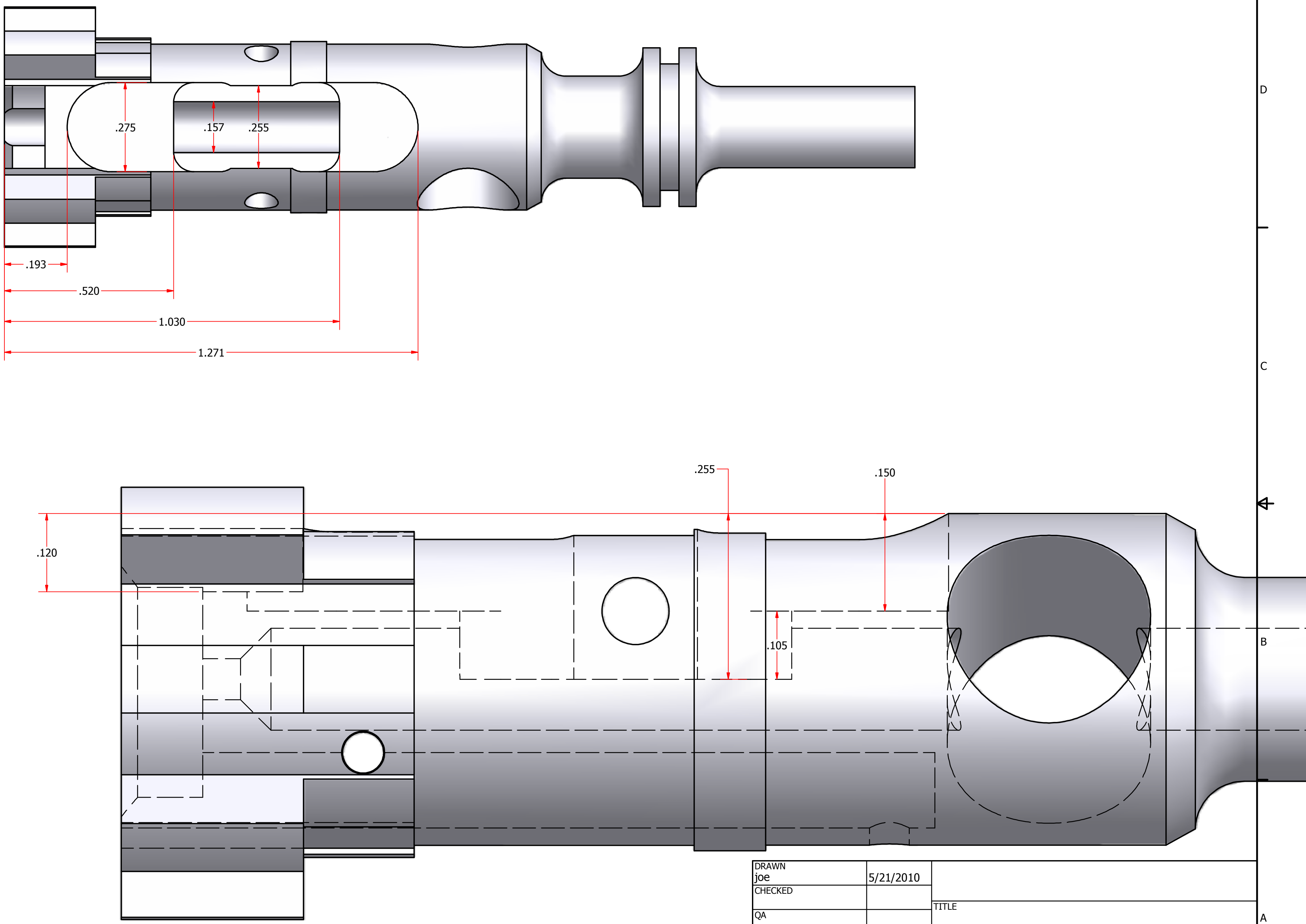
SIZE	FSCM NO.	
C	19200	9349116
SCALE 10/1	UNIT WT.	SHEET 1 OF 1

ARRADCOM FORM 67 AUG 77 REPLACES SARPA FORM 1040 OCT 75 WHICH MAY BE USED UNTIL EXHAUSTED


2.798
2.126
2.073
2.015
1.962
1.650
1.605
.990
.880
.450
.280
.113
.105
R.032
R.052
R.156
R.075
R.075
.372
.790
1.431
.045 X 29° Chamfer
.544
.528
.510
.389
.488
.314
.250
67°

DRAWN joe	5/21/2010	
CHECKED		TITLE
QA		
MFG		M4A1 Bolt
APPROVED		

SIZE	DWG NO	REV
C	M4A1 - Bolt - Bolt-1	
SCALE	SHEET 1 OF 1	

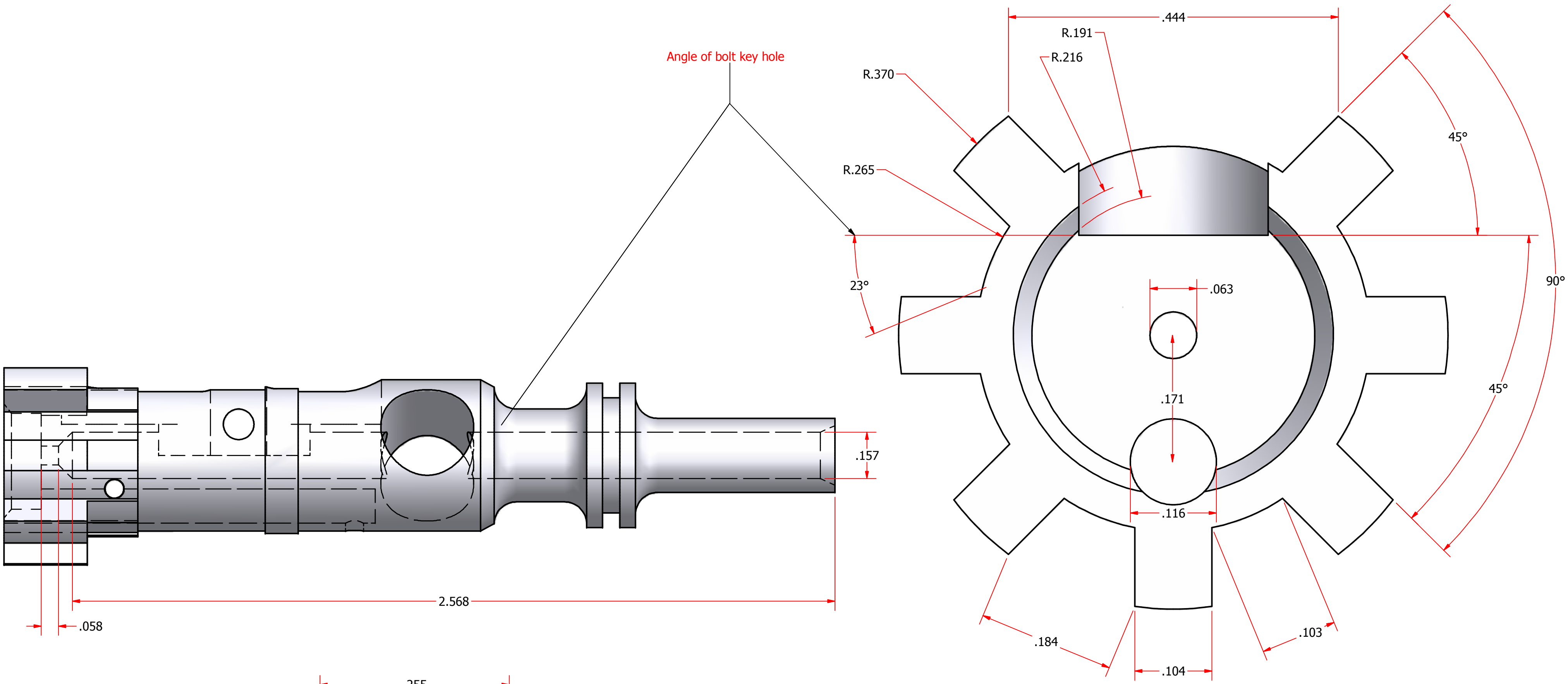

.275
.157
.255
.193
.520
1.030
1.271
.255
.150
.120
.105
4
3
2
1
D
C
B
A

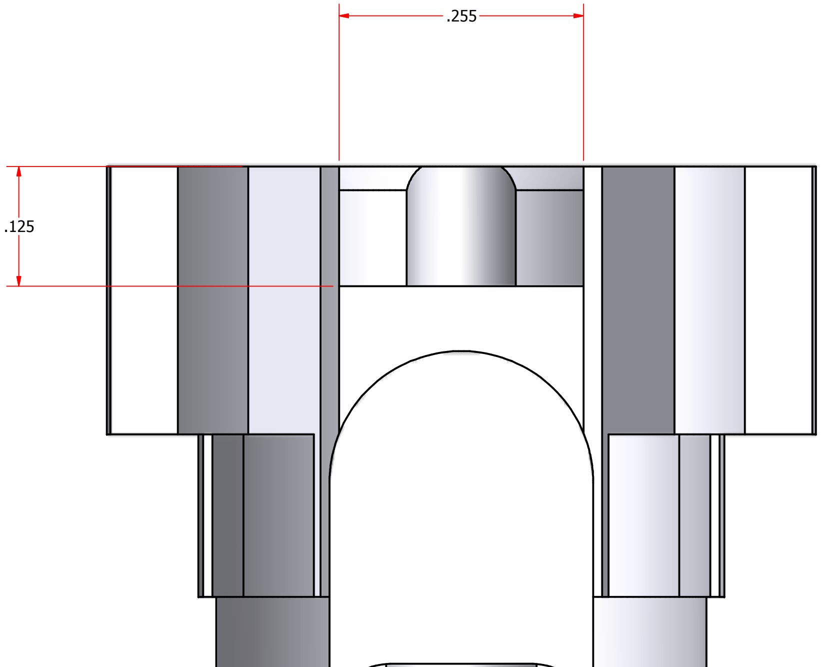
DRAWN
joe
5/21/2010
CHECKED
QA
MFG
APPROVED

TITLE

Ejector slot detail

SIZE
C
DWG NO
M4A1 - Bolt - Bolt Ejector slot detail
REV
SCALE
SHEET 1 OF 1


Angle of bolt key hole
R.370
R.191
R.216
R.265
.444
45°
90°
45°
23°
.063
.171
.116
.184
.104
.103
.157
2.568
.058



DRAWN
joe
5/21/2010
CHECKED
QA
MFG
APPROVED
TITLE
Bolt face detail
SIZE
C
DWG NO
M4A1 - Bolt - Bolt Face detail
REV
SCALE
SHEET 1 OF 1